



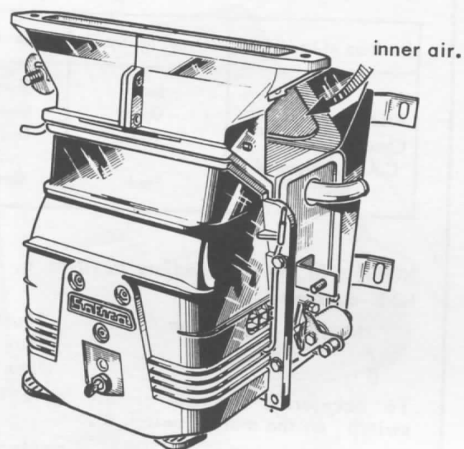
TECHNICAL DESCRIPTION

SOFICA CLIMATIZER

The SOFICA climatizer is a self-contained unit...

13 - BODYWORK ACCESSORIES

SOFICA CLIMATIZER TECHNICAL DESCRIPTION	183
SUNROOF	184
WINDSCREEN	185
REAR WINDOW	186
DOORS	187
UPHOLSTERY CLEANING	187
BODY COLOUR LIST	188
BODY ASSEMBLING	189



TECHNICAL DESCRIPTION

SOFICA CLIMATIZER

The SOFICA climatizer allows all combinations :

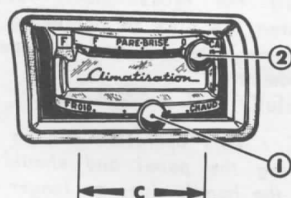
- Heating
- Demisting - defrosting
- Ventilation.

It is essentially made of a bakelite casing which contains :

- A radiator.
- An electrical motor with turbine.

The constituent elements are different according to the atmospheric conditions of the countries where the cars are operated.

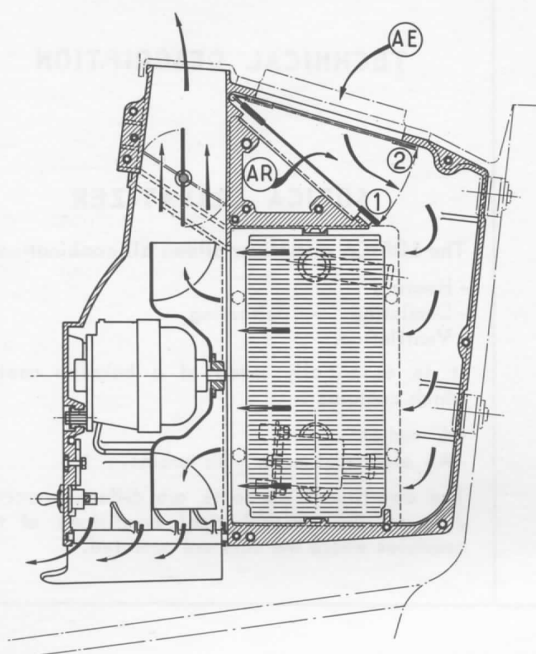
Identification of the climatizers	CPR1 Type "NORMAL"	CPR2 Type "DEEP COLD"	CPR7 Type "TROPICAL"
	Home market & Export	Export	
Heater radiator thickness	60 mm	80 mm	No radiator
Fan	1 speed	2 speed	1 speed
Cal/h power : 1st speed	1700	2800	—
2nd speed	—	3400	—
Output M3/h : 1st speed	90	110	100
2nd speed	—	140	—
Intensity (A)	2,2	2,6 to 4,3	2,2



The handle 1 on the instrument panel controls :

- a - The upper shutter 3
- b - The water circuit tap 4

The handle 2 controls the shutter 5 (defrosting).
(see sketch next page)



AE : External air intake, shutter in position 1

AR : Recirculated air, shutter in position 2

OPERATION

Position of handle 1 :	Upper Shutter 3 :	Tap 4 :
F	Shut	Shut
Froid (cold)	Open	Shut
Chaud (Warm)	Open	Open
C.A. (accelerated heating)	Shut	Open

NOTE : In the intermediary position C, relative taps opening :

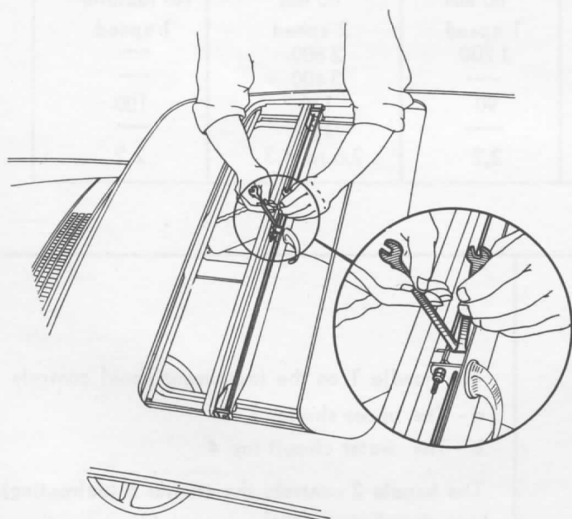
Handle 2 in position :	Shutter 5 :
F	Shut
O	Open

To accelerate the air circuit (cold or warm) switch on the motor (switch 6).

Deep cold countries : USA, Canada, Sweden, Norway, Denmark, Finland, Belgium, Holland, Germany, Switzerland, Austria.

NOTE : For the vehicles equipped with a "Deep cold" type heater, a calorstat 944 (black reference dash) corresponding with a 88°C opening temperature ($\pm 199^\circ$ F) is delivered with the toolkit.

This calorstat should replace the serial one during the deep cold periods.



SUNROOF

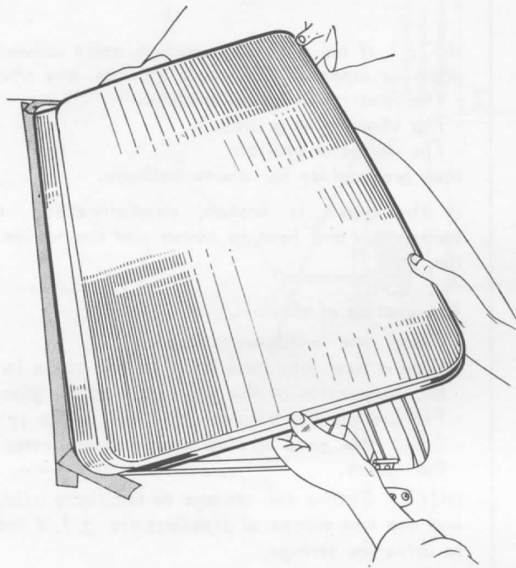
Removal

- Protect the front seats with covers.
- Shut and lock the sliding panel.
- Remove the four front crossmember fixation screws.
- Lift the crossmember, unscrew the nuts and locknuts from the lock rods.

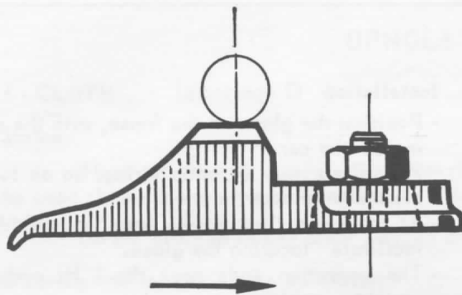
Reinstallation

- Install the crossmember, locks and rods. Tighten the nuts to obtain an equal tension between both rods and a proper stiffness at the handle.
- Carefully lock the locknuts.

NOTE : This operation can be done without removing the panel and should be performed when the handle does no longer provide proper locking.



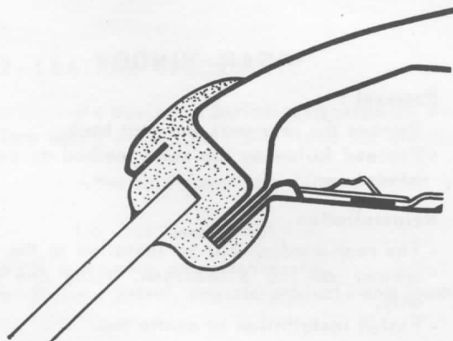
- Protect the rear of the roof with adhesive tape.
- Present the tension springs equipped with upper rollers, under the roof.
- Push the panel, helping it at the rear, from inside, so as to engage the lower sliders rollers under the roof.
- Position and fix the crossmember onto the panel.
- Actuate the sunroof.



SLIDERS ADJUSTEMENT

If, when opening or closing the sunroof, this gets jammed sideways.:

- Shut the roof.
- Check the lower rollers for position on upways sliders.
- Adjust each slider so that the rollers start together up the slope.

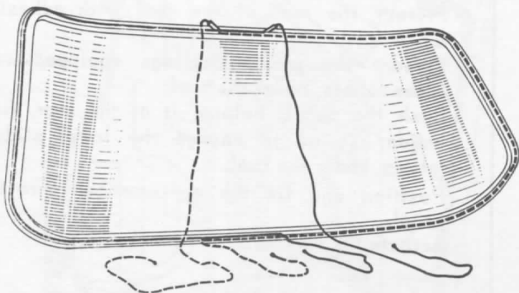


WINDSCREEN GLASS

Removal : Protect the wings and seats by means of covers.

- Remove :**
- The windscreen wiper brush holder.
 - The sun-visor and rear-view mirror.
 - The windscreen panel upright pillars.
 - The half circle trims.

Push off the windscreen and seal from inside to the outside, striking with a rubber mallet. In case of difficulty, cut off the joint outer lip and take away the glass and joint.



NOTE : If the glass is cracked, stick adhesive paper or tapes on the whole surface, and shut :

- The ventilation intake orifices.
- The ventilation grilles.
- The defroster splits.

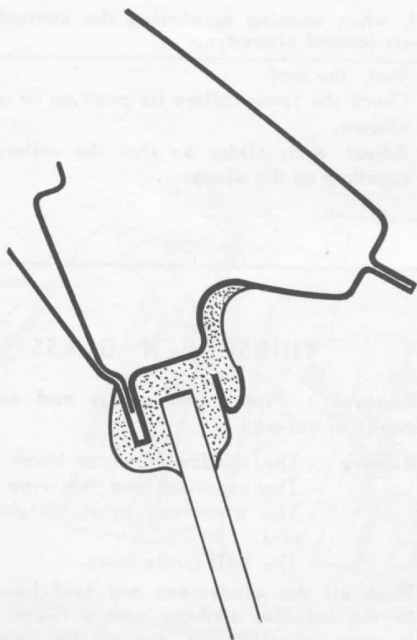
then proceed as per above methods.

If the glass is broken, carefully clean the ventilation and heating hoses and the inside of the car.

Preparation of glass

- Clean the windscreen frame.
- Glue a new joint and fit it on the glass (with the connection at the top centre of the glass).
- Fit two strings between the lips of the joint.
- Cross the ends at top and bottom centre of the glass.

NOTE : Tallow the strings to facilitate sliding and use two pieces of pipe (ext.dia. $\pm 1/4$ inch) to drive the strings.



Installation (2 operators)

- Position the glass on the frame, with the string inside the car.
- Pull alternately on each string, so as to pull the inner lip over the inner panel.
- At the same time, strike from the outside, to facilitate locating the glass.
- The operation ends near the L.H. and R.H. upright centres.
- Glue the outer lip of the joint, onto the outer panel.
- Refit the accessories. Clean the glasses.

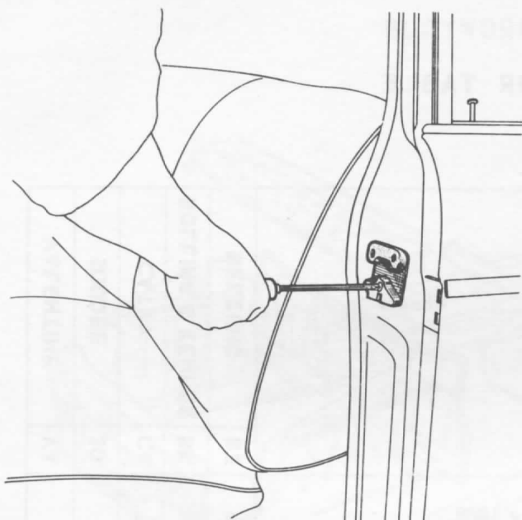
REAR WINDOW

Removal :

- Remove the rear seat and seat back.
- Proceed following the same method as per the windscreen.

Reinstallation

- The rear window will be installed in the same manner as the windscreen, using one string only.
- Finish installation at centre top.



