

Service Manual

Front Tandem Axle

Limited Slip

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This documentation is not subject to revision. We reserve the right to make modifications without prior notice.

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Introduction

Axles, transmissions, wheel gears and non drive wheels from Kessler & Co. GmbH & Co.KG (hereinafter referred to as KESSLER) are designed and manufactured in accordance with the state of the art and the recognised technical safety regulations.

This documentation describes the state of the art at the time the documentation was created. Although the documentation was created with great care KESSLER accepts no liability for any errors with respect to the depiction and description.

This documentation is not subject to revision service. We reserve the right to make modifications without prior notice.

Due to continuous developments and technical improvements of our products, the depictions in the following work steps may deviate or differ from the actual product / component. Drawings, graphics, pictures and photos are generally not true-to-scale.

This manual was developed for technicians who have been trained by KESSLER for the repair and servicing of KESSLER axles, transmissions, wheel gears and non drive wheels.

The manual must be stored where it is available to the technicians at all times.

The company will not be liable for damages and consequential costs resulting from improperly executed work by third parties. This also applies if spare parts other than those specified by KESSLER are used.

KESSLER offers customer service tools that make working on axles, transmissions, wheel gears and non drive wheels easier and safer.

General information

Axles, transmissions, wheel gears and non drive wheels from KESSLER may be used only in technically flawless condition and as specified, in a safety- and hazard-conscious manner and in compliance with the manual. Defects, especially those that could impair safety, must be remedied immediately. It is likewise prohibited to use defective or improperly serviced, repaired or modified axles, transmissions and non drive wheels.

In addition to and having priority over the warning and safety information in this manual, the applicable national safety and environmental regulations also apply.

Maintenance, repairs or modifications may be performed only by trained specialists.
The manual must be read prior to starting maintenance, repairs or modifications.
In case of ambiguities and uncertainty, always consult KESSLER.

When performing maintenance and repairs, comply with the safety regulations and the statutory requirements for preventing injuries and damage to the product. Persons who perform these tasks are obligated to become familiar with and comply with these regulations. These persons are responsible for the occupational safety.

After conducting maintenance and repairs, the product must be inspected to ensure that it is functioning properly.

In case of major repairs and overhauls it is recommended to send the entire components (axle, gear, wheel gear and non drive wheel) to KESSLER.

All maintenance instructions in the KESSLER manual must be complied with.

Assembly and disassembly must be carried out in a clean work area.



Use special tools from KESSLER for the work.



Before reinstalling used parts, they must be inspected for damage, undamaged contact surfaces and wear. It is especially important to ensure that no chips or other foreign objects remain in the axles, transmissions, wheel gears and non drive wheels.



To remove the components (axle, gear, wheel gear and non drive wheel) from the vehicle, read the instructions of the vehicle manufacturer. The following descriptions assume that the component has been removed and mounted on a mounting device for further processing.


Safety

Explanation of the warning information and symbols appearing in the Service Manual

 DANGER	
	<p>Highest danger level</p> <p>There is immediate danger of death or severe injury in case of failure to comply with this safety notice.</p> <ul style="list-style-type: none">➤ this arrow indicates the absolutely necessary measures for preventing the specific danger

 WARNING	
	<p>Second highest danger level</p> <p>There is possible danger of death or severe injury in case of failure to comply with this safety notice.</p> <ul style="list-style-type: none">➤ this arrow indicates the absolutely necessary measures for preventing the specific danger

 CAUTION	
	<p>Third highest danger level</p> <p>There is danger of minor injury or property damage in case of failure to comply with this safety notice.</p> <ul style="list-style-type: none">➤ this arrow indicates the absolutely necessary measures for preventing the specific danger

NOTICE	
	<p>Failure to observe this will result in dangers to the machine and its functions.</p>







Information



Offers additional information to facilitate working.



Special types of danger

 DANGER	
	When working on brakes, make sure that releasing the braking force cannot result in unintentional movement of the machine.

 DANGER	
	When working on assemblies with spring actuator elements, such as: brakes and brake cylinders, whether service brake or parking brake. The assemblies are under spring tension. Improper opening can cause parts to suddenly be released and fly off. <ul style="list-style-type: none">➤ In such cases, always comply with the safety, repair and maintenance instructions of the suppliers.

 DANGER	
	Special care is necessary when working on wet multiple disk brakes. They are under high spring tension. Improper installation and/or removal of the brake can cause parts to suddenly be released and fly off. <ul style="list-style-type: none">➤ Do not pre-tension and release the tension on the springs by means of the brake housing screw connections!➤ Open the screw connection of this brake only using a suitable press or mounting device➤ Preferably, installation/removal should be carried out by KESSLER

 DANGER	
	Never remain directly in front of the wheel rim during deflation or inflation. The pressure inside the tyre could cause parts to suddenly be released and fly off.

 DANGER	
	When removing and mounting wheels on vehicles with clamped rims there is a danger that the tyre pressure can cause damaged parts of the rim to become released explosively when removing the clamped rim, which can cause severe or fatal injuries to the mechanic. <ul style="list-style-type: none">➤ Completely deflate the tyre before performing any task➤ Never remain directly in front of the wheel rim during deflation or inflation of tyres

⚠ DANGER

Comply with tightening torque for wheel nuts.

- Retighten wheel nuts after a short operating period!

Basic safety information**⚠ WARNING**

Comply with the safety signs on the axle.

- They must be kept in legible condition at all times.

⚠ WARNING

Only tools and equipment of the highest quality may be used; tools and equipment must be undamaged and electrical equipment must be approved for use in the respective country.

- Never use improvised devices.
- Use only original tools from KESSLER.

⚠ WARNING

Due to the unforeseeable dead weight of the single parts (e.g. wheel hub) or complete axles, transmissions, wheel gears or wheel ends it is possible that they can fall or tip over during assembly work.

- Always use suitable, undamaged and tested cranes and load attachment gear for the respective load.
- Never work or stand under suspended loads
- Secure parts with a lashing strap and/or support
- Wear safety shoes

⚠ WARNING

Movement / rotation of different parts can result in the danger of injury to limbs.

- Never reach between moving parts with your hands

⚠ WARNING

Welding repairs are permitted only in coordination with KESSLER!

⚠ WARNING

Work on an axle, a transmission, a wheel gear and a wheel end is allowed only if the temperature of the respective component permits.

- Make sure that the oil has cooled before draining it
- Make sure that rotating parts have cooled before starting to remove them
- Wear fireproof gloves

⚠ CAUTION

During all machining work on metal parts, during which there is a danger of splinters (abrasive cutting, deburring, cleaning with compressed air, etc.), flying metal parts can cause eye injuries.

- Wear protective goggles

⚠ CAUTION

It is prohibited to wear loose clothing and long open hair when working on axles, transmissions, wheel gears and wheel ends! Oils and greases can cause allergic skin reactions.

- Wear suitable protective clothing

NOTICE

Always observe the technical data (brake connections, tightening torques of screws and wheel locking nuts, etc.). Compliance with these specifications is very important for the safety of other people.

