

Adjustments

Description		Adjustment mm
Preloading of torque ball shells		0 to 0.1
Breakway torque for drive pinion bearing		3.0 to 3.5 Nm
Backlash in differential		0.15 to 0.20
Shift dog play in differential lock		0.5 ± 0.2
End play, deep-groove ball bearing in wheel hub drive		0 no preloading
End play, deep-groove ball bearing on driven gear		0
Bearing play at differential (taper roller bearing)		0 no preloading
Backlash		0.15 to 0.20
Steering knuckle bearing		no play
Boss at torque ball casing	a	27
Bore dia. in torque ball casing	b	13.2
Length for adapter socket	A	33 ± 0.3
Torque ball casing	Bore dia. in torque tube	9.8
	Bore countersinking	1 × 45°
	Spacing	a

Necessary materials

Cons. No.	Part	Part No.
1	Teroson Atmosit, non-curing	regular
2	Longlife lubricating grease	regular
3	Molybdenum disulfide grinding paste	regular
4	Loctite No. 241	002 989 70 71
5	Ciba adhesive „Araldit“ with bonding agent 123 B and hardener 953 B	regular
6	Molykote Paste DX	regular
7	Molykote liquid grease	regular
8	Graphite grease	regular
9	Anti-corrosion oil SAE 30	regular
10	Hypoid gear oil SAE 90	regular
11	Loctite Nr. 274	002 989 02 71

Tightening torques

Location	Thread	Nm	737.0	737.1
Wheel hub to steering knuckle	M 12 X 1,5–10.9	90 to 100	X	X
Wheel hub to driven gear	M 16 X 1,5–10.9	320	X	X
Nut, clamping bolt to driven gear	M 20 X 1,5	220	X	X
Brake disk to wheel hub	M 16 X 1,5	320		X
Fixed caliper to reduction gear housing	M 16 X 1,5–12.9	320		X
Torque ball casing to transmission	M 10 – 10.9	60	X	X
Drive shaft to transmission	M 12 X 1	56	X	X
Torque tube to center axle housing	M 12 X 1,5–10.9	90 to 100	X	X
Axle tubes to center axle housing	M 12 X 1,5 X 45 M 12 X 1,5 X 175	90 to 100 135	X	X
Ring gear to differential housing	M 12 X 1,5–10.9	110	X	X
Axle strut to axle tube	M 16 X 1,5–10.9	250	X	X
Axle strut to torque tube				
Steering knuckle arm/steering arm to steering knuckle	M 16 X 1,5–12.9	400	X	X
Stop to steering knuckle	M 12 X 1,5–8.8	100	X	X
Transverse link to frame and axle	M 14 X 1,5–10.9	180	X	X
Ball joint, tie rod to steering arm and steering knuckle arm	M 18 X 1,5	180	X	X
Front spring to axle and frame	M 14 X 1,5–8.8	140	X	X
Shock absorber mounting to axle and frame	M 20 X 1,5–8.8	240	X	X
Wheel nuts	M 18 X 1,5	350	X	X