DOORS

Catch adjustment

- Make sure that the latch and its control work properly and that the door hinges are duly tightened without distortion.
- Untighten the three catch fixation screws and drive catch to the outside.
- Press, without releasing, the outer handle knob and shut the door slowly, pushing hard.
- Open the door, release the knob.
- Lock the catch fixation screws.
- Check the way the door closes and correct if necessary.

Maintenance

- Oil moderately the sole and rod.
Never oil the nylon safety slope.

UPHOLSTERY CLEANING

1 - CLOTH

Stains

They get off with dyer's refined benzin, in slight application. No trichlorethylen or petrol should be used : they damage the cloth and make it loose elasticity.

Do not proceed in any other way, in order to avoid making indelible stains.

Cleaning and refreshing the upholstery

The cloth can be washed, but this necessitates difficult and costly stripping and relining.

"Dry foams" are nowadays available on the market, which permit to clean and refresh the cloth after carefully dusting the car.

2 - LEATHER UPHOLSTERY

We advise to periodically wipe off the leather completely with a very clean piece of cloth, dipped into soapy water ; carefully rinse out the cloth afterwards. Use a non caustic soap, such as toilet soap.

After this operation, dry and polish with a dry cloth.

Do not use :

- a - Rain water, too often dusty.
- b - Polish, petrol, caustic products and leather creams, which are liable to stain the leather.

BODY COLOUR TABLE

Body x	Wheels o					
		BELZUNG	BOLLIG & KEMPER	CATRY	SOUDEE	VALENTINE
		BE	BK	CA	SO	VA
Tango 1005 up to July 6, 1960	Ivory 1008	o		x		
Turquoise 1006	Turquoise 1006			xo		
Ivory 1010	Ivory 1010	xo			xo	
Grey 501 up to May 29, 1961	Grey 501	xo				
Grey 1026 as from May 29, 1961	Grey 1026	xo				
Metallic grey 1004 up to May 12, 1961	Metallic grey 1004		xo			
Metallic grey 1025 as from May 12, 1961	Grey/black		xo			
Black	Ivory 1008	o		x		x

As from June 15 th 1961, the wheels are painted metallic light grey Valentine 1027.

NAMES & ADDRESSES OF THE PAINT SUPPLIERS

BE - BELZUNG (Ets A. BELZUNG) 5, rue de Bâle - DANNEMARIE (Haut-Rhin) - 52

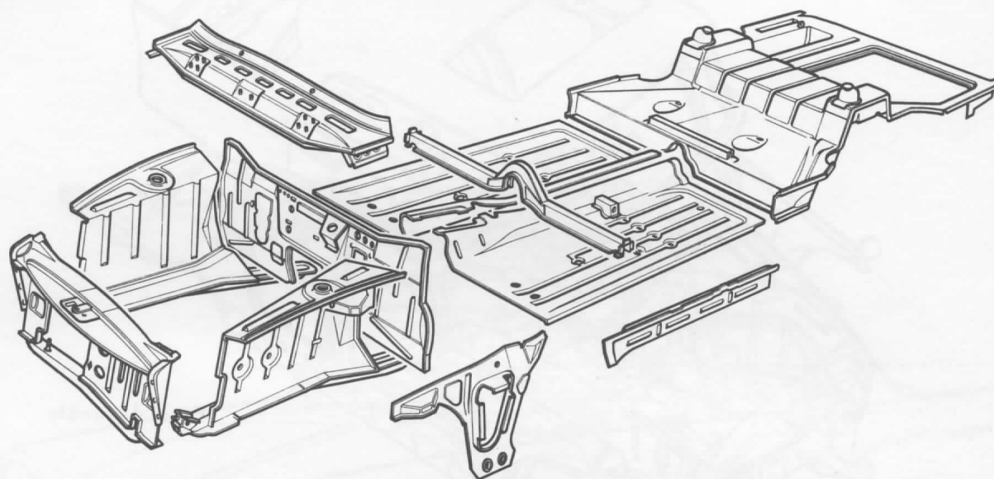
BK - BOLLIG & KEMPER, Vitalisstrasse 114 - Köln - Bickendorf - ALLEMAGNE

CA - CATRY (Ets Albert CATRY et Cie), 344, Avenir Jean - Jaurès -
RONCHIN-lez-LILLE (Nord) LILLE 311-83

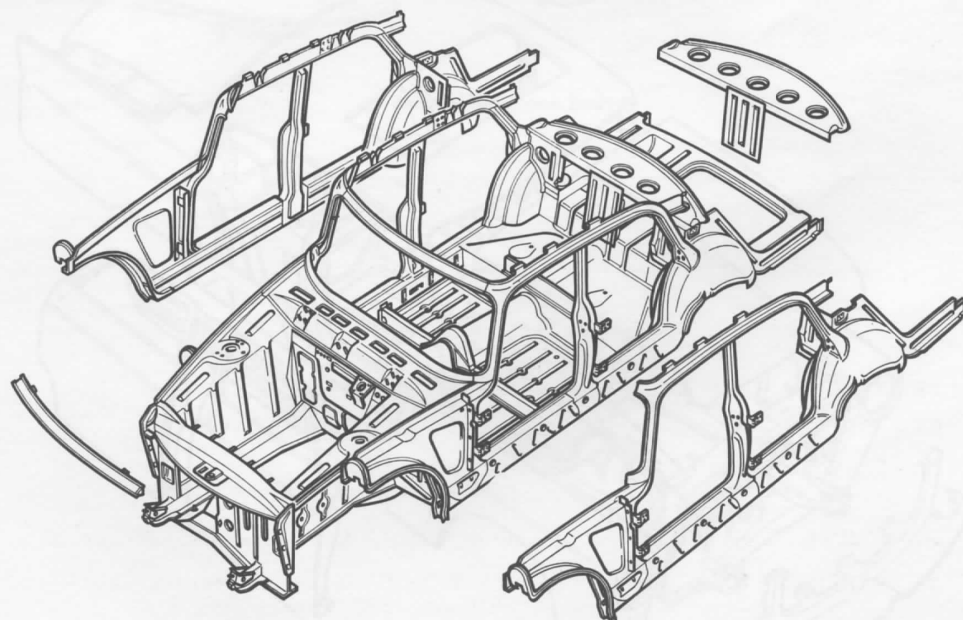
SO - SOUDEE (Vernis SOUDEE), 26, Avenue de Paris - VILLEJUIF (Seine) - ITA. 34-30

VA - VALENTINE (Compagnie des Vernis VALENTINE), 185, Avenue des Grésillons -
GENEVILLIERS (Seine) - GRE. 19-24

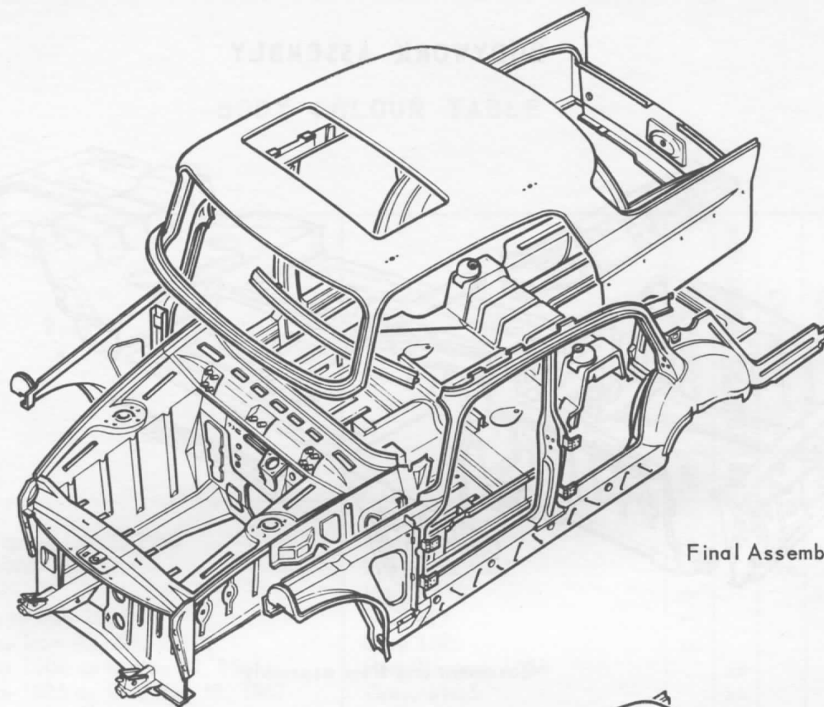
BODYWORK ASSEMBLY



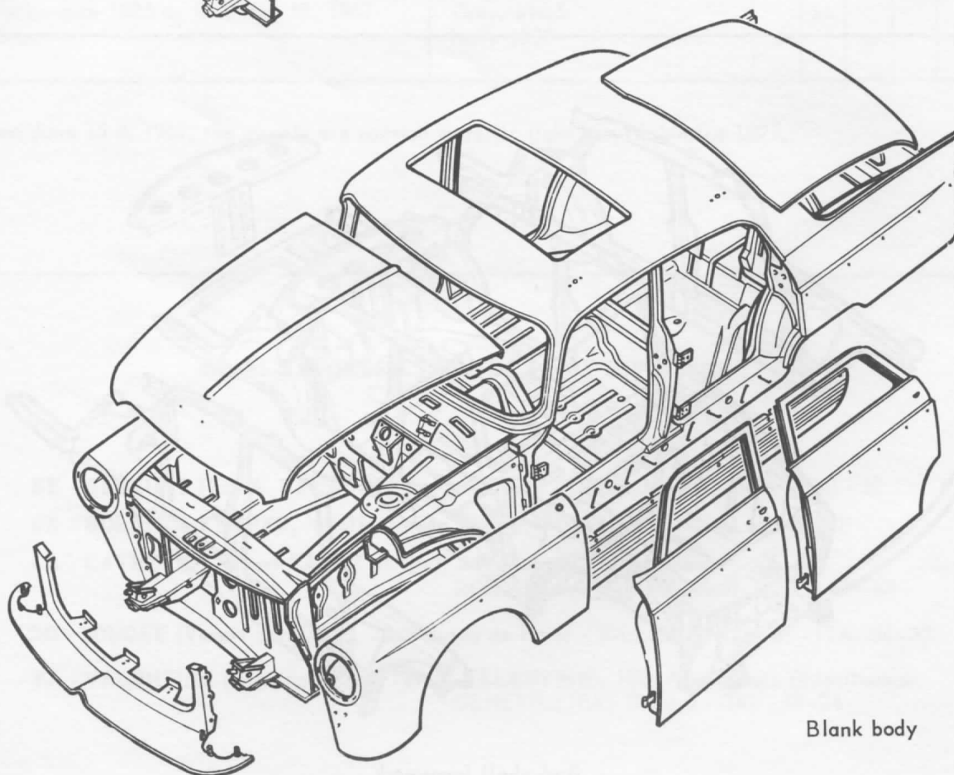
Basement and floor assembly



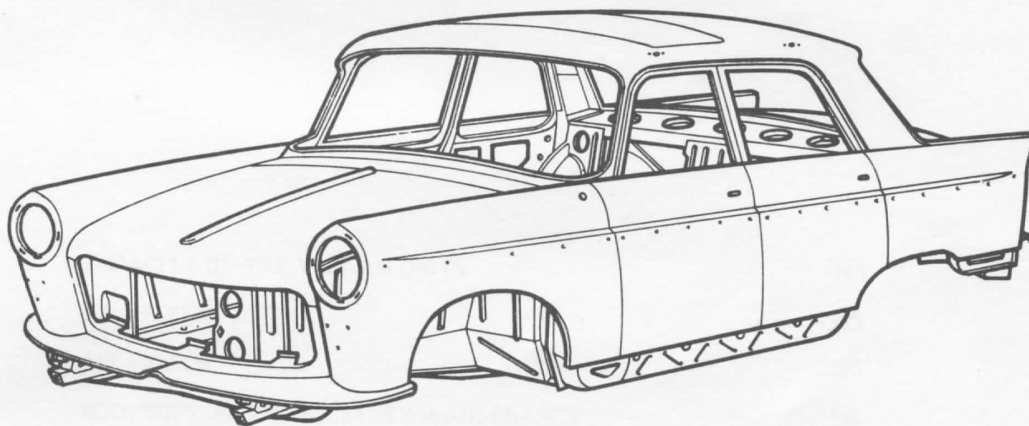
Bodysell framework



Final Assembly



Blank body



Assembled blank body

13 - BODYWORK AND ASSOCIATED EQUIPMENT

	Page
Paint suppliers	119
Hulls with increased usable inside space	120
Front floor - Reinforcement for mounting safety belts	121
Front and rear doors	123
Workshop procedures concerning doors of 404 cabriolets	129
Front and rear seats	134
Roof headlining	136
Installing the hard-top on 404 cabriolets	138