- For information on connections: see installation drawing
- For information on tightening torques: see "Important Information"
- For information on the drive assembly: see "Drive assembly"
- For information on the hub assembly: see "Hub assembly"
- For information on the planetary gear drive: see "Planetary gear drive"
- For information on the brakes: see "Brakes"

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1	Important remarks
2	Lubrication intervals and maintenance instructions
3	General instructions for correct assembly and disassembly Service tools
4	Assembly drive assembly
5	Assembly hub assembly
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7	Assembly service brake
8	Assembly parking brake

Important remarks

Checking of screw connections, safety devices and corrosion

For safety reasons, the vehicle operator must check and service all important screw connections and safety devices at regular intervals.

- Wheel nuts
- Nuts of axle mounting bolts
- Tightening screws on housing joints and steering components will break the Loctite bond, which means the screws have to be reinstalled!
Secure screw connections and joints in accordance with specifications; in case of doubt, contact Kessler & Co. GmbH & Co.KG.
- Corrosion and cracks on support components (e.g. the axle spindle) are not permissible for reasons of operational safety and leaks.
Supporting components with cracks must be replaced!
- Cracks on steering components are not permissible for reasons of operational safety.
Steering components with cracks must be replaced!

Check of brakes

- Inspect brake lining and brake drum / brake disc regularly as well as wear of brake system parts.
- Inspect the free movement of brake system rods.
- In case of signs of excessive heating, consult a brake specialist or the manufacturer.

Service instructions

- Assembly and disassembly may be carried out only by trained specialists.
- Repair welding is permissible only after consulting Kessler & Co. GmbH & Co.KG!
- To remove the axle from the vehicle, read the instructions in the vehicle manufacture's manuals. The following descriptions assume that the axle has been removed and mounted on a jig for further processing.
- Always comply with the safety regulations for your country. There is no guarantee that they correspond to the instructions in this manual.

Instructions for ordering spare parts

Warranty

Kessler & Co. GmbH & Co.KG provides a warranty only for the original delivered replacement parts. Please be aware that the use of other than original replacement parts can have a negative effect on the design properties of the axle, therefore making it unsafe.

Kessler & Co. GmbH & Co.KG will not be liable for any damages resulting from the use of other than original replacement parts and accessories. Please be aware that special production and delivery specifications exist for proprietary or third-party parts and that our replacement parts comply with the most recent standards as prescribed by law.

Ordering

When ordering original Kessler replacement parts, please provide the following information:

1. Part number (no. on the installation drawing) → see identification plate
2. Serial → see identification plate
3. Vehicle manufacturer
4. Name of the spare part
5. Spare part number (drawing or DIN no.)
6. Quantity
7. Mode of dispatch

Identification plate

- The position of the identification plate on the axle is mostly next to the drive assembly on the same side as the oil fill plug.
- Close to the identification plate, you will also find the axle serial number of the axle stamped into the axle housing.



Necessary to contact Kessler & Co. GmbH & Co.KG.

- In case of questions, contact Kessler & Co. GmbH & Co.KG.
- In case of major repairs or overhaul, it is advisable to send the entire axle to Kessler & Co. GmbH & Co.KG.

General lubrication instructions

Oil change

- see page 2.2

Preservation of Kessler axles for an extended storage period

- Replace the breather with a screw plug with a sealant in order to avoid water intrusion and oil leakage.
- Fill axles completely up with oil, the same applies to wet disc brakes.
- Protect machined surfaces (for example: rim surface, steering cylinder, brake disc,) with additional anticorrosive.

Before putting the axle into operation



- Drain storage oil. Fill the axle with suitable oil (see service manual Kessler & Co. GmbH & Co.KG) to the required oil level.
- Check sealing contact surfaces for corrosion. Check the seals immediately after start-up for leakage and renew them if leaking.
- Completely remove the anticorrosive machined surfaces (for example: rim surface, steering cylinder, brake disk,).
The rim face must be cleaned from rust or grease in order to secure a correct friction tight with the rim and to prevent loosening of the rim.
Possible surface corrosion on the brake contact surface of the brake disks is a normal und harmless phenomenon. Surface corrosion on the brake disks will be removed automatically by the first brake operations during vehicle commissioning.
- Check axle structure for corrosion, especially after several years of storage.

Oil change

During changing the oil, always follow the stated measures:

- Place vehicle in horizontal position so that complete draining of oil is possible and clean oil can be filled to the correct level.
- Make sure that oil has cooled down before draining it.
- Always replace gaskets of the screw plugs with new gaskets. The gaskets are mostly copper rings.
- Pay attention to the specific notes.
- The precise position of the lube point can deviate from the illustration. The relevant lube point can be found on the KESSLER product on hand.
- Pay attention to the given activity sequence.

Oil drain

 CAUTION	
	Hot oil Burn hazard ➤ Make sure that oil has cooled down before draining it.

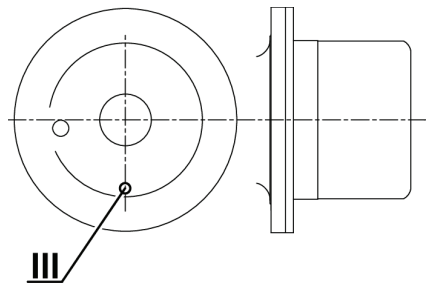


The axle has a total oil space.
Oil drain has to take place at the complete axle.



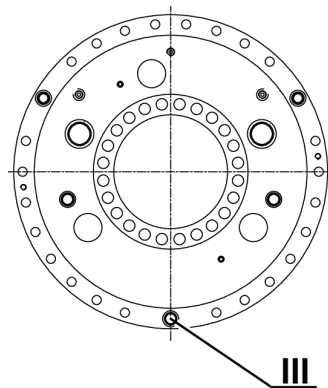
Wet multiple disk brake
Drain the extra oil.

III = oil drain point



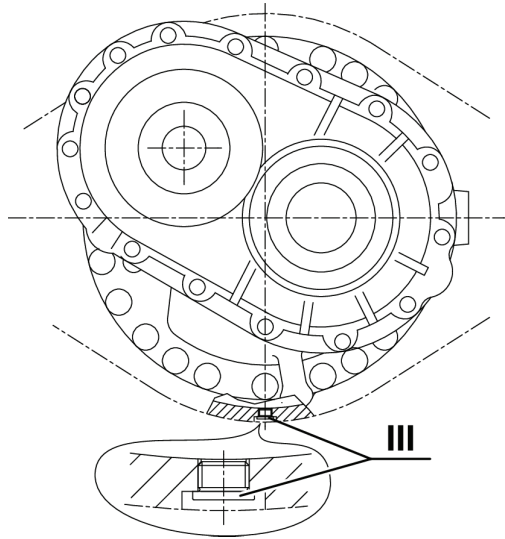
Oil drain, hub assembly:

1. Clean drainage point and oil drain plug.
2. Rotate the hub assembly until the oil drain plug is at the bottom position (6 o'clock position).
3. Open the oil drain plug and allow oil to drain.
 - Collect the oil in a suitable container.
 - Dispose of the oil in an environmentally friendly manner.
4. Clean borehole and oil drain plug.
5. Screw oil drain plug back in.
 - Tightening torque: [see " Tightening torque for screw plugs"](#)



Oil drain, wet multiple disk brake:

1. Clean drainage point and oil drain plug.
2. Open the oil drain plug and allow oil to drain.
 - Collect the oil in a suitable container.
 - Dispose of the oil in an environmentally friendly manner.
3. Clean borehole and oil drain plug.
4. Screw oil drain plug back in.
 - Tightening torque: [see " Tightening torque for screw plugs"](#)



Oil drain, differential and carrier assembly/axle housing:

1. Clean drainage point and oil drain plug.
2. Open the oil drain plug and allow oil to drain.
 - Collect the oil in a suitable container.
 - Dispose of the oil in an environmentally friendly manner.
3. Clean borehole and oil drain plug.
4. Screw oil drain plug back in.
 - Tightening torque: [see " Tightening torque for screw plugs"](#)

Oil filling and filling level



The axle has a total oil space.

