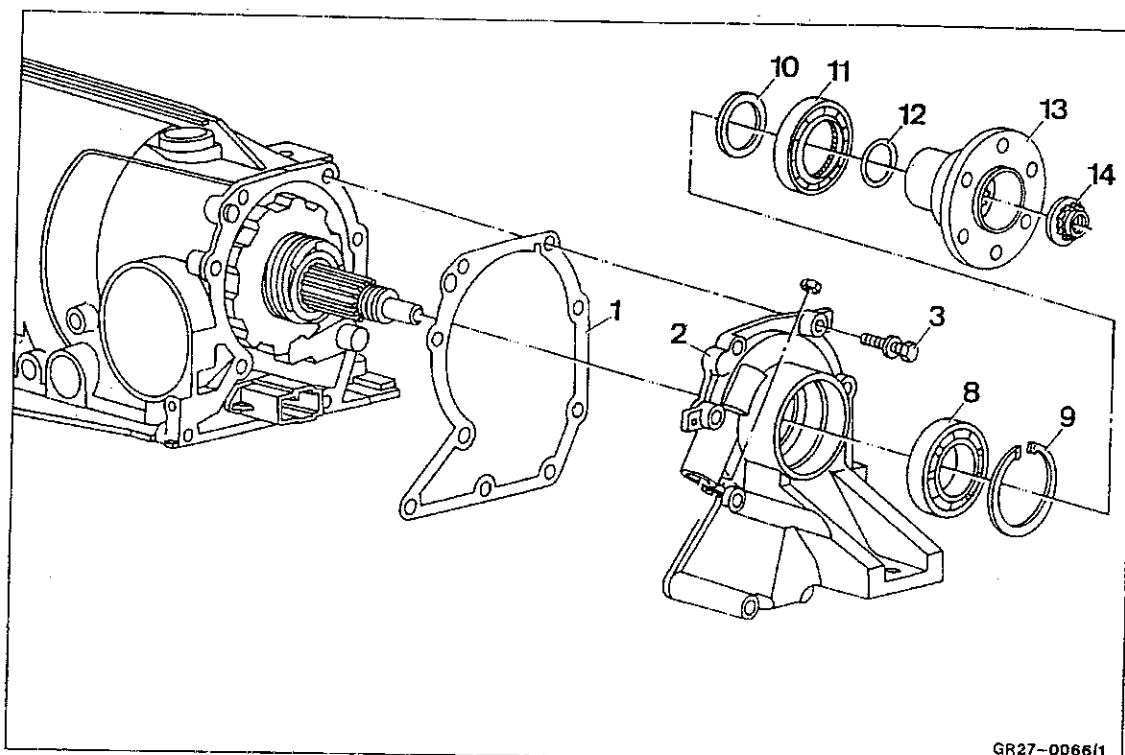


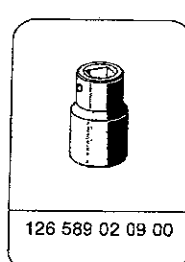
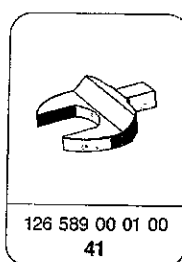
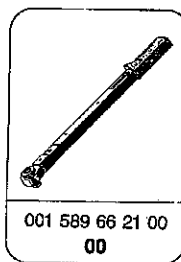
Removal and installation and disassembly and assembly of rear cover 27.51

Tightening torques



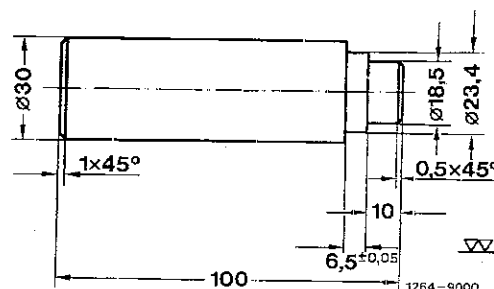
Item no.	Designation	Nm
3	Hexagon bolt	13
14	Twelve-point collar nut	120

Special tools



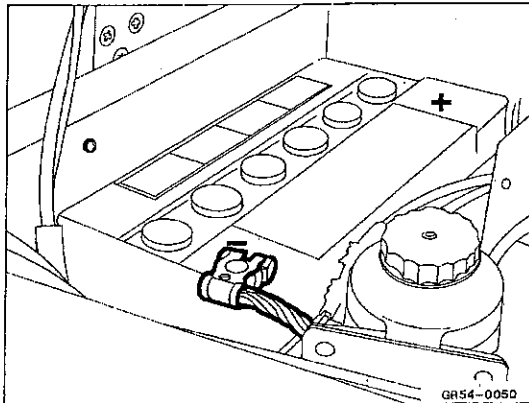
Tool for self-assembly

Note: The drive-in drift is shop made corresponding to the specified dimensions.