BODY WORK AND ASSOCIATED EQUIPMENT
PAINT SUPPLIERS

13

119

SHADE	Reference	MANUFACTURER
BLACK COARSE-GRAIN BLACK	BE-VA SO	BELZUNG-VALENTINE SOUDEE
515 BLUE 530 BLUE 1023 ADMIRAL BLUE 1066 LIGHT BLUE	CA-AC-SO VA VA-AC RV-AC	CATRY - ASTRAL CELLUCO - SOUDEE VALENTINE VALENTINE - ASTRAL CELLUCO VILLEMER - ASTRAL CELLUCO
1006 TURQUOISE	CA	CATRY
507 GREEN 1001 DARK GREEN 1002 LIGHT GREEN 1028 GREEN 1077 IMPERIAL GREEN	SO-BE VA VA VA-AC RV-VA	SOUDEE - BELZUNG VALENTINE VALENTINE VALENTINE - ASTRAL CELLUCO VILLEMER - VALENTINE
1005 TANGO RED 1024 RED	CA RV	CATRY VILLEMER
516 BEIGE 1045 BEIGE 1045 COARSE-GRAIN BEIGE	RV SO-RV CA	VILLEMER SOUDEE - VILLEMER CATRY
1010 IVORY 1008 IVORY 1021 FROSTED IVORY	SO CA CA	SOUDEE CATRY CATRY
501 GREY	AC-BE-SO RV	ASTRAL CELLUCO - BELZUNG - SOUDEE VILLEMER
1026 GREY 1075 GREY 463 GREY 529 GREY 532 LIGHT GREY 667 GREY 1025 METALLIZED GREY 1004 METALLIZED GREY 1027 METALLIZED GREY	AC-BE SO-VA RV VA VA VA BK BK VA	ASTRAL CELLUCO - BELZUNG SOUDEE - VALENTINE VILLEMER VALENTINE VALENTINE VALENTINE BOLLIG & KEMPER BOLLIG & KEMPER VALENTINE
1003 SAFFRON-SHADED WHITE	VA	VALENTINE

PAINTS FOR CABRIOLETS AND COUPES

BLACK
1031 SARATOGA WHITE
1041 SKY BLUE
1039 CHANTILLY IVORY
1083 SAFARI IVORY
1033 CAPANELLE RED
1036 PAVONE BLUE
1055 GRAPHITE GREY
1057 DARK BLUE

VALENTINE
ASTRAL CELLUCO
SOUDEE
VILLEMER

NOTE. - The above-listed paints are sold by T.U.P.A.C., 18 Bvd National, La Garenne, Seine, France.

As from serial numbers :

404 - 4.400.001
 404 J - 4.528.001
 404 KF - 4.557.001
 404 D - 4.600.077

As from serial numbers :

404 L - 4.838.007
 404 LD - 4.977.069
 404 U6 - 4.720.035
 404 U6D - 4.904.202

The front framework assembly and back window shelf have been changed to increase the usable inside space.

A modified front framework assembly, identical to the one used for saloon cars, has been installed on 404 associated vehicles.

P/N FOR MODIFIED BODY WORK PARTS

		Earlier installation	Later installation
Hull assembly, "A"	Saloon cars w/ petrol engine { With sliding roof	7001.73	7001.86
	{ W/o sliding roof	7001.74	7001.87
	Saloon cars w/ Diesel engine { With sliding roof	7001.83	7001.88
	{ W/o sliding roof	7001.84	7001.89
	Family cars w/ petrol engine	7001.79	7001.90
	Family cars w/ Diesel engine	Special order	
Hull assembly, "B"	Utility cars w/ petrol engine	7001.80	7001.91
	Utility cars w/ Diesel engine	7001.81	7001.92
	Saloon cars w/ petrol engine { With sliding roof	7002.34	7002.38
	{ W/o sliding roof	7002.35	7002.39
Front framework assy	Saloon cars w/ Diesel engine	Special order	
	Associated vehicles		
L.H. front wing valance	Saloon cars & associated vehicles w/ petrol engine	7003.67	7003.72
	Saloon cars & associated vehicles w/ Diesel engine	7003.71	7003.73
R.H. front wing valance	Saloon cars & associated vehicles w/ petrol engine	7121.14	7121.16
	Saloon cars & associated vehicles w/ Diesel engine	7121.12	7121.15
Dashboard	Saloon cars & associated vehicles - All types	7122.16	7122.17
	Saloon cars & associated vehicles - All types	7150.23	7150.26
Dashcowl	Saloon cars & associated vehicles - All types	7140.21	7140.23
	Saloon cars & associated vehicles - All types	7220.07	7220.08
Rear bench backrest backing plate	Saloon cars	8515.16	8515.21
	Saloon cars	8516.18	8516.23
L.H. rear wheel arch	Saloon cars	8316.04	8316.05
	Saloon cars		
R.H. rear wheel arch	Saloon cars	7485.07	7485.09
	Saloon cars		
Back window shelf	Saloon cars		
	Saloon cars		
Felt dampening pad, front floor front section	Saloon cars & associated vehicles		
	Saloon cars & associated vehicles		
Cardboard sound absorber, front floor front section	Saloon cars & associated vehicles	7485.06	7485.08
	Saloon cars & associated vehicles		
Bonnet, rubber, front floor covering	Except Superluxe	7503.14	7503.21
	404 Superluxe	7503.16	7503.22
L.H. front rubber mat	Except 404 Superluxe	7504.22	7504.31
	404 Superluxe	7505.18	7505.26
R.H. front rubber mat	Except 404 Superluxe	7504.26	7504.32
	404 Superluxe	7505.21	7505.27
L.H. front rubber mat	404 Superluxe	8939.04	8939.05
	Saloon cars	8942.21	8942.34
Rear bench cushion body	Saloon cars	08/23/27	35/36/37
	Saloon cars (according to shade)	8948.27	8948.40
Rear bench backrest cover	Saloon cars (according to shade)	08/29/33	41/42/43
	Saloon cars (according to shade)		
Rear bench backrest body	Saloon cars		
	Saloon cars		
Rear armrest and support	Saloon cars		
	Saloon cars		
Rear armrest cover	Saloon cars		
	Saloon cars		

Special order

NOTE - The above-listed parts are sold by T.U.P.A.C. 18 Boulevard National, La Garenne, Seine, France.

FLOOR REINFORCEMENT PROCEDURE FOR MOUNTING SAFETY BELTS
ON 404 SALOON CARS AND ASSOCIATED VEHICLES

FRONT FLOOR - ALL TYPES OF 404s

SAFETY BELT ANCHOR POINTS

As from serial numbers

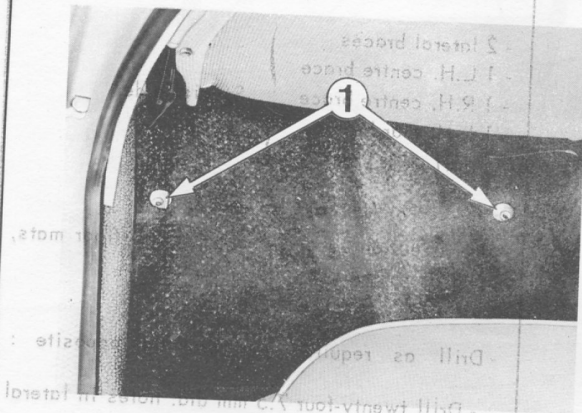
404	- 4.444.551
404 J	- 4.528.648
404 KF	- 4.559.550
404 C	- 4.497.302
404 C.KF	- 4.592.574
404 D	- 4.600.404
404 L	- 4.842.482
404 LD	- 4.977.658
404 U6	- 4.726.040
404 U6D	- 4.905.603

The front floor has been reinforced and incorporates 4 tapped anchor points for securing safety belts.

1 - 7/16" (11.11 mm) dia. mounting nuts
Pitch : 1.27 mm or 20 threads per inch.

BENCH-CHECKING MODIFIED HULL ASSEMBLIES

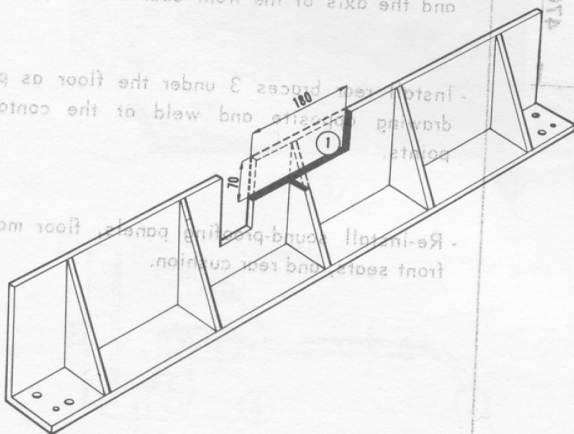
- CELETTE bench : no modification work.
- FORGES DE CHATILLON or FRANTZ benches : the rear floor holding crossbar should be modified.



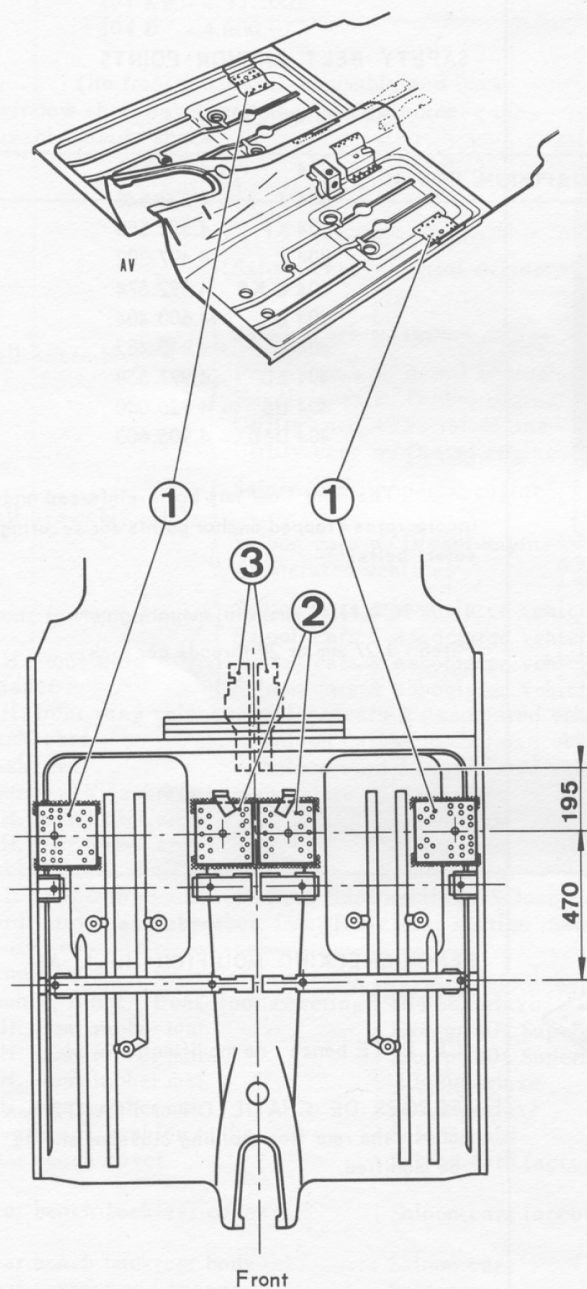
Drill as reduced size :
- Drill twenty-four 7.5 mm dia. holes in lateral places 1;
- Drill eighteen 7.5 mm dia. holes in centre places 2;
- Allow for spot-welding of the above parts with a torch.

- Locate and weld places 1 and 2 to obtain a 170 mm dimension between the anchor plates and the axis of the front seat front supports.

- Install sand-panels floor mats, front seats and rear cushion.
- Re-install sand-panels floor mats, front seats and rear cushion.
- Install sand-panels floor mats, front seats and rear cushion.



FLOOR REINFORCEMENT PROCEDURE FOR MOUNTING SAFETY BELTS ON 404 SALOON CARS AND ASSOCIATED VEHICLES



Parts required

- 2 lateral braces
 - 1 L.H. centre brace
 - 1 R.H. centre brace
 - 1 L.H. rear brace
 - 1 R.H. rear brace
- } Special order

- Remove front seats, rear cushion, floor mats, and floor sound-proofing panels.