All oil drain plugs have to be closed before filling with oil.


The whole axle is filled with oil from the hub assembly and differential and carrier assembly / axle housing together.

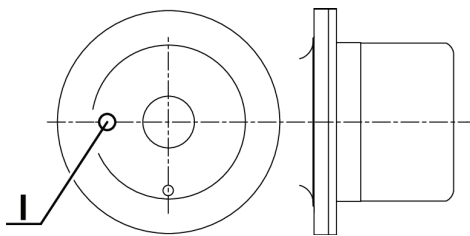
The oil level for the whole axle is specified at the component (differential and carrier assembly / axle housing).

The oil level of the whole axle needs to be checked at the differential and carrier assembly / axle housing.

I = oil filling point

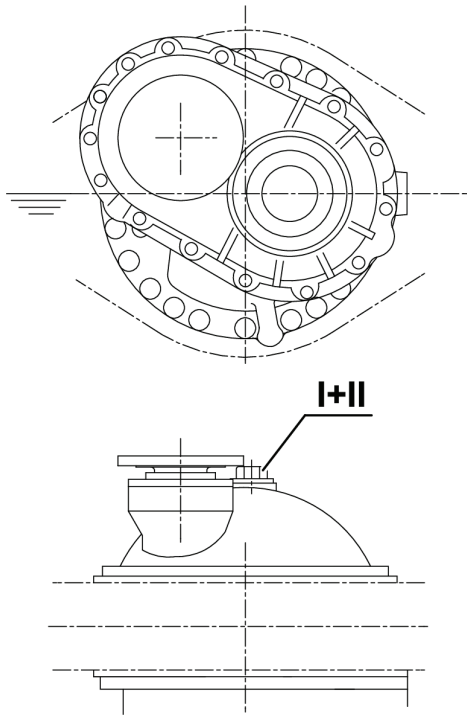
II = oil level inspection point

 = oil level



Oil filling and oil level on hub assembly:

1. Clean filling point and oil filling plug.
2. Turn both hub assemblies into position.
 - The oil drain plug has to be down.
3. Open the oil filling plug.
4. Fill both hub assemblies with clean oil until the oil level reaches the filling bore.
 - Oil in accordance with the specified lubricants. [see "Lubricants and lubrication intervals"](#)
5. After a few minutes, check the oil level again at the oil level inspection plug for differential and carrier assembly / axle housing.
 - If necessary, refill oil at both hub assemblies.
6. Clean borehole and oil filling plug.
7. Screw oil filling plug back in.
 - Tightening torque: [see "Tightening torque for screw plugs"](#)



Oil filling and oil level on differential and carrier assembly/axle housing:

1. Clean filling point and oil filling plug.
2. Open oil filling plug.
3. Fill axle and differential and carrier assembly with clean oil until the oil level reaches the filling bore (= inspection bore).
 - Overflow check
 - Oil in accordance with the specified lubricants. [See "Lubricants and lubrication intervals"](#)
4. After a few minutes, check the oil level again at the filling bores.
 - Keep filling the axle until the oil level remains constant.
5. Clean borehole and oil filling plug.
6. Screw oil filling plug back in.
 - Tightening torque: [see "Tightening torque for screw plugs"](#)





Recheck the oil level of the KESSLER product after driving the first time.

Lubricants intervals and lubricants

Lube point	Remarks	before startup	Lubrication point h = hours of operation The value that is reached first is always valid.		
			after 100 h 1000 km	every 1000 h 10000 km	at least 1x per year
Lubricant - Hypoid gear oil... - specification see page 2.3.1 – recommended Hypoid gear oil Maybe this addition is needed: Lubricant- Additive for limited slip differential... - Spezifikation see page 2.3.1 – additive for versions with limited slip differential					
Differential and carrier assembly Wheel hub - planetary gears Wheel bearing oil-lubricated	Oil change monthly oil level check by overflow measurement	check the oil filling	+	+	+
Lubricant - Wet multiple disk brake - specification see chapter 7					
Wet multiple disk brake	with external cooling Oil change	check oil filling	depends on tank volume / cooling system / application		

Operating Fluids

 CAUTION	
	<p>When filling and working with operating fluids (oil, grease, coolant, ..), skin and eye contact with the operating fluid can occur.</p> <p>Operating fluids can trigger allergic reactions on skin.</p> <p>➤ Wear protective goggles and protective gloves.</p>

Recommended oil-additive for versions with limited slip differential



On the axles with self locking differentials, a noise is produced if normal oils are used. In case of abnormal noises and in case of a jerky roll off of the tyres, use gear oil EP with additives of the "Limited Slip" type conforming to **specification M 2C - 104 A**.

Oils

Recommendable hypoid gear oils

Hypoid gear oils which meet the following minimum requirements must be used as operating lubricants:

API GL-5 and API MT-1

or

SAE J2360 and API MT-1

The viscosity (SAE class) of the hypoid gear oils must be selected in each case on the basis of the given ambient temperature during use according to the following table.

Before using lubricants, we recommend that you ensure compliance of the oil qualification with the above specifications by checking product information or confirmation from your lubricant manufacturer.

Lubricant - Hypoid gear oil	
Ambient temperature when Kessler product is used	Viscosity
	Lubricant minimum requirement L Hypoid-gear oil according to API GL-5 and API MT-1 or Hypoid-gear oil according to SAE J2360 and API MT-1
from -10°C to +30°C	Single-grade oils SAE 90 or Multigrade oils SAE 75W-90 / SAE 80W-90 / SAE 85W-90
permanently less than -10°C	Multigrade oils SAE 75W-85 / SAE 75W-90
permanently over +30°C	Single-grade oils SAE 140 or Multigrade oils SAE 75W-140 / SAE 80W-140 / SAE 85W-140

Grades designated by lubricant manufacturers:

- AVIA Hypoid 90 EP
- AVIA Synthogear FE 80W-90
- AVIA Hypoid 85W-140 EP
- SHELL Spirax S3 AM 80W-90
- SHELL Spirax S3 AD 80W-90
- SHELL Spirax S4 AX 80W-90
- SHELL Spirax S5 ATE 75W-90

Under no circumstances should "normal" gear oils (such as industrial gear oils) be used!