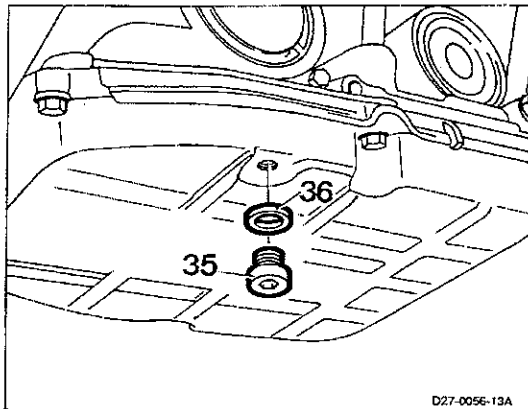


Removal

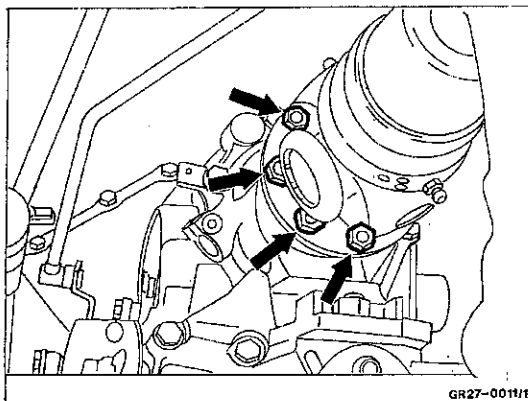
- 1 Disconnect battery at negative terminal.
- 2 Pull out oil dipstick.



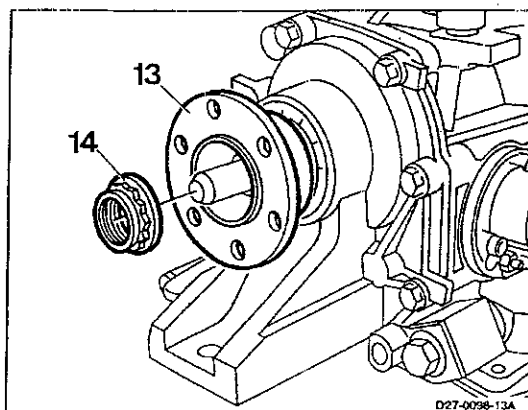
- 3 Unscrew drain plug (35) with sealing ring (36) and drain gear oil.



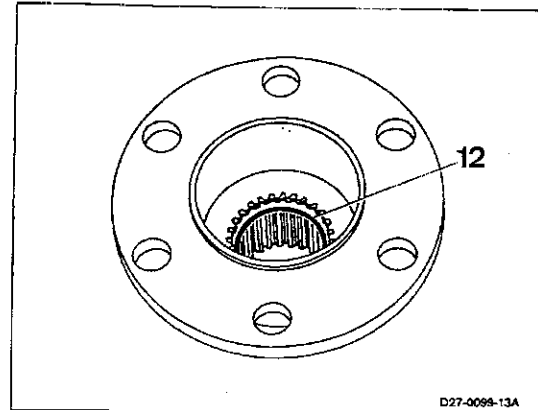
- 4 Mark installation position of propeller shaft, detach and tie up to the side
- 5 Unscrew bolts on transmission mount.



- 6 Unscrew twelve-point collar nut (14) and remove flange (13)

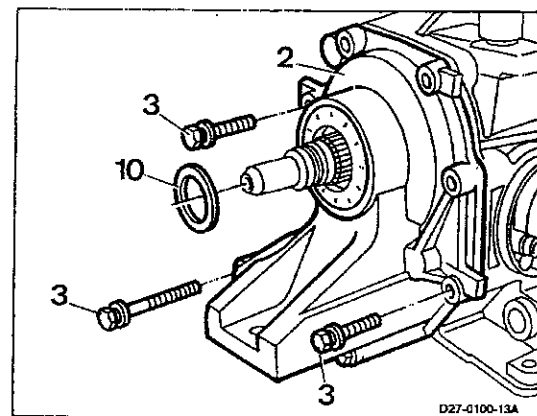


- 7 Remove O-ring (12) from flange.