- Drill as required per drawing opposite :

- Drill twenty-four 7.5 mm dia. holes in lateral braces 1,

- Drill eighteen 7.5 mm dia. holes in centre braces 2,

to allow for spot-welding of the above parts with a torch.

- Locate and weld braces 1 and 2 to obtain a 470 mm dimension between the anchor plates and the axis of the front seat front supports.

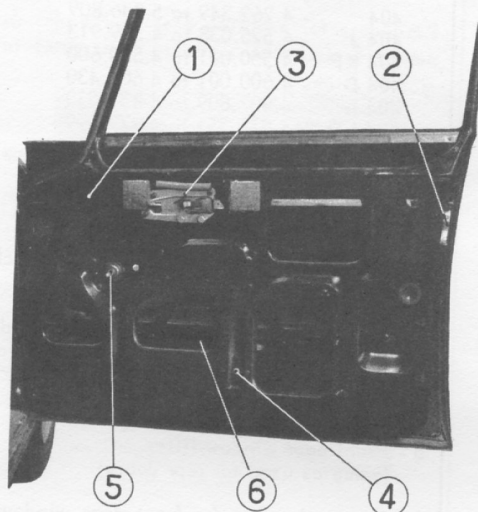
- Install rear braces 3 under the floor as per drawing opposite and weld at the contact points.

- Re-install sound-proofing panels, floor mats, front seats, and rear cushion.

STRIPPED FRONT & REAR DOORS - SALOON CARS AND ASSOCIATED VEHICLES

1st installation - With trim strip

Front door

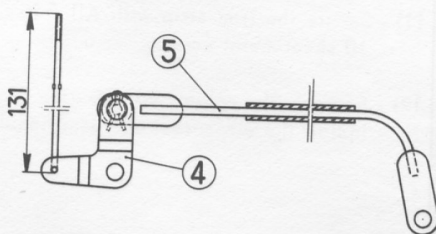
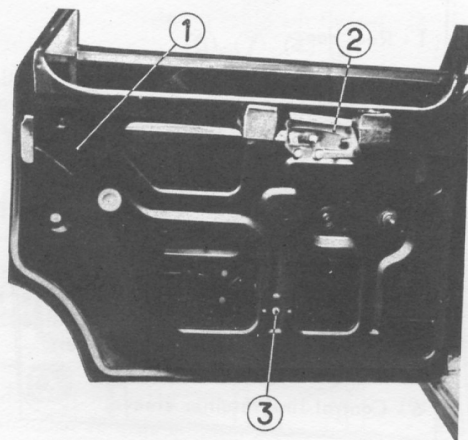


Up to serial numbers :

404 - 4.262.348
 404 J - 4.525.037
 404 L - 4.827.008
 404 LD - 4.975.350
 404 U6 - 4.704.784
 404 U6D - 4.900.974

- 1 - Front door
- 2 - Front door lock (with 176-mm long catch control rod)
- 3 - Remote control (attached to the inside face of the inner door panel)
- 4 - Window panel stop
- 5 - Front door window-lifter
- 6 - Support bracket for front door window panel.

Rear door

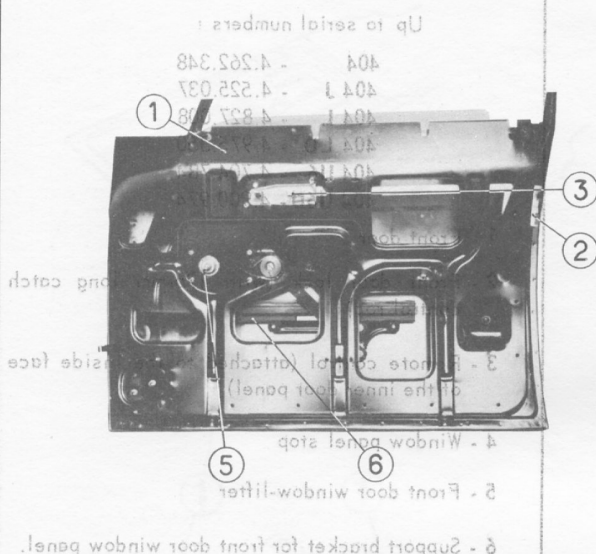


- 1 - Rear door
- 2 - Remote control (attached to the inside face of the inner door panel)
- 3 - Window panel stop
- 4 - Rear door control bellcrank (with 131-mm long rod)
- 5 - Rear door control link (with rubber sleeve)

STRIPPED FRONT & REAR DOORS OF SALOON CARS AND ASSOCIATED VEHICLES

2nd installation - Without trim strip

Front door

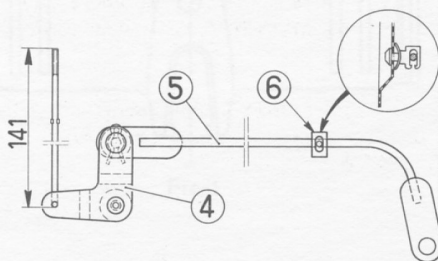
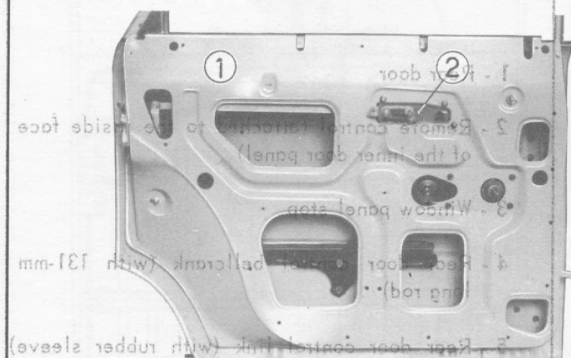


From serial numbers:

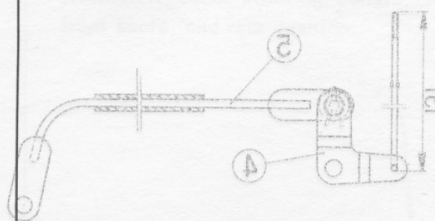
404	- 4.262.349 to 5.046.809
404 J	- 4.525.038 to 4.529.913
404 KF	- 4.550.001 to 4.570.600
404 D	- 4.600.001 to 4.605.430
404 L	- 4.827.009 to 4.851.530
404 LD	- 4.975.351 to 4.979.999
404 U6	- 4.704.785
404 U6D	- 4.900.975

- 1 - Front door
- 2 - Front door lock (with 181-mm long catch control rod)
- 3 - Remote control (attached to the inside face of the inner door panel and incorporating a window-lifter gear sector stop to replace window panel stop 4)
- 5 - Front door window-lifter (same as used for rear doors)
- 6 - Support bracket for front door window panel.

Rear door



- 1 - Rear door
- 2 - Remote control (attached to the inside face of the inner door panel and incorporating a window-lifter gear sector stop to replace window panel stop 3).
- 4 - Rear door control bellcrank (with 141-mm long rod)
- 5 - Rear door control link (without rubber sleeve, but positioned by Rilsan retainer sleeve 6 secured to the door inner panel).
- 6 - Control link retainer sleeve.

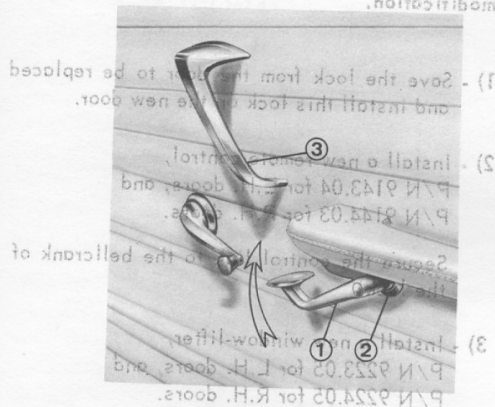


STRIPPED FRONT & REAR DOORS - SALOON CARS & ASSOCIATED VEHICLES

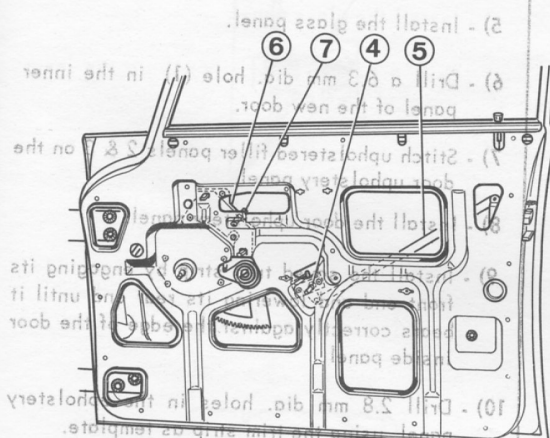
FRONT DOORS

3rd installation

Procedure for adapting a second model door to permit installation on 404s built prior to this modification.



4) - Save the window glass panel.
Replace the old fitting by fitting
P/N 9213.15, installed at 127 mm from the
glass panel.



11) - Secure the trim strip with Allen-head 3.2 x 10 sheet-metal screws.

12) - Screw in the catch button.
Install the elbow-rest and door handles.

Doors locks are equipped with a control lever.

As from serial numbers :

404	- 5.046.810
404 J	- 4.529.914
404 KF	- 4.570.601
404 D	- 4.605.431
404 L	- 4.851.531
404 LD	- 4.980.001

- 1 - Lever-type door lock
- 2 - Control lever escutcheon
- 3 - Grip-handle
- 4 - Door remote control
- 5 - Door remote-control link
- 6 - Door lock support plate
- 7 - Front door window-lifter stop

INTERCHANGEABILITY

The inner panels of the new model doors incorporate all holes and stamped sections required for installation on saloon cars, family cars, and utility cars.

Stripped front doors are therefore common to all three models listed above.

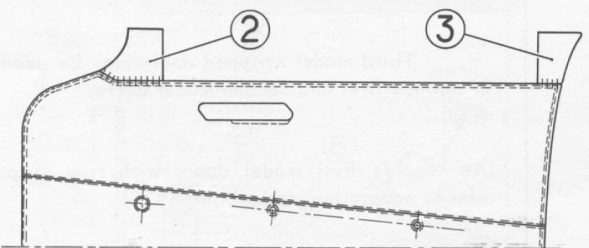
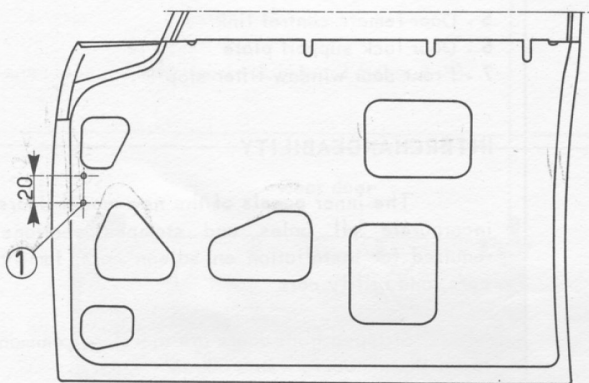
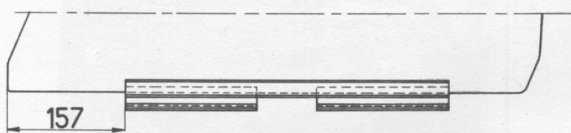
Stripped rear doors are identical for family cars and utility cars.

The new model door locks cannot be installed on cars built prior to the above modification.

Third model stripped doors may be used to replace first and second model doors.

(As regards first model doors with trim strip, refer to adaptation method, page 126).

FRONT & REAR DOORS - INTERCHANGEABILITY



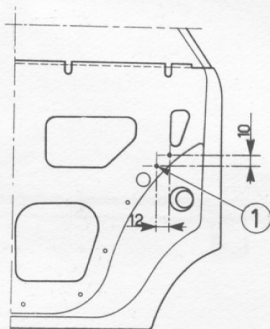
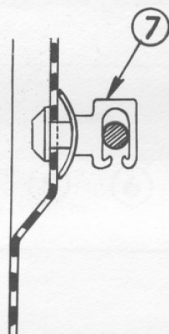
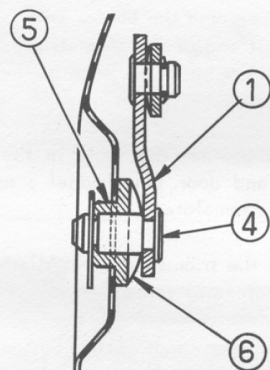
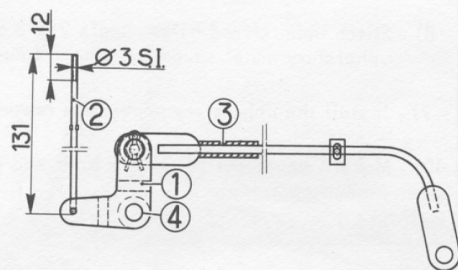
FRONT DOORS

Procedure for adapting a second model door to permit installation on 404s built prior to this modification.

