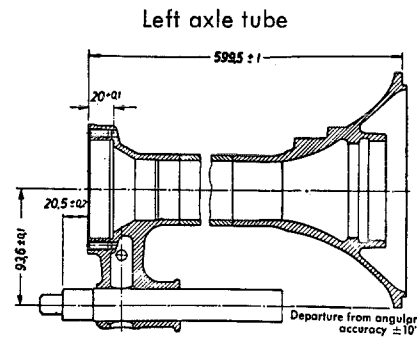


Fig. 35 — 5/16

Bore in axle tube diameter mm	Supporting tube external diameter mm	Oversize mm
$\frac{26.000}{26.021}$	$\frac{26.048}{26.035}$	+ 0.014 to + 0.048

16. Rub tallow on the new supporting tube and press the supporting tube in. When pressing in, care must be taken to ensure that the end

of the bolt is not damaged (Figs. 35 — 5/16 and 35 — 5/17).



Right axle tube

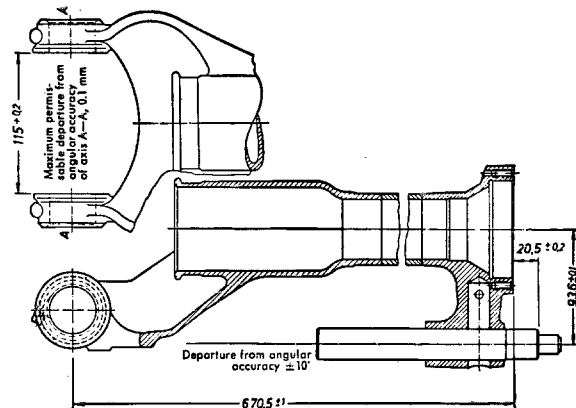


Fig. 35 — 5/17

17. Use Checking Device 180 589 09 21 to check the parallelity of the axis of the axle tube and the supporting tube which has been pressed in (see Section D. Axle Tubes, Para. 4).

E. Rear Axle Housing

Dimensions and tolerances of rear axle housing

in mm

Function	Designation	Outer race of bearing diameter	Bearing seat in housing diameter	Force-fit dimension (+) or clearance (—)
Angular contact bearing with split inner race for drive pinion	000 981 04 27 000 981 07 27 (optional)	$\frac{80.000}{79.987}$	$\frac{79.994}{80.013}$	— 0.026 to + 0.006
Cylindrical roller bearing for drive pinion	000 981 16 01	$\frac{80.000}{79.987}$	$\frac{79.985}{80.004}$	— 0.017 to + 0.015
Taper roller bearing for differential	30208 DIN 720	$\frac{80.000}{79.987}$	$\frac{79.985}{79.999}$	— 0.012 to + 0.015

1. Check the bores for pits or scoring. The bores must not be re-machined. If necessary, the rear axle housing must be replaced.
2. Check the contact surfaces for the eyes of the right axle tube at the rear axle housing. If the surfaces are damaged or worn, they should be reconditioned in the same way as the eyes of the right axle tube (see Section D and Fig. 35—5/13, Fig. 35—5/15 and Fig. 35—5/19).

A stock reduction of up to 0.3 mm on each side is permissible. The diameter of the bore is 27.983—27.996 mm.

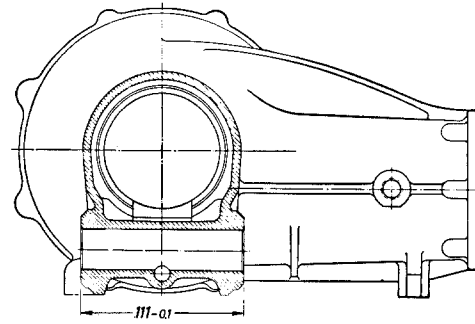


Fig. 35—5/19

F. Gear Train

Drive Pinion Shaft:

1. Check the drive pinion shaft for run-out. If the permissible run-out is exceeded at the various points (Fig. 35—5/20), the drive pinion shaft must be replaced.

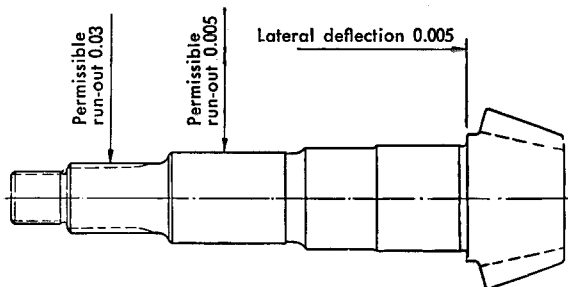


Fig. 35—5/20

Note: The drive pinion shaft must only be replaced together with the ring gear.

2. Check the bearing seats (dimensions and tolerances, see Table).

When pressing the bearings onto the drive pinion shaft, be careful to avoid chipping.

Pressure must only be exerted on the bearings at the inner race.

Dimensions and tolerances of drive pinion shaft in mm

Designation of bearing	Inner race of bearing diameter	Bearing seat on the drive pinion shaft diameter	Force-fit dimension (+) of clearance (—)
Cylindrical roller bearing 000 981 16 01	$\frac{39.988}{40.000}$	$\frac{40.013}{40.002}$	+ 0.002 to + 0.025
Angular contact bearing 000 981 04 27 000 981 07 27 (optional)	$\frac{34.988}{35.000}$	$\frac{35.006}{34.995}$	— 0.005 to + 0.018

Joint Flange:

3. Check the joint flange for lateral deflection. The deflection, measured at the outer diameter, must not be more than 0.02 mm.

If, after repositioning on the splines, the deflection is still greater than 0.02 mm, the joint flange can be turned down to 5.7 mm thickness. Otherwise, the joint flange must be replaced. If the sealing surface for the seal at the joint flange is worn, the sealing surface can be reconditioned, removing up to 0.5 mm of stock. When the sealing surface is new, the diameter is 34.840 to 35.000 mm. After reconditioning, the sealing sur-