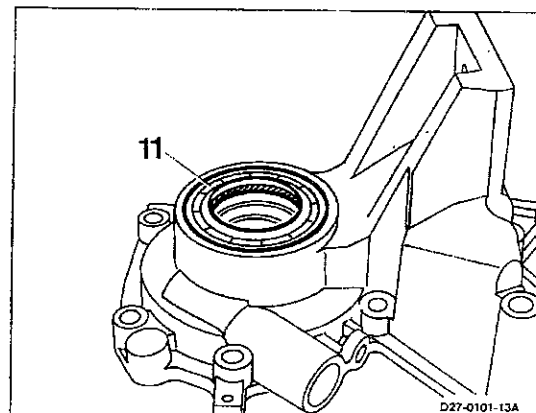
- 8 Remove washer (10).

- 9 Unscrew hexagon head bolts (3) and remove rear cover (2).

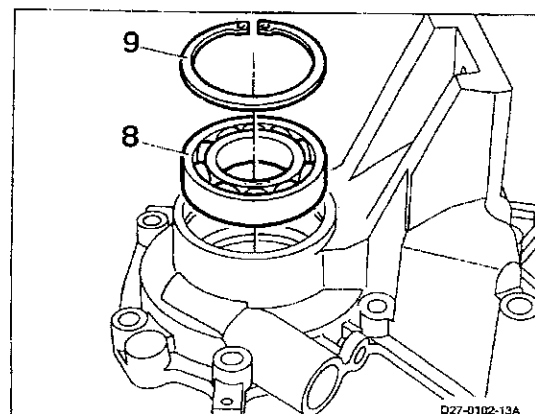


Disassembly

- 1 Remove radial shaft seal (11).

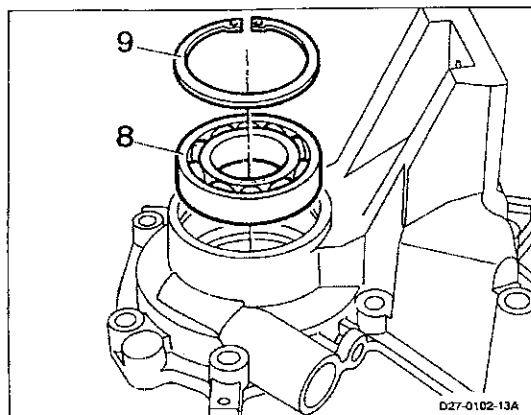


- 2 Remove locking ring (9) and ball bearing (8).



Assembly

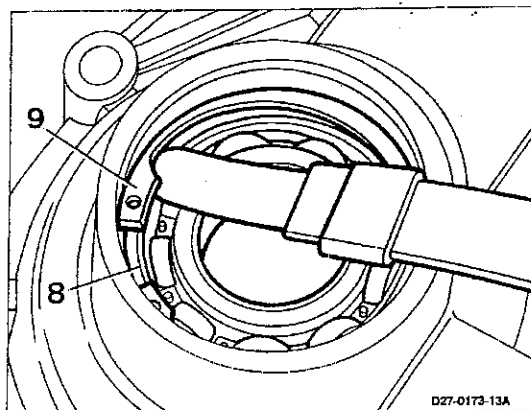
- 1 Install ball bearing (8) using a suitable drift.
- 2 Install locking ring (9).



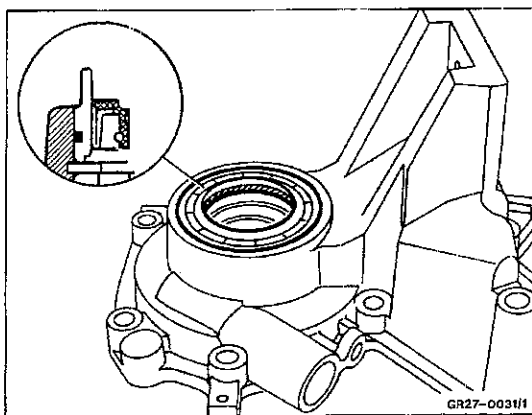
- 3 Measure clearance between locking ring (9) and ball bearing (8) with feeler gauge.