- 1) - Save the lock from the door to be replaced and install this lock on the new door.
- 2) - Install a new remote control,
P/N 9143.04 for L.H. doors, and
P/N 9144.03 for R.H. doors.

Secure the control link to the bellcrank of the lock.

- 3) - Install a new window-lifter,
P/N 9223.05 for L.H. doors, and
P/N 9224.05 for R.H. doors.
- 4) - Save the window glass panel.
Replace the old fitting by fitting,
P/N 9213.15, installed at 157 mm from the
glass panel.
- 5) - Install the glass panel.
- 6) - Drill a 6.3 mm dia. hole (1) in the inner
panel of the new door.
- 7) - Stitch upholstered filler panels 2 & 3 on the
door upholstery panel.
- 8) - Install the door upholstery panel.
- 9) - Install the saved trim strip by engaging its
front end and lowering its rear end until it
bears correctly against the edge of the door
inside panel.
- 10) - Drill 2.8 mm dia. holes in the upholstery
panel, using the trim strip as template.
- 11) - Secure the trim strip with Allen-head 3.5 ×
10 sheet-metal screws.
- 12) - Screw in the catch control button.
Install the elbow-rest and door handles.



REAR DOORS

Procedure for adapting a second model rear door to permit installation on 404s built prior to this modification.

- 1) - Save the lock from the door to be replaced and install this lock on the new door.
- 2) - Save the safety catch control and install a new bellcrank (1).

Cut off the end of the catch control rod to reduce its length to 131 mm.

Thread the end of the rod over a length of 12 mm.

Move rubber sleeve 3 on the link towards bellcrank 1.

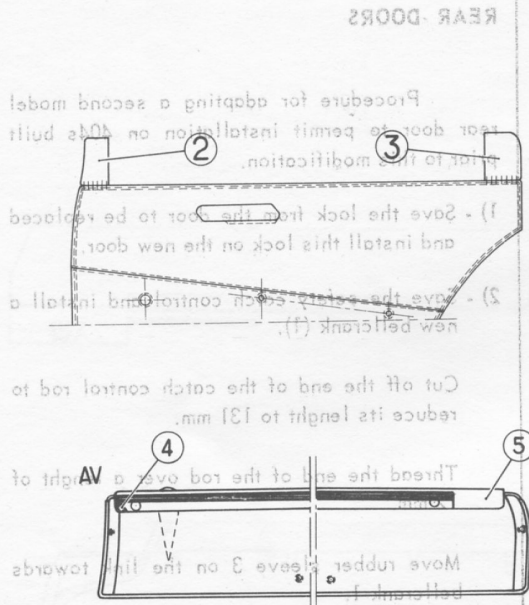
- 3) - Install the safety catch control.

Engage bellcrank pivot 4 in bushing 5 on the inner door panel after installing spring washer 6.

Secure the control link to the lock bolt.

Secure retainer sleeve 7, P/N 9162.03, to the inner panel of the door and engage the control link in the retainer sleeve.

- 4) - Save the remote control and mount it inside the door inner panel using three 6 × 10 "H" screws.
- 5) - Install the window-lifter and glass panel lower stop saved from the old door.
- 6) - Install the window glass panel.
- 7) - Drill a 6.3 mm dia. hole (1) in the inner panel of the door.



8) - Stitch upholstered filler panels 2 & 3 on the upholstery panel saved from the old door.

9) - Install the upholstery panel thus reworked.

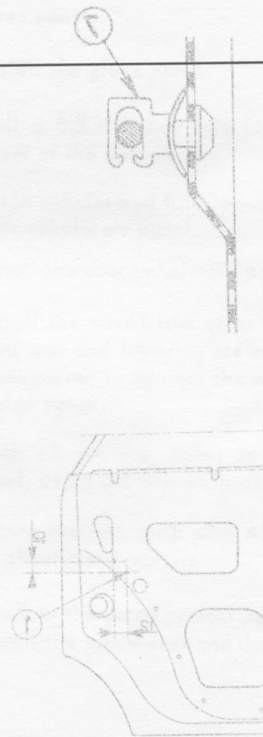
10) - Make a bevel cut (4) at the front end of the folded edge of the trim strip saved from the old door.

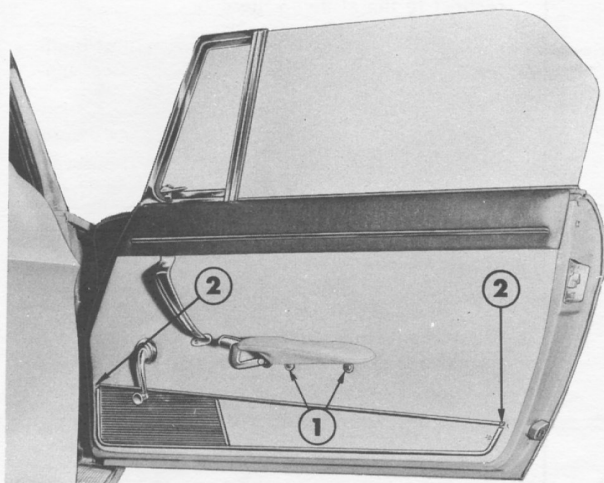
11) - Install the trim strip by engaging the rear end (5) of the folded edge between the inner door panel and the border strip; then rotate the front end of the trim strip until it bears correctly against the edge of the door inner panel.

12) - Drill a 2.8 mm dia. hole in the upholstery panel and door inner panel; use the trim strip as template.

13) - Secure the trim strip with Allen-head 3.5 x 10 sheet-metal screws.

14) - Screw in the catch control button and install the elbow-rest and door handles.



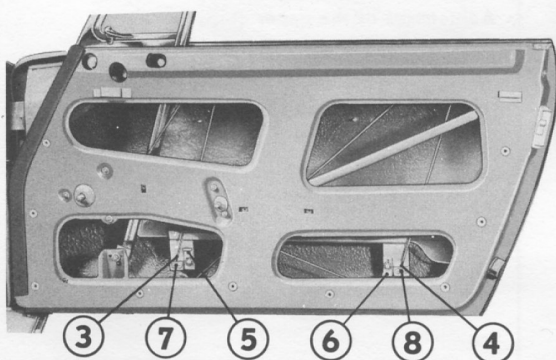


I - REPLACING THE GLASS PANEL OF A DOOR

Remove :

- Window-lifter crank,
- Inner door-opening handle,
- Two screws 1 located under the arm-rest (the arm-rest remains attached to the upholstery panel),
- Both attachment screws 2 for the door lower trim bar.

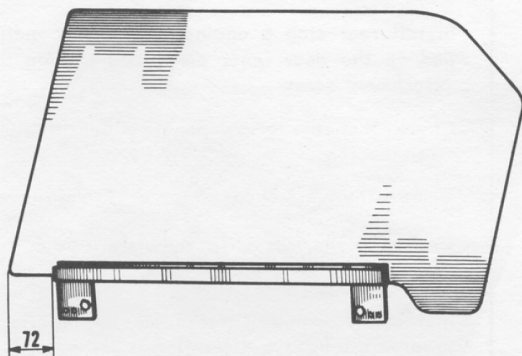
- Unstitch the upholstery panel and pull it down to remove it.
- Remove the upper trim strip (3 screws) by sliding it rearwards to disengaging it from the ventilator handle.
- Peel off the vinyl sheet used to cover the inner door panel.



- Mark the glass panel fitting attachment points on both sections of the cable (ref. No. 3 & 4).

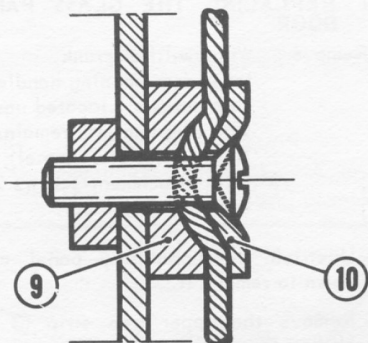
Remove : Both glass panel stops 5 & 6 both cable clamps 7 & 8.

- Remove the glass panel fitting.
- Remove all broken glass from the lower part of the door, if necessary.



Working at the bench :

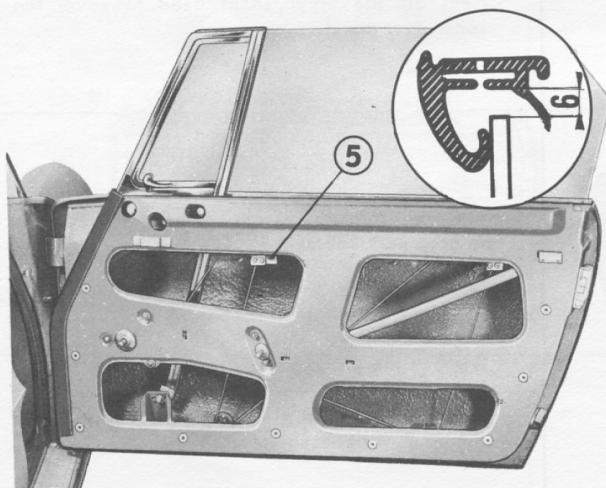
- Replace the glass panel rubber wedge, P/N 9209.10, systematically.
- Clean the glass panel fitting thoroughly.
- Smear the rubber wedge and fitting with cement.
- Place the wedge and fitting on the glass panel; the distance between the end of the fitting and the front end of the glass panel should be 72mm
- Remove excess cement.



- Check the alinement of the ventilator with respect to the slide on the door.

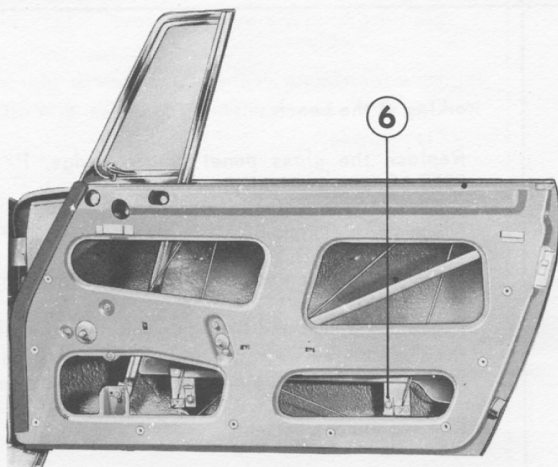
The ventilator should be removed and straightened if bent (see page 132, "Replacing ventilators").

- Engage the glass panel in the slide, make sure the glass panel does not bind, and lower it fully (adjust the position of rear slide if necessary).
- Assemble the cable clamps and insert the cable between plates 9 & 10.
- Bring the reference marks in alinement and tighten the cable clamp screws.



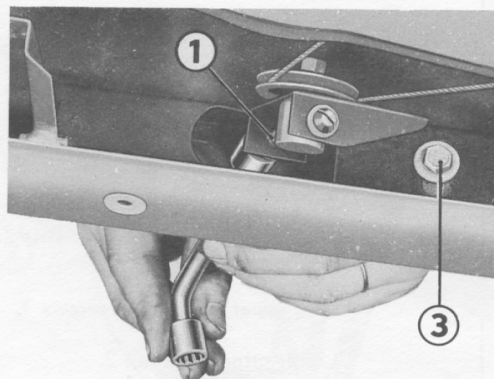
Adjustment of the upper stop :

- Close the door and raise the glass panel until its top edge is at 6 mm from the bottom of the upper rubber gasket, as shown on drawing opposite.
- Install front stop 5 against the corresponding pad on the door inner panel and tighten the attachment screw.



Adjustment of the lower stop :

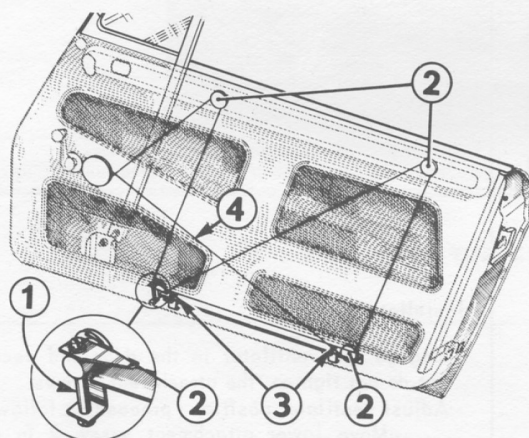
- Lower the glass panel until it is flush with the outer trim and rubber gasket.
- Install rear stop 6 against the corresponding pad on the door inner panel and tighten the attachment screw.
- Check that the glass panel slides freely ; raise it fully.
- Cement the vinyl sheet on the door inner panel.
- Re-install the trim strip, upholstery panel and door opening handle.
- Install the window-lifter crank by turning it towards the front and slanting it about 45 deg. downwards.