General maintenance instructions

Inspection and maintenance points	Remarks	Maintenance intervals 1.)				
		after 10Bh 500Km	after 100Bh 1000Km	every 500Bh 5000Km	every 1000Bh 10000Km	at least 1x per year
Wheel bearing	Check and readjust		⊕			⊕
Wheel nuts	Check and retighten with a torque wrench (following a tire change, after about 50km and about 200km)	⊕	⊕	⊕		
Castle nuts/track rod Screws/drive flange Nuts/axle mounting bolts	Inspection and check for firm fit, if necessary retighten	⊕	⊕	⊕		⊕
Brakes (see also chapter 7)	Check lining wear, if necessary readjust, control the proper operation of the brake shafts	⊕	monthly			
Wet disc brake	Check the lining wear					⊕
Wet disc brake - spring load design	Check the lining wear				⊕	
Lever screwing	Inspection and check for firm fit, if necessary retighten, the screw have to be remounted with Loctite, according to page 5.1.4		⊕			⊕
Screwed connections	Check			⊕		
Ring gear support bolt on drive assembly	Readjust					⊕
Gaskets	Check sealing points for leaks	monthly				
Differential lock	Check function of the indicator light in the driver's cap Check function and automatic retraction into off position	monthly				

(Bh = Hours of operation)

1.) The value that is reached first is always valid.

General instructions for correct assembly and disassembly

General instructions for disassembly

- The disassembly occurs made inverted to the respective assembly instruction.
- Drain oil before removing, check for presence of metal particles.
- Mark the parts to each other before dismantle.
- Never use a hard object to separate tightly fitted assemblies. To remove bearings, drive flange and similar parts, use adequate pull-off tools.
- It is recommended that the special tools according 3.6 be used for disassembly.
- Before disassembly, the destruction of bearings and other components must check, if it is necessary to destroy it.
- Systematically replace used seals, O-rings and if needed bearings on disassembly.
- Replace or clean corroded parts.
- Do not place parts on dirty surface.

General instructions for assembly

- Clean parts before reassembly.
- The cages of bearings rotating in oil must coat with oil at reassembly.
- During mounting of radial seal rings, pay attention that there is sufficient overlap to the housing bores. Pay attention for a plain alignment of the radial seal ring. The seal lips may never be encountered Loctite!
- Oil seal rings and particularly the anti-dust lip seals must fill with grease.
- The universal joint shafts and the axle shafts must forcibly mounted (they must slide).
- Seal ring treads on flanges, shafts and so on, must preserve with Castrol Rustilo DWX 32 before mounting.
- Refill oil after assembly!

Auxiliary materials: Adhesives, sealing compounds, grease and assembly pastes



If a screw is used covering with a securing (for example: Precote covering), more Loctite must not apply.

Use of auxiliary materials

Type	Application	Product	Type	Color
Adhesive	Screw securing light	LOCTITE	243	Blue
Adhesive	Screw securing medium	LOCTITE	262	Red
Adhesive	Screw securing very tight	LOCTITE	270	Green
Adhesive	Friction increase in joint faces	LOCTITE	270	Green
Adhesive	Surface sealing	LOCTITE	510	Orange
Adhesive	Special sealing	LOCTITE	572	White
Adhesive	Sealing with wide gap	LOCTITE	638	Light green
Adhesive	Surface sealing	LOCTITE	5926 or 209 125	Blue
Sealing compound	Elastic sealing	Dirko	Grey	Gray
Assembly paste with MoS ₂	Prevents stick-slip	LIQUI MOLY	LM 48	Gray
Multi-purpose grease	Adhesive lubricant	FUCHS	RENOLIT AS	Yellow transparent
Multi-purpose grease lithium soap-based	Bearing lubrication - worked penetration in accordance with NLGI 2	FUCHS	RENOLIT MP150	Yellow transparent
Special grease	Gear-shifting	Klüber	Mircolube GL261	yellow, almost transparent

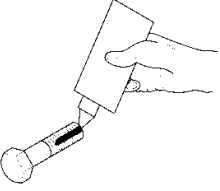
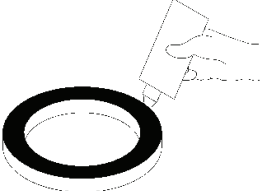
General instructions for correct assembly and disassembly

Section **3**
3.2.1

Handling auxiliary materials

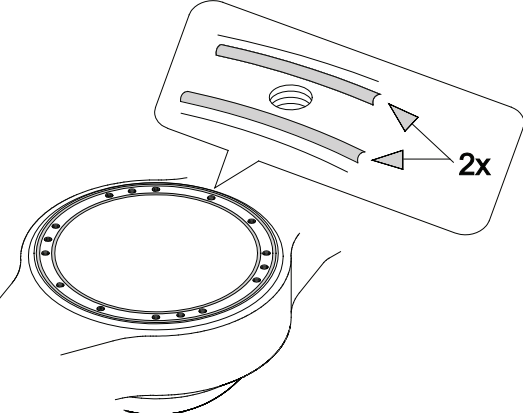
Handling of Loctite 243 / 262 / 270 / 510 / 572 / 638

- The surfaces or screws and threaded boreholes to be cemented need to be free of paint, grease, and oil (washed).
- The Loctite adhesives applied cure under the following conditions:
 - Absence of air
 - Metal contact
 - Warmth
- Only a short time may pass between pre-assembly and controlled tightening (5 - 10 minutes).
- Parts prepared with Loctite intended for cementing can be exposed to air for up to 1 hour.
Exception: Parts made of nonferrous metal may rest for no more than one minute.
- Allow loaded connections to cure for at least 24 hours.

Loctite amount:		Loctite amount:	
	For screws: 1 bead		On contact surface: ensure sufficient coating

Handling of Loctite 5926

- The surfaces or screws and threaded boreholes to be cemented need to be free of paint, grease, and oil (washed).
- The Loctite adhesives applied cure under the following conditions:
 - moisture curing begins immediately after the product is exposed to the atmosphere
- Parts to be assembled should be mated within a few minutes after the product is dispensed

Loctite amount:	
	on sealing surface 2 beads

Application of Loctite and operating supplies of hub assembly

Safety blocked parts	Joint	Loctite	Operating supplies
Spacer ring	Contact surface	572	-
Axle spindle	Screws	262	-
Axle spindle	Contact surface	270	-
Grommet	in planetary housing	270	-
Disc	in axle spindle	270	-
Adjusting screw with nut	in planetary housing	270	-
Support	Screw	262	-
Ring gear retainer	Screws	270	-
Pol wheel	Contact surface	638	-
Steering lever Track rod lever	Screws	262	-
Steering lever Track rod lever	Contact surface	270	-
Wheel hub cover	Thread	572	-
Radial seal rings Rubber casing	Contact surface	572	-
Radial seal rings Steel casing	Contact surface	270	-
Wheel safety nut → see chapter 5 → Adjustment of wheel bearings			

Application of Loctite and operating supplies of differential and carrier assembly

Safety blocked parts	Joint	Loctite	Operating supplies
Drive flange	Nut surface	-	Epple 33 alternative Dirko grey
Diff-housing	Screws	262	-
Shifter cylinder (Diff-lock)	Contact surface	572	-
Diff.carrier (Through drive)	Contact surface	510	-
Drop gear housing	Contact surface	510	-
Diff.carrier	Contact surface	-	Epple 33 alternative Loctite 5926 and 209125
Through drive cover	Contact surface	510	-
Differential strap	Screws	262	-
Adjustment nut screw	Screw	270	-
Ring gear	Screws	262	-
Ring gear	Contact surface	270	-
Ring gear support	Cap	270	-
Ring gear support	Thread	-	Epple 33 alternative Dirko grey

Tightening torques

General instructions for tightening torques (Nm)

$\mu = 0,14$

All tightening torques are rated in Nm.