Note: If the locking ring cannot be inserted, use a thinner locking ring.

There is to be no clearance between locking ring (9) and cylinder roller bearing (8). Make up for any clearance using a thicker locking ring. Locking rings are available in the following thickness: 2,0; 2,1; 2,2 mm.

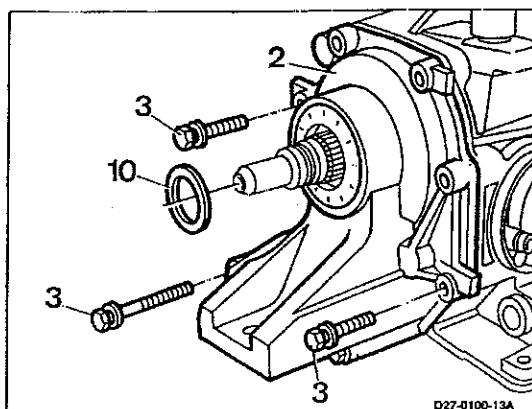


- 4 Drive in new radial shaft seal to be flush using a suitable drift.

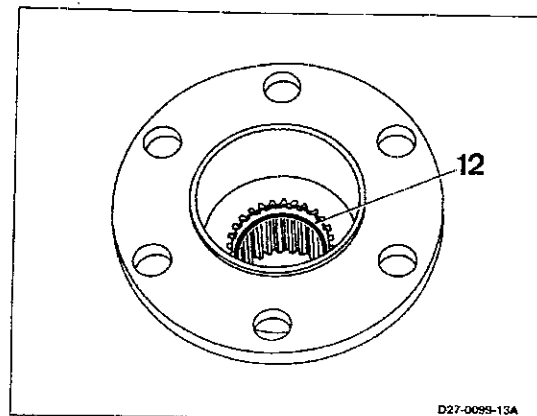


Installation

- 1 Mount rear cover (2) with new gasket, screw in hexagon bolts (3) and tighten to 13 Nm.
- 2 Insert washer (10).



- 3 Insert new O-ring (12) in flange.

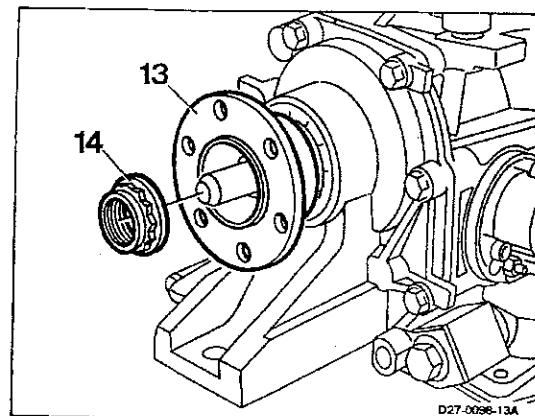


- 4 Slide on flange (13).

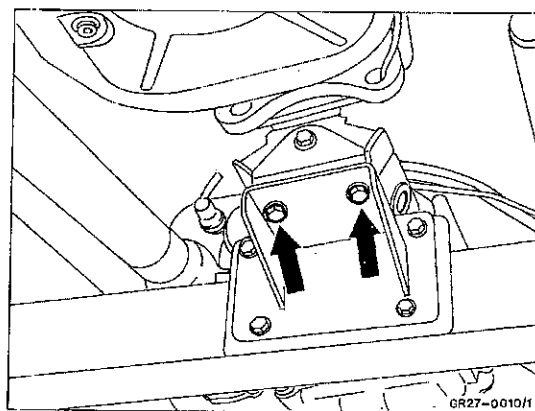
- 5 Screw on twelve-point collar nut (14) and tighten to 120 Nm.

Check concentricity of flange, refer to 4.10/1.

Note: Caulk nut to base of groove



- 6 Attach transmission bearing.



- 7 Mount universal-joint drive shaft and tighten to 35 Nm.



000 589 10 99 16
001 589 66 21 00

Note: From transmission no. 3 684 000 (installation of homokinetic propeller shaft) the tightening torque is 50 to 60 Nm.