II - REPLACING A WINDOW-LIFTER AND CABLE ASSEMBLY

Remove : - Upholstery panel and trim strip (see page 129),
- Both cable clamps,
- Glass panel stops,
- Glass panel together with its fitting
- Window-lifter.

- Slacken cable tensioner 1 located on the lower pulley-bar ; to achieve this, remove the rubber plug from the lower end of the door to gain access to the tensioner screw.



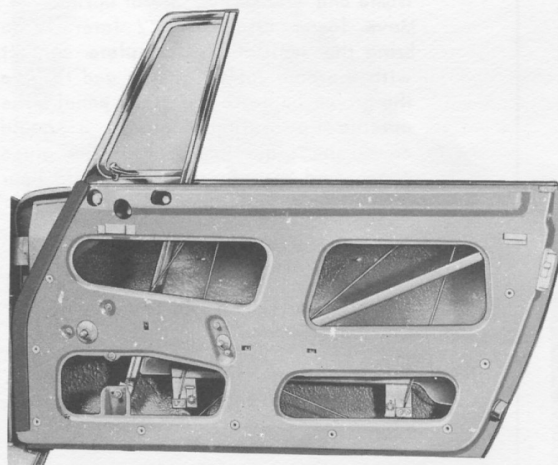
- Check that all 4 pulleys 2 rotate freely.

- Secure the new window-lifter.

- Engage the cable on the 4 pulleys successively, as indicated on drawing opposite (section 4 of the cable should be in front of the other cable sections).

- Turn tensioner screw 1 as required to obtain moderate tension of the cable.

- Adjust position of lower pulley bar by slackening attachment screws 3 to prevent the cable runs from rubbing against each other.



- Insert the glass panel in the corresponding slides, check that the glass panel does not bind, then lower it fully.

- Turn window-lifter crank backwards fully.

- Rotate it forwards by two full turns.

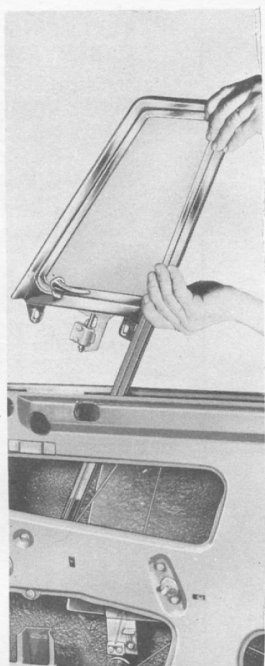
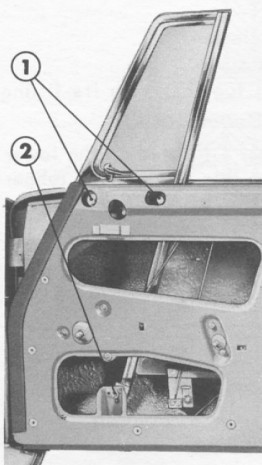
- Install both cable clamps with the crank in this position, and tighten the cable clamp screws.

- Install and adjust the window stops (see page 130).

- Check for proper operation and lubricate the window-lifter mechanism.

- Raise the window panel.

- Re-install the trim strip, upholstery panel, door-opening handle and window-lifter crank-which should be turned towards the front and slanted about 45 deg. downwards.



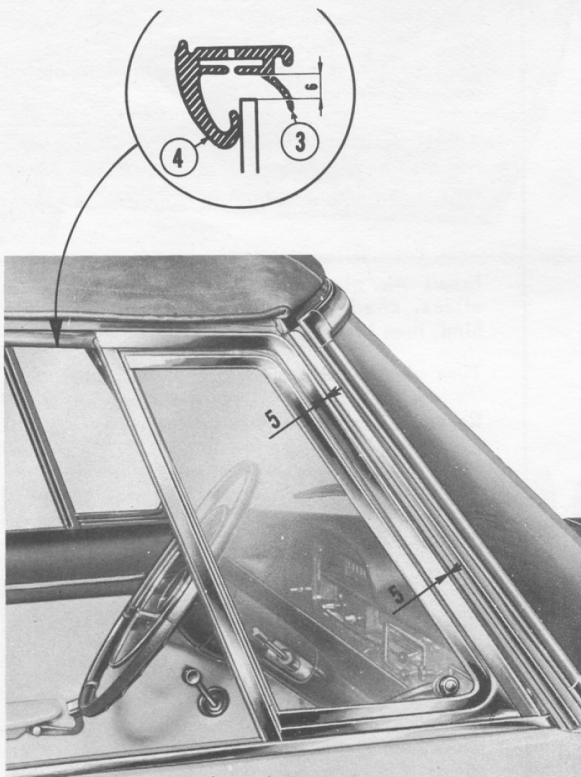
III - REPLACING A VENTILATOR

Removal :

Remove : - Upholstery panel and trim strip (see page 129).

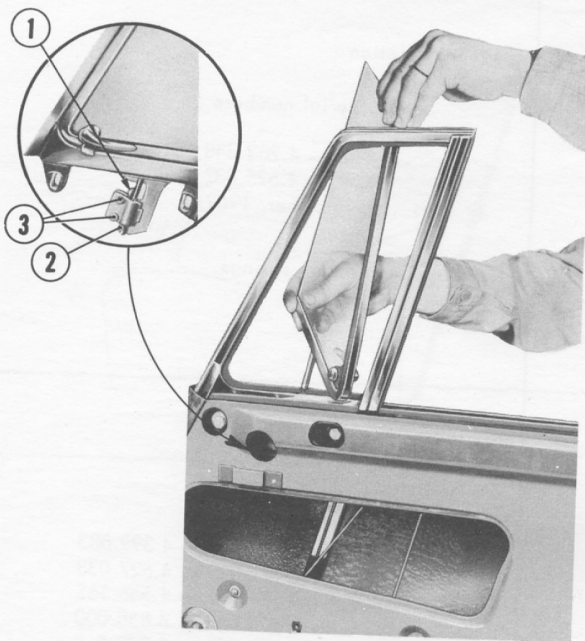
- Both upper attachment screws 1,
- Lower attachment nut 2.

- Raise the ventilator to remove it.



Installation

- Engage the ventilator in the door and secure, but do not tighten, the attachment screws.
- Adjust ventilator position ; proceed as follows :
 - Move lower attachment screw 2 in its mounting slot to obtain an even clearance of about 5 mm between ventilator frame and windscreen lateral upright.
 - Move lower attachment 2 laterally to bring the ventilator in complete contact with the door rubber gasket and to give the proper angle to the glass panel ; the outside lip of rubber gasket 3 should cover the glass panel, and the glass panel, and the glass panel should bear against inner lip 4.
- Tighten ventilator attachment screws.
- Check that the window panel slides freely ; adjust the lower attachment of the window rear channel if required.
- Re-install the trim strip, upholstery panel, door-opening handle and window-lifter crank.



IV - REPLACING THE MOBILE FRAME OF A DEFLECTOR

Removal

- Remove : - Upholstery panel and trim strip (see page 129),
- Both stop screws 1 & 2 on the lower pivot rod,
- Upper pivot screw.

- Slacken both screws 3 on lower bearing.

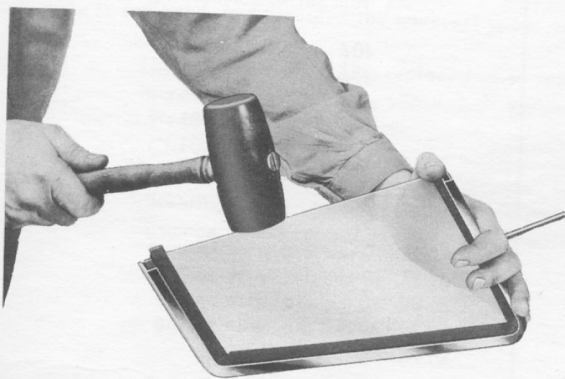
- Lift the mobile frame and turn it inwards to remove it.

Installation

- Installation is the reverse of the removal procedure.

- Adjust hardness of rotation of the ventilator by tightening screws 3 as required.

V - REPLACING THE GLASS PANEL OF A VENTILATOR



- Remove the ventilator mobile frame (see above)

- Save the ventilator handle.

- Clean the mobile frame carefully.

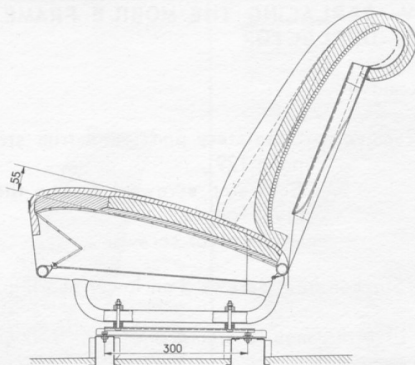
- Install a new rubber gasket, P/N 9338.05 on the glass panel. Trim and cut off the corners.

- Smear with tallow and install the above assembly in the frame by tapping lightly with a mallet on the edge of the glass panel (the frame should bear evenly on a wooden block).

- Cut off the ends of the rubber gasket and clean the glass panel.

- Install the ventilator handle.

- Re-install the ventilator mobile frame (see above).



1st installation

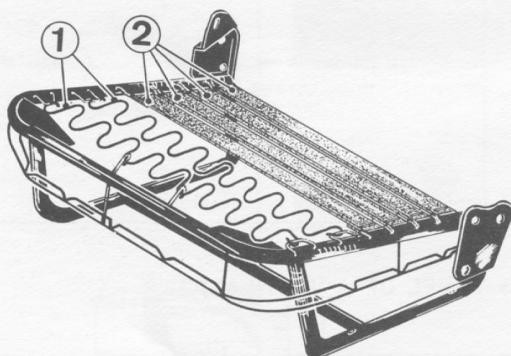
Up to serial numbers :

404 - 4.262.348

404 J - 4.525.037

(September, 1962)

Lengthwise springs.



2nd installation

From serial numbers :

404 - 4.262.349 to 4.399.083

404 J - 4.525.038 to 4.527.033

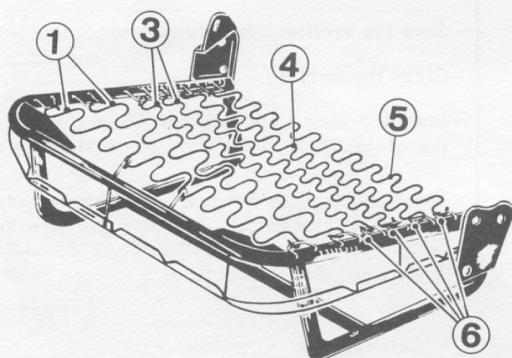
404 KF - 4.550.001 to 4.556.165

404 L - 4.825.001 to 4.838.000

404 LD - 4.975.001 to 4.977.068

1) 34/10 mm dia. wire crosswise springs

2) Rubber straps.



3rd installation

As from serial numbers :

404 - 4.399.084

404 J - 4.527.034

404 KF - 4.556.166

404 D - 4.600.001

404 L - 4.838.001

404 LD - 4.977.069

1) 34/10 mm dia. wire springs

3) 37/10 mm dia. wire springs

4) 40/10 mm dia. wire spring

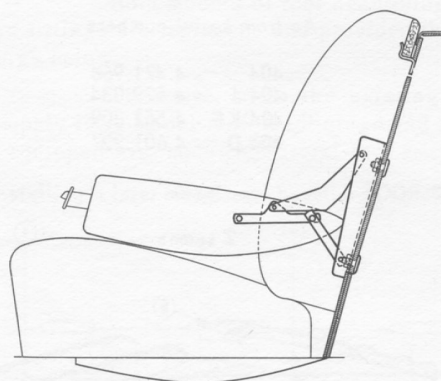
5) 42/10 mm dia. wire spring

6) Attachment hooks

NOTE. - As from serial numbers : 404 - 5.046.810
404 J - 4.529.914
404 D - 4.605.431

404 L - 4.851.531
404 LD - 4.980.001

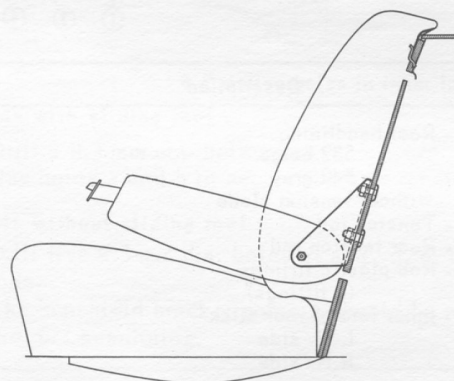
Cloth covers used for front and rear seats incorporate soldered plastic ribs.
Paddings used for the seat cushions and backrests have been changed accordingly.
Cloth covers are interchangeable, provided the corresponding paddings are also replaced.