Tolerance of the tightening torques is **$\pm 5\%$**

(assuming a manually operated torque spanner is used)

Tightening torque of metric coarse-pitch thread

Thread	Screw	Nut	Screw	Nut	Screw	Nut
	8.8	8	10.9	10	12.9	12
M 4	3,0		4,4		5,1	
M 5	5,9		8,7		10	
M 6	10		15		18	
M 8	25		36		43	
M 10	49		72		84	
M 12	85		125		145	
M 14	135		200		235	
M 16	210		310		365	
M 18	300		430		500	
M 20	425		610		710	
M 22	580		830		970	
M 24	730		1050		1220	
M 27	1100		1550		1800	
M 30	1450		2100		2450	

Tightening torque of metric fine pitch thread

Thread	Screw	Nut	Screw	Nut	Screw	Nut
	8.8	8	10.9	10	12.9	12
M 8 x 1	27		39		46	
M 10 x 1	55		81		95	
M 10 x 1,25	52		76		90	
M 12 x 1,25	93		135		160	
M 12 x 1,5	89		130		155	
M 14 x 1,5	145		215		255	
M 16 x 1,5	225		330		390	
M 18 x 1,5	340		485		570	
M 20 x 1,5	475		680		790	
M 22 x 1,5	650		920		1050	

Thigtening torque for galvanized bolts and nuts!

Regard reduced tightening torque for galvanized bolts and nuts!

Tightening torque for brake caliper dowel screws (greased !)

M 20 x 1,5	400 + 100
M 27 x 2	900 + 100

Tightening torque of the nut for steering stop

300

Approximate value for the thiqthening torque for screw plug

Thread	Tightening torque (Approximate value)	Tightening torque (Screw plugs with O-Ring)
M14x1,5	ca. 45	45
M16x1,5	ca. 60	-
M22x1,5	ca. 100	100
M24x1,5	ca. 120	-
M30x1,5	ca. 160	-
M36x1,5	ca. 210	
M42x1,5	ca. 260	-
M45x1,5	ca. 280	-
9/16-18 UN (F)	--	34

Units

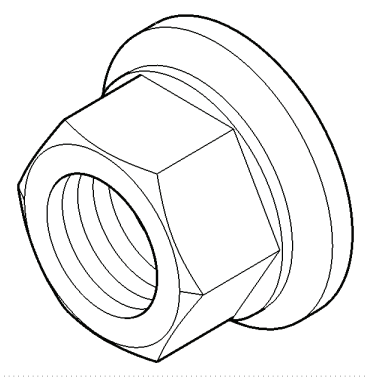
Comparison table for units

25,40 mm	=	1 in (inch)
1 mm	=	0,0394 in (inch)
1 kg (kilogram)	=	2,205 lb (pounds)
9.81.Nm (1 kpm)	=	7,233 lbf x ft (pound force foot)
1,356 Nm (0,138 kpm)	=	1 lbf x ft (pound force foot)
1 bar (1,02kp/cm ²)	=	14,5 psi (pound force per square inch lbf/in ²)
0,070 bar (0,071 kp/cm ²)	=	1 psi (lbf/in ²)
1 Litre	=	0,264 Gallon (Imp.)
4,456 Litre	=	1 Gallon (Imp.)
1 Litre	=	0,220 Gallon (US)
3,785 Litre	=	1 Gallon (US)
1609,344 m	=	1Mile (land mile)
0°C (Celsius)	=	+32°F (Fahrenheit)
1°C (Celsius)	=	+33,8°F (Fahrenheit)
0°C (Celsius)	=	273,15 Kelvin
1°C (Celsius)	=	274,15 Kelvin

Names of the legal units

Term	Symbol	New	Old	Conversion	Comment
Torque	T	Nm (Newton meter)	kpm	1 kpm = 9,81 Nm	T (Nm) = F (N) x r (m)
Moment of force	M	Nm (Newton meter)	kpm	1 kpm = 9,81 Nm	M (Nm) = F (N) x r (m)
Pressure	pü	bar	atü	1,02 atü = 1,02 kp/cm ² = 1 bar = 750 torr	

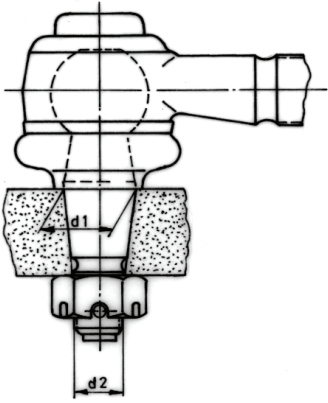
Tightening torque wheel nut with thrust collar



Dimension	Tightening torque	
	Wheel nut with thrust collar – Phosphorous darkened -	Wheel nut with thrust collar – Galvanized -
M20x1,5	470 Nm	--
M22x1,5	650 Nm	--

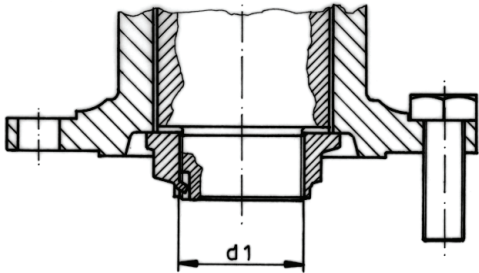
Tightening torques for castle nuts and adjusting nuts

Tightening torques for castle nuts on ball joints for track rods and ram cylinders

	Cone size d1 (mm)	Thread d2 (mm)	Torque (Nm)
	26	M 20 x 1,5	200 - 220
	30	M 24 x 1,5	280 - 300
	32	M 27 x 1,5	290 - 320
	38	M 30 x 1,5	340 - 360
	45	M 39 x 1,5	410 - 430

The tightening torques of the different thread dimensions of the joints are applicable for nuts of quality S6.

Tightening torque of the adjusting nut resp. slotted nut at flanges resp. gearwheels ect.

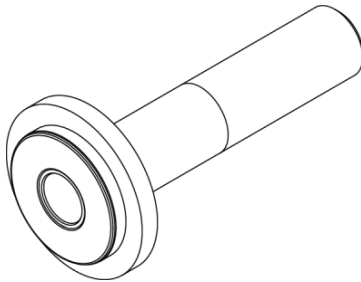
	Thread d1 (mm)	Torque (Nm)
	M 24 x 1,5	360
	M 30 x 1,5	450
	M 36 x 1,5	540
	M 42 x 1,5	850
	M 45 x 1,5	850
	M 48 x 1,5	850
	M 52 x 1,5	950
	M 64 x 1,5	1050 - 1100

1 Customer service tools drive



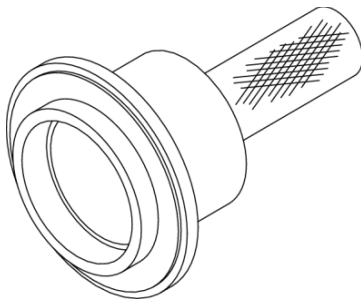
The following tool list is an overview of required service tools for disassembly and assembly. It does not claim to be completely.

