

Steering — Group 46

Play in Steering Assembly Units

Permissible play, measured at steering wheel circumference	max. 25
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Steering Gear Housing, Steering Shaft and Steering Worm

Steering shaft	Upper and lower bearing bushing			Steering gear housing
Bearing diameter	Internal diameter rough-turned	Internal diameter final	External diameter	Base bore diameter
$\frac{29.993}{29.980}$	$\frac{29.5}{29.6}$	$\frac{30.000}{30.013}$	$\frac{32.059}{32.043}$	$\frac{32.000}{32.025}$

Taper roller bearing				Steering worm	Steering gear housing
Part No.	Internal diameter	External diameter	Width	Bearing seating diameter	Base bore diameter
000 981 03 18	$\frac{19.590}{19.600}$	$\frac{44.475}{44.450}$	$\frac{14.180}{14.448}$	$\frac{19.615}{19.602}$	$\frac{44.470}{44.495}$

Pressure Spring

External diameter	Wire gage mm	Free length mm	Length under load	
			mm	kg
$17.5^{-0.1}$	3.5	23.6 ± 0.2	18.7	80^{+10}_{-5}

Pressure Sleeve

External diameter	Internal diameter	Length
$\frac{22.048}{22.035}$	$\frac{17.8}{18.0}$	22

Pressure Screw

External diameter	Internal diameter	Tightening of pressure screw in cover
M 28 x 1.5	$\frac{22.2}{22.3}$	Tighten hard, then 3-4 mm back, measured around circumference of pressure screw

Steering Gear Arm

Crank	39 ± 0.3
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Steering Relay Arm

Trunnion bearing	Bearing bushing			Steering relay arm
Base bore diameter	External diameter	Internal diameter		Bearing diameter
		rough-turned	final	
$\frac{22.000}{22.021}$	$\frac{22.048}{22.035}$	$\frac{17.7}{17.8}$	$\frac{18.006}{18.024}$	$\frac{17.984}{17.966}$
Permissible radial play of steering relay arm			0.022 — 0.058	
Oversize dimension of bearing bushing			0.014 — 0.048	