EARLIER INSTALLATION

Up to serial numbers :

404	- 4.399.562	} End of series equipped with earlier model hull assembly
404 J	- 4.527.038	
404 KF	- 4.556.190	



LATER INSTALLATION

As from serial numbers :

404	- 4.400.001	} Beginning of series equipped with later mo- del, increased usable inside space hull as- semblies
404 J	- 4.528.001	
404 KF	- 4.557.001	

INTERCHANGEABILITY - Rear seats are interchangeable, provided the backrest, cushion body and arm-rest assembly is replaced, and provided the backrest upper attachment and arm-rest support attachment are reworked.

The following should be replaced when replacing an earlier model hull assembly with a later model, increased usable inside space, hull assembly :

- Pedal support and gasket,
- Clutch, brake, and accelerator pedal,
- Double acting contactor switch (Conac) for 404s with JAEGER clutch,
- Steering column jacket backing plate and gasket,
- Change speed control rod on all 404s built prior to the following serial numbers :

404	- 4.383.925	404 LD	- 4.976.871
404 KF	- 4.555.262	404 U6	- 4.718.016
404 L	- 4.836.026	404 U6D	- 4.903.753

- Besides, the upper end of the hand brake control cable sheath should be shortened by 12 mm and the petrol or fuel pipes should be re-routed.

BODY WORK AND ASSOCIATED EQUIPMENTROOF HEADLINING - SALOON CARS

Earlier installation

Up to serial numbers :

404 - 4.471.967
 404 J - 4.529.033
 404 KF - 4.561.308
 404 D - 4.601.226

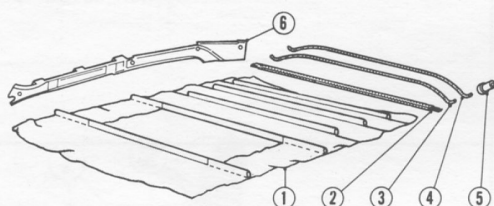
Later installation

As from serial numbers :

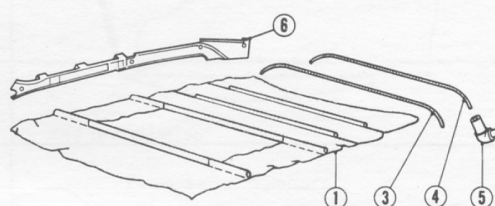
404 - 4.471.968
 404 J - 4.529.034
 404 KF - 4.561.309
 404 D - 4.601.227

WITH SLIDING ROOF

3 seams



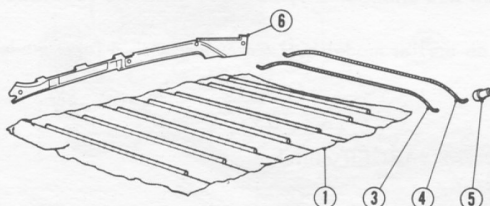
2 seams



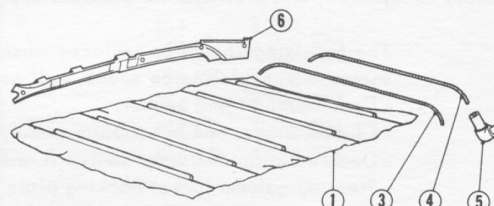
Description	P/N	Description	P/N
1 - Roof headlining 552 beige 549 grey	8323.11 8323.12	1 - Roof headlining 552 beige 549 grey	8323.22 8323.23
2 - Tension blade	8325.11	Without tension blade	
3 - Tension rod	8330.05	3 - Tension rod	8330.06
4 - Rear tension rod	8331.04	4 - Rear tension rod	8331.06
5 - Rod & blade plastic fittings (6 fittings)	8334.01	5 - Rod plastic fittings (4 fittings)	6987.11
6 - Inner lateral roof stick L.H. side R.H. side	8310.13 8311.15	6 - Inner lateral roof stick L.H. side R.H. side	8310.17 8311.19

WITHOUT SLIDING ROOF

7 seams



5 seams



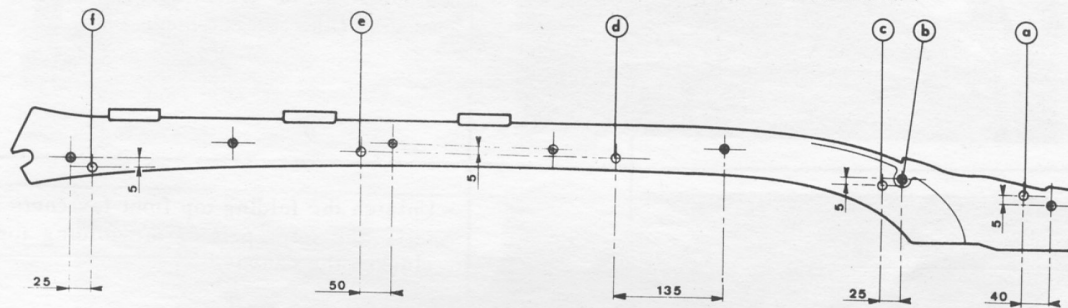
Description	P/N	Description	P/N
1 - Roof headlining 552 beige 549 grey	8323.13 8323.14	1 - Roof headlining 552 beige 549 grey	8323.24 8323.25
3 - Tension rods (6 rods)	8330.05	3 - Tension rods (4 rods)	8330.06
4 - Rear tension rod	8331.04	4 - Rear tension rod	8331.06
5 - Tension rod plastic fittings (14 fittings)	8334.01	5 - Tension rod plastic fittings (10 fittings)	6987.11
6 - Inner lateral roof stick L.H. side R.H. side	8310.13 8311.15	6 - Inner lateral roof stick L.H. side R.H. side	8310.17 8311.19

INTERCHANGEABILITY

Both models of roof headlinings are interchangeable, provided the tension rods and plastic fittings are replaced, and provided the inner lateral roof sticks are drilled as indicated on drawings below.

Therefore, when the existing stocks will be exhausted, Spare Parts Department will supply later model roof headlinings and inner lateral roof sticks only, as well as hull assemblies equipped with modified lateral roof sticks.

1) - Installing a later model roof headlining on 404s built prior to the above modification :



● Existing holes in inner lateral roof sticks

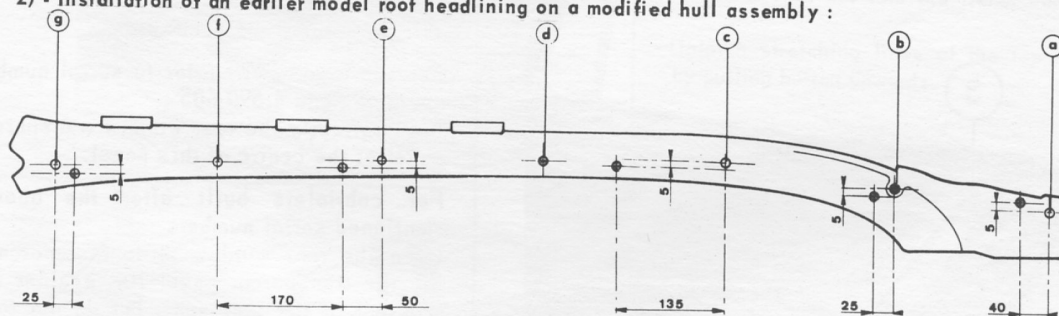
a) 404s with sliding roof :

- Drill a 8.3 mm dia. hole at a,
- Use holes a and b to secure the new tension rods.

b) 404s without sliding roof :

- Drill five 8.3 mm dia. holes at a, c, d, e, and f ; use these holes to secure the new tension rods.
- The sunshield bracket corners should be rounded off slightly to avoid any risk of cutting into the roof headlining.

2) - Installation of an earlier model roof headlining on a modified hull assembly :



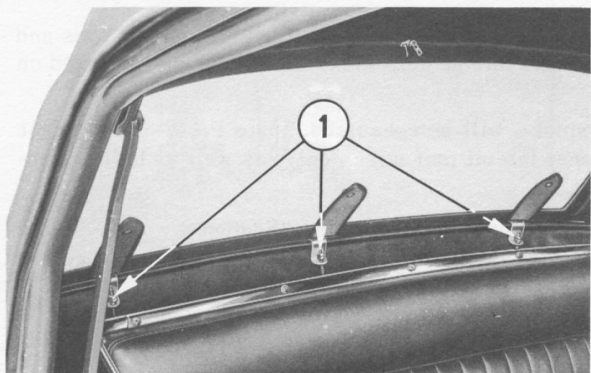
● Existing holes in inner lateral roof sticks

a) 404s with sliding roof :

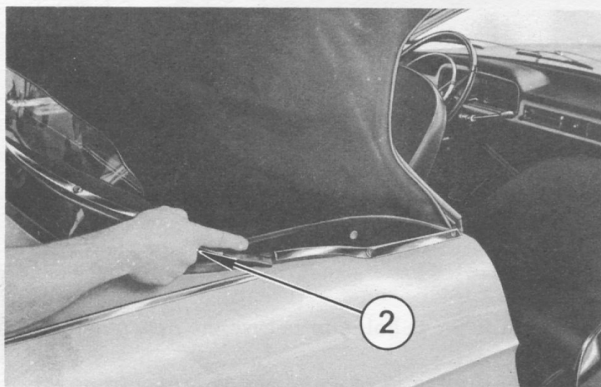
- Drill two 8.3 mm dia. holes at a and c.
- Weld three tension blade attachment lugs on the frame of the sliding roof.
- Use holes a and b for attaching the tension rods, and hole c for attaching the tension blade.

b) 404s without sliding roof :

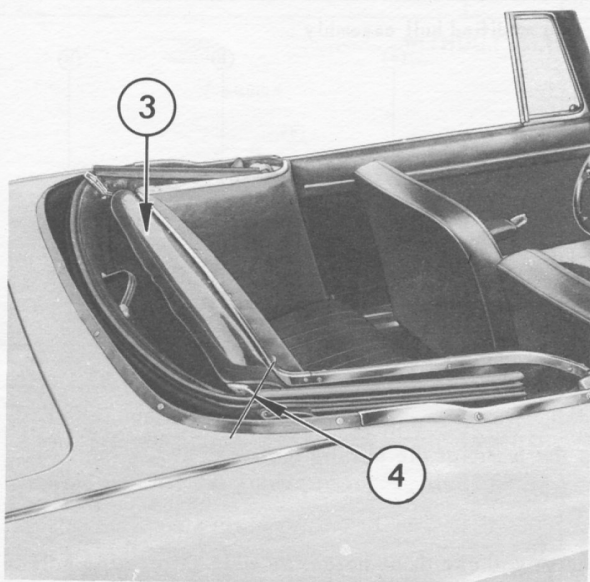
- Drill five 8.3 mm dia. holes at a, c, e, f, and g, and use these holes, as well as existing holes b and d for attaching the tension rods saved from the old jull.

**REMOVING & STORING THE FOLDING TOP**

- Remove attaching nuts 1 for the canvas folding top rear trim strip and disengage the hooks from the corresponding angle plates (up to serial numbers 4.495.599 and 4.590.267, the rear frame is secured by means of the two end-hooks only).



- Unlatch the folding top front fasteners and raise the front part of the folding top to slacken the canvas.
- Release the side snap-fasteners on the rear deck panel and free rear bail 2 by pulling it upwards and backwards.



- Store the rear bail in the bottom of the folding top storing recess.
- Tilt the folding top backwards.

For cabriolets built prior to serial number 4.495.686 and 4.590.605 :

Fold correctly the rear window transparent panel at the centre of this panel.