Due to the wide variety of KESSLER products, it is not possible to offer tools for all applications. The tools listed here are in stock and can be supplied.



SEAL RING SLEEVE DRIVER

Part Number: 261590



SEAL RING SLEEVE DRIVER

Part Number: 261591

(Seal ring dimension 95x125x12 mm)



SPANNER FOR BEARING ADJUSTMENT RING

Part Number: 261592

(thread M127 / M130 / M132)

1 Customer service tools hub assembly



The following tool list is an overview of required service tools for disassembly and assembly. It does not claim to be completely.

Due to the wide variety of KESSLER products, it is not possible to offer tools for all applications. The tools listed here are in stock and can be supplied.



WRENCH, SPANNER
for wheel bearing adjustment nut

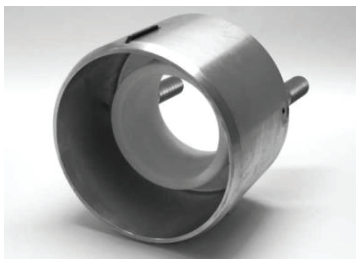
➤ If needed three more bolts can be pressed in.

Part Number: 596633



SEAL RING SLEEVE DRIVER
for seal ring within the wheel hub

Part Number: 261594
(Seal ring dimension 180x210x8.5 mm)



CENTERING TOOL FOR DISKS
Order number: 261595



INSTALLATION TOOL FOR FACE SEAL
Order number: 261596

Adjustment of contact pattern of bevel gear teeth



NOTICE: search for the production numbers of the drive pinion and the ring gear.

It is only possible to achieve an optimal contact pattern, if:

Version 1	Version 2
<p>Production numbers</p> <ul style="list-style-type: none">• on drive pinion (marked on the end face)• on ring gear (marked on the face of the ring gear)	<p><u>No</u> production numbers</p> <ul style="list-style-type: none">• on drive pinion• on ring gear
<p>➤ The production numbers of the drive pinion and ring gear <u>must</u> match – only mount in pairs!</p>	<p>➤ <u>indiscriminate</u> use of drive pinion and ring gear is possible – no pairing necessary!</p>

Checking the contact pattern of the gear teeth



- 1. Coat the teeth of the ring gear with spotting paste and then turn it several times until you can see pressure marks from the drive pinion on the coated teeth.
- 2. Check the contact pattern / pressure marks and compare them with the illustrations in the following table.
- 3. If necessary, make adjustments as shown in the table.

	<p>Optimal contact pattern</p>	
	<p>Contact pattern too high.</p> <p>Reduce drive pinion distance by correcting thickness of the adjustment disk. Adjust the backlash by moving the ring gear out.</p>	
	<p>Contact pattern too low.</p> <p>Increase drive pinion distance by correcting thickness of the adjustment disk. Adjust the backlash by moving the ring gear in.</p>	

Securing of the striking nut



NOTICE: The brim of the striking nut has to be sheared only along the slot flank and the corner has to be bended on the slot ground.

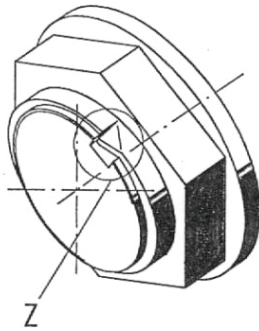


Figure 1

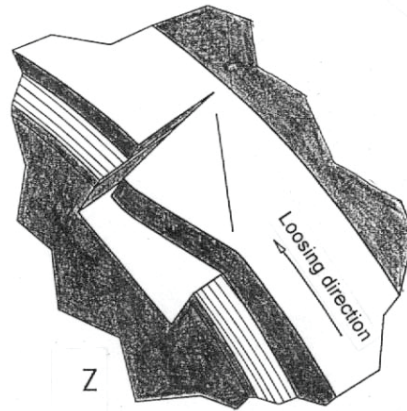


Figure 2

Use of Loctite and other operating supplies

- Striking nut at drive flange
 - In thread: assembly paste with MoS2 (exception: through drive pinion see enumeration 2)
 - Front side contact surface: sealing compound (Epple 33 or equivalent)
- Striking nut at through drive nut
 - On thread: Loctite 262
- Striking nut at gear wheels, bearings and so on
 - On thread: assembly paste with MoS2

Removing of the striking nut



NOTICE: Bend away the nose completely. Otherwise, the thread of the of the drive pinion will be damaged. Screw the nut off.



Figure 3



Figure 4



Figure 5

1. The secured striking nut.

2. Applying an applicable flat chisel in the slot between drive pinion and securing and removing the securing of the striking nut.

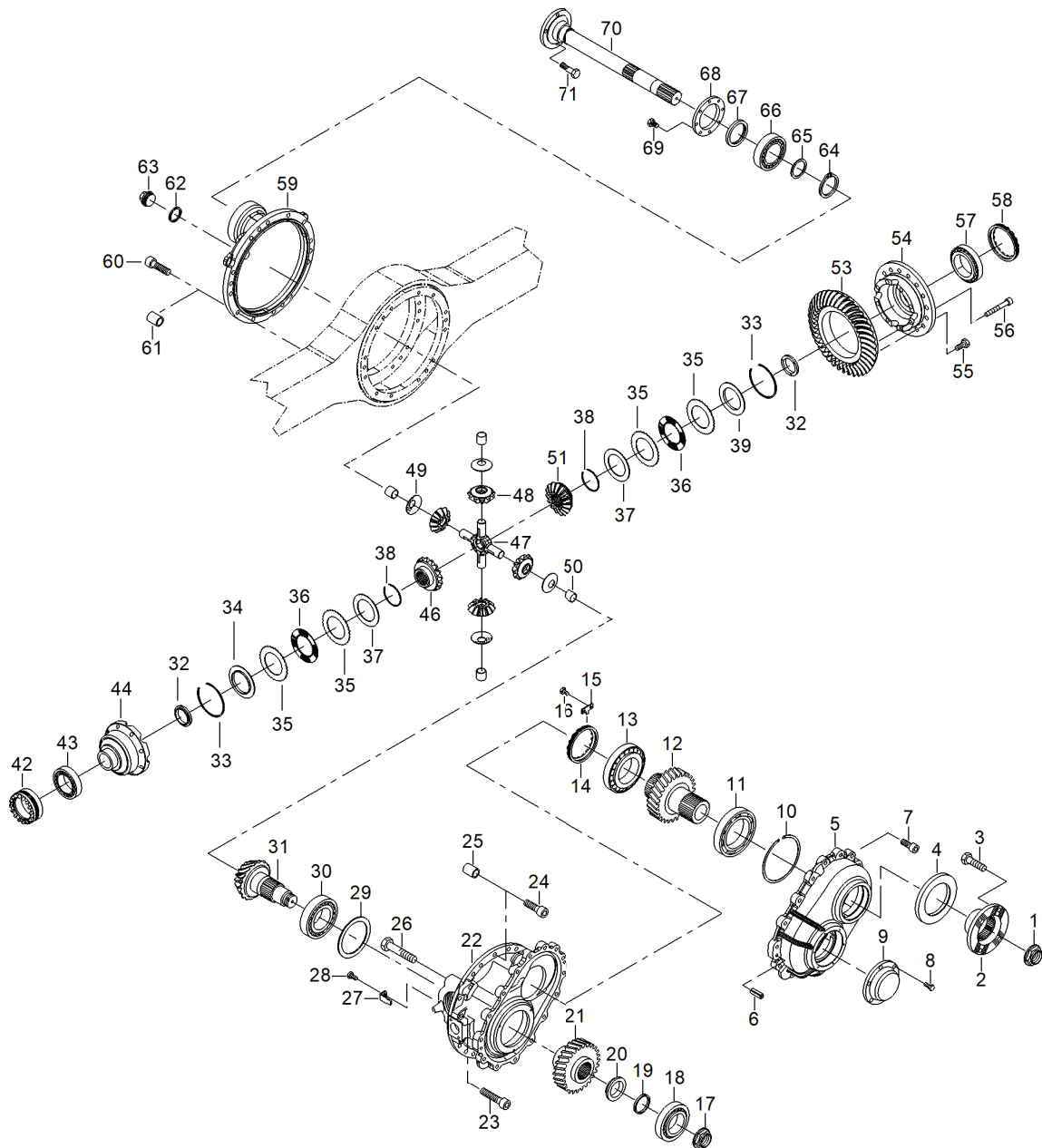
3. The loosened striking nut.