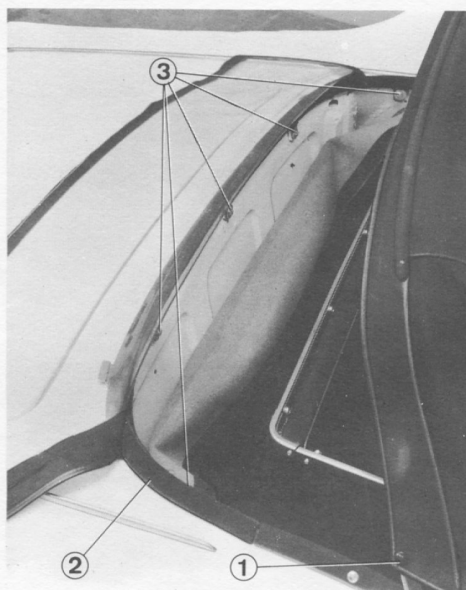
For cabriolets built after the above-mentioned serial numbers :

Open the rear window slide fastener and lay the transparent panel flat against the backrest of the rear seat, but do not fold the panel

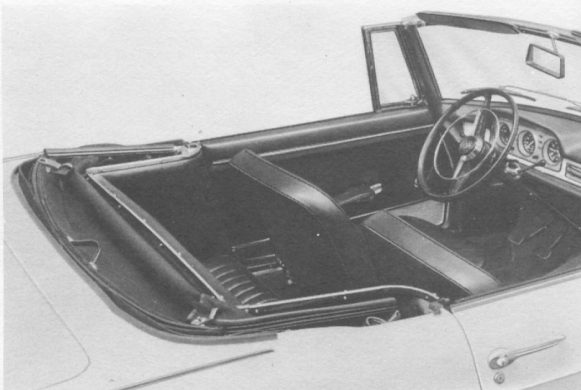
- Store the folding top correctly in its storage recess. The upper point (4) of the folded top should be level with the rear rim of the car body.
- Fold back the rear window transparent panel and slide fastener assembly 3 over the folded canvas top assembly.

**FOLDING TOP**

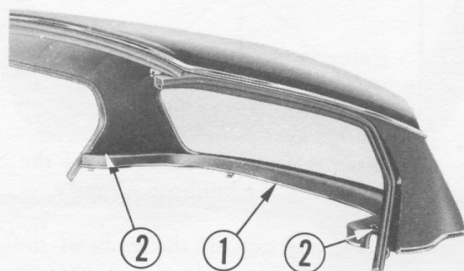
- Unlock both left and right top attachments at upper part of the windscreen pillars by pulling the locking handles until the striker is released.
- To open rear window slide zip fastener runner across the top to the opposite side until completely opened.



- Release both side snap fasteners (1) left and right, and unfasten rear window and the folding top on each side.
- Clear the rear of the top storage recess by unfastening the Velcro (2) strip.
- Slacken all five fixing screws (3) of rear top rim and remove the rear window assembly.
- Install the rear top rim and rear plastic window flat against the bottom of the top storage recess but do not fold the transparent panel.
- Unlatch stretching links of the top rear bail by pulling button upwards.

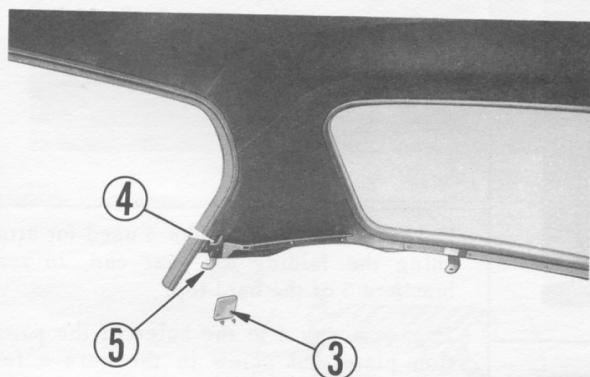


- Fold back the top and arrange correctly in its recess.
- Ensure that the cloth does not get caught up between the metal fittings or body edges.

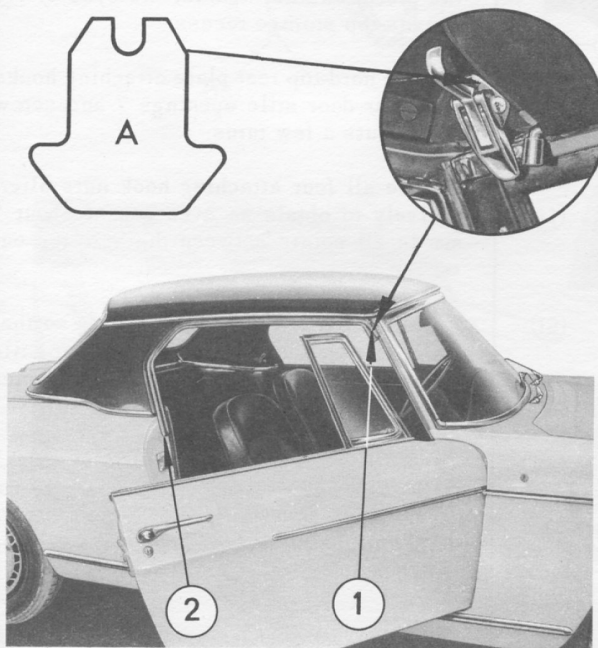


PREPARING THE HARD-TOP

- Remove rear shelf 1 by removing attachment screws 2 and pulling shelf towards the front.



- On either side, remove access plate 3 for nut 4 securing lateral attachment hook 5.



INSTALLING THE HARD-TOP

- Locate the hard-top on the car by positioning front end of gasket 1 against wind-screen lateral upright, and rear end 2 against the rear edge of the door opening.
- Lock the front crossbar of the hard-top ; blocking spacers A packed in a bag supplied with the hard-top should be installed under the base plate of the attachment hooks, if required.

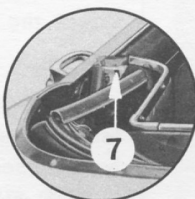
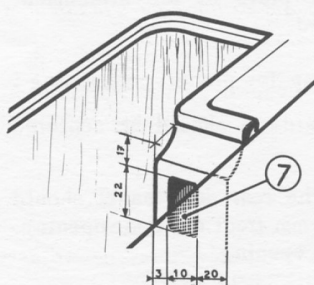
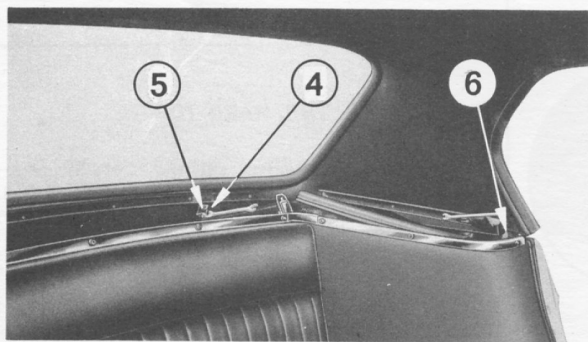
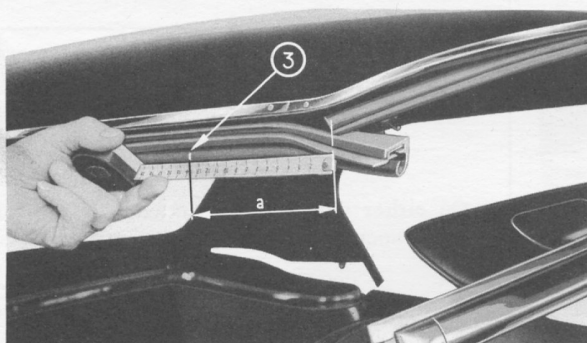
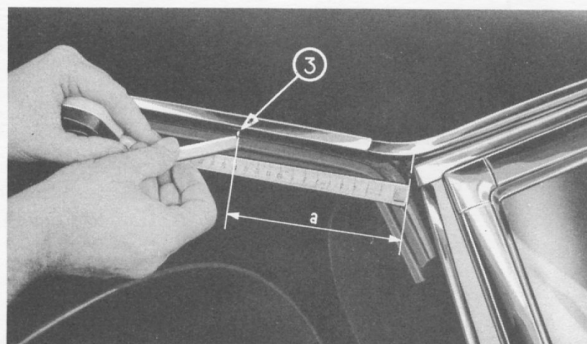
Check the *hard-top* for proper positioning :

laterally : the hard-top should be centered correctly ;

longitudinally : the rear deck panel should be recessed by 5 mm front the door opening, or flush with this opening.

BODY WORK AND ASSOCIATED EQUIPMENT

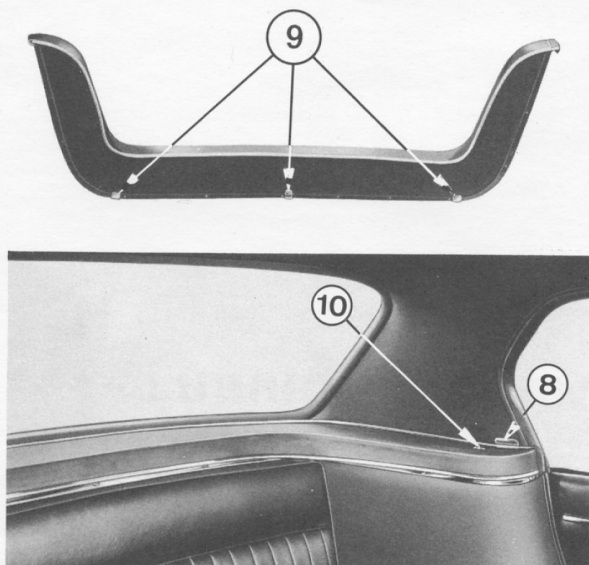
INSTALLING THE HARD-TOP ON 404 CABRIOLETS



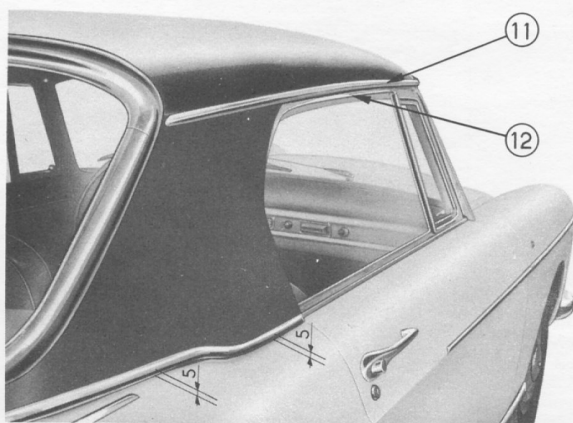
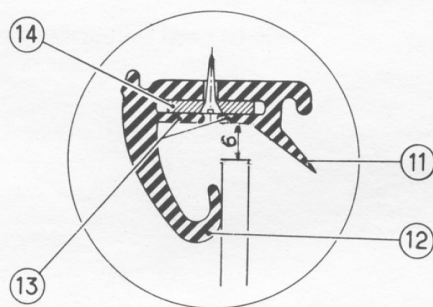
- Using a scale, note the position of the gaskets with respects to the lateral upright of the windscreen (dimension a).
- Unlock the front cross-bar of the hard-top and raise the hard-top slightly.
- Mark and cut off the ends of the gaskets at dimension a from reference 3, so that the gaskets press against the lateral uprights of the windscreen.
- Lock the front end of the hard-top.

- Engage both lateral hooks 4 used for attaching the folding top rear end, in rear brackets 5 of the hard-top.
- Engage hooks 4 in the holes of the partition plate and screw in the nuts a few turns. Make sure the hooks bear against the plate, and not against the eyes of the canvas-top storage recess.
- Engage hard-top rear plate attaching hooks 6 in rear door stile openings 7 and screw in the nuts a few turns.
- Torque all four attaching hook nuts alternatively to obtain an even gap of about 5 mm in all points between the hard-top outer rim and the hull of the car.
- Cut off the rear end of the gaskets so that the gaskets press against the door stile uprights and door inner trim panels when the doors are closed.

NOTE.- The early models of cabriolets do not include openings 7 ; these openings should therefore be bored as indicated on the drawing opposite.



- Secure plates 8.
- Install the rear shelf by engaging all three rear catches 9 under the hard-top rear angle.
- Torque both front attachment screws 10.



- Check door window glass panel position with respect to the corresponding gaskets: Outer lip 11 should cover the glass panel, and the glass panel should press against inner lip 12.

If required, spread apart lips 13 covering metal strip 14, loosen the gasket attachment screws slightly and slide the gasket laterally until it bears correctly against panel.

- Make sure the gaskets press correctly over the whole length of the door opening. If a small void remains, fill it up with black putty, bodywork type.

NOTE. - If, exceptionally, adequate results cannot be obtained by moving the gasket laterally, the slant of the door window panel should be adjusted as follows :

- Remove the upholstery of the door and move the lower ends of the window slides laterally.
- The position of the folding top gaskets with respect to the new location of the window panels should then be adjusted when re-installing the canvas top.