The following explode representation with numbering is only a list of the part names.

Spare parts must be ordered according to the valid spare parts list of the respective Kessler product.

Differential and carrier assembly with drive-through D 71

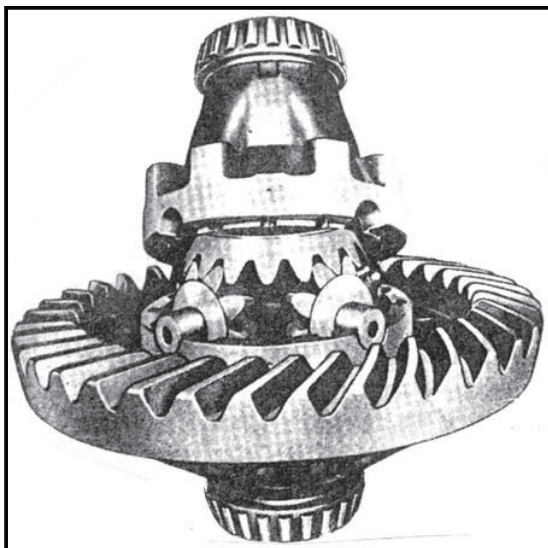
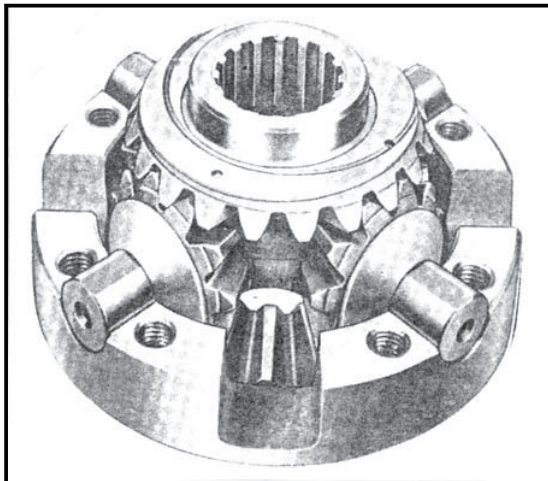
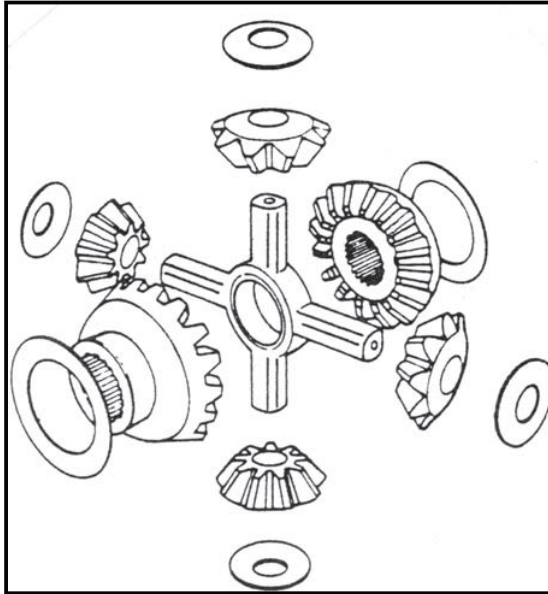


Overview of parts

1. Lock nut	25. Spacer sleeve	49. Disk
2. Drive flange	26. Screw	50. Bushing
3. Screw	27. Lock plate	51. Differential side gear
4. Radial seal ring	28. Screw	52. Disk
5. Drop gear housing	29. Adjustment disk	53. Ring gear
6. Spring-type straight pin	30. Tapered roller bearing	54. Differential housing
7. Screw	31. Drive pinion	55. Screw
8. Screw	32. Disk	56. Screw
9. Cover	33. Circlip	57. Tapered roller bearing
10. Circlip	34. Disk	58. Setting ring
11. Tapered roller bearing	35. Outer disk	59. Housing cover
12. Gear wheel	36. Inner disk	60. Screw
13. Tapered roller bearing	37. Disk	61. Spacer sleeve
14. Setting ring	38. Circlip	62. Sealing ring
15. Lock plate	39. Disk	63. Screw plug
16. Screw	40. --	64. Circlip
17. Lock nut	41. --	65. Disk
18. Tapered roller bearing	42. Setting ring	66. Spherical roller bearing
19. Spacer ring	43. Tapered roller bearing	67. Radial seal ring
20. Ring	44. Differential housing	68. Cover
21. Gear wheel	45. Disk	69. Screw
22. Differential carrier	46. Differential side gear	70. Through drive shaft
23. Screw	47. Differential spider	71. Screw
24. Screw	48. Differential pinion	

The assembly of the drive assembly with drive-through has to be realized in following succession:

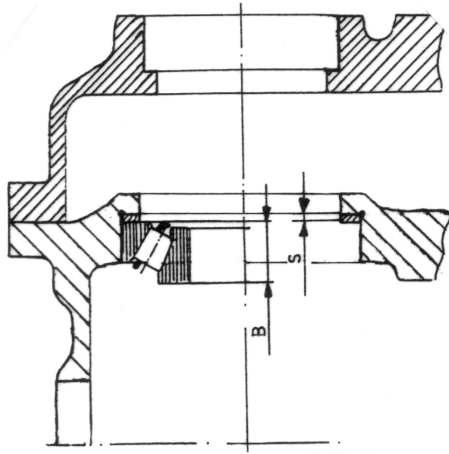
1. Assembly of the differential	⇒	see sheet 4.1.3
2. Adjustment of gear meshing	⇒	see sheet 4.9.2
3. Assembly an bearing adjustment of the drive gear wheel	⇒	see sheet 4.6.2
4. Assembly and bearing adjustment of the drive pinion with side gear wheel	⇒	see sheet 4.6.3
5. Assembly of drive assembly	⇒	see sheet 4.9.5
6. Pre-assembly of the drive-through shaft	⇒	see sheet 4.9.6
7. Assembly of the drive-through with shaft	⇒	see sheet 4.6.4
8. Limited-slip differential	⇒	see sheet 4.6.5



Before assembly all of the bevel gears and the thrust rings should be well oiled.

1. Place one differential side gear with the side gear thrust washer in the differential case.
2. Install the spider with differential gears and differential pinion thrust washers in the differential case.
3. Install the other differential side gear and side gear thrust washer. (At variants with Nospin differential install the Nospin diff. instead of the differential gears)
4. Install the other half of the differential case over the assembly and observe the alignment marks, tighten the differential case bolts. Secure with Loctite 262.
5. Check that all differential pinions can rotate easily.
6. Coat the contact surface of the ring gear with Loctite 270 and install the ring gear on the differential case by tapping lightly on the circumference. Tighten the ring gear bolts. Secure with Loctite 262.
7. Heat the two taper roller bearings to about 100°C and install them by using a sleeve.

Adjustment of drive pinion distance

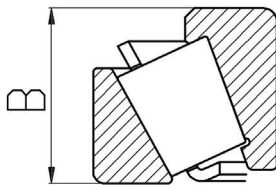


To obtain the proper tooth flank contact, adjust the axial position of the drive pinion with the thickness of the adjustment disc. The necessary thickness of the adjustment disc for first time assembly can be obtained by measurement (see calculation example).

Drive assembly	A 71
theoretical S	3
theoretical B	40

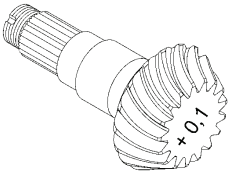
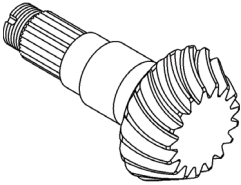
The final thickness of the adjustment disc can be fixed during the checking of gear meshing at the assembled drive assembly (see page „Checking the contact pattern of the gear teeth” – 4.0.1).

B = Measured width of the taper roller bearing.


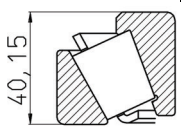
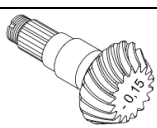

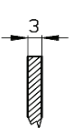
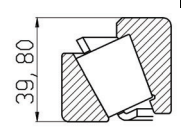
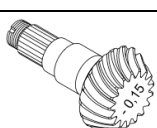
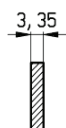

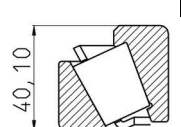
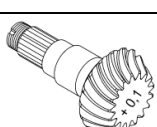
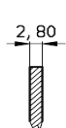


Assembly of differential and carrier assembly A71

Section 4
4.9.2

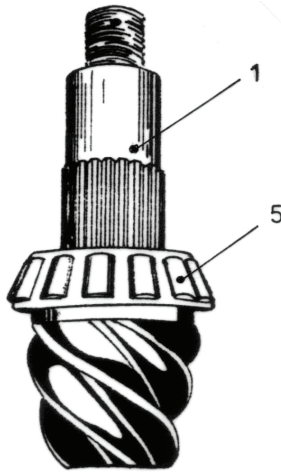
Version 1	Version 2
<p>Adjustment dimension – A</p> <p>Deviating dimension (defined during production) is marked on the locating face of the pinion. It indicates the deviation from the specified dimension.</p> <p>Example: Deviation +0,1</p> 	<p>Adjustment dimension – A</p> <p>Without inscription on the locating face of the pinion, the deviating from the specified dimension is 0.</p> <p>Example: Deviation 0</p> 

Sample calculations (dimensions in mm):

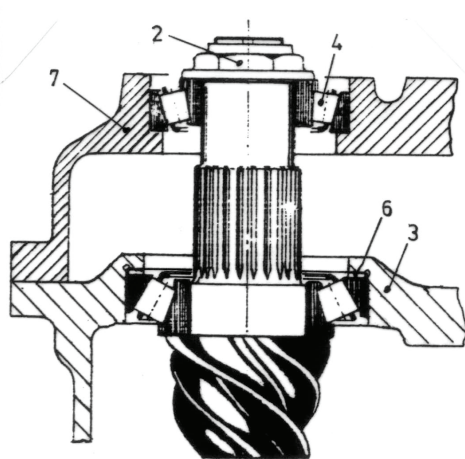
Theor. adjustment disk thickness	Measured bearing width	Tolerance at drive pinion	Calculation of the required adjustment disk thickness	Required adjustment disk thickness
		Version 1 	theor. disk thickness - deviation from bearing + deviation from pinion = required disk thickness	
	deviation from the theoretical dimension +0,15	deviation from the theoretical dimension -0,15	3,0 - 0,15 + 0,15 = 3,0	
		Version 1 	theor. disk thickness + deviation from bearing + deviation from pinion = required disk thickness	
	deviation from the theoretical dimension -0,20	deviation from the theoretical dimension -0,15	3,0 + 0,20 + 0,15 = 3,35	
		Version 1 	theor. disk thickness - deviation from bearing - deviation from pinion = required disk thickness	
	deviation from the theoretical dimension +0,10	deviation from the theoretical dimension +0,10	3,0 - 0,1 - 0,1 = 2,8	

Fit corresponding disc and outer rings of the taper roller bearings.

Assembly drive pinion shaft

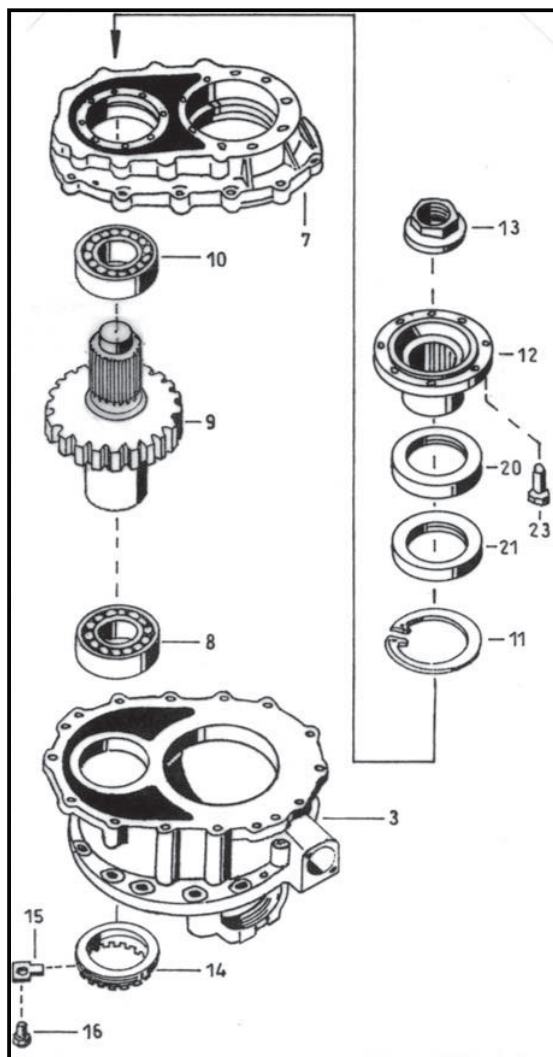


1. Heat the taper roller bearing (5) (drive pinion side) to about 100°C and install it on the drive pinion shaft. (After cooling, drive on for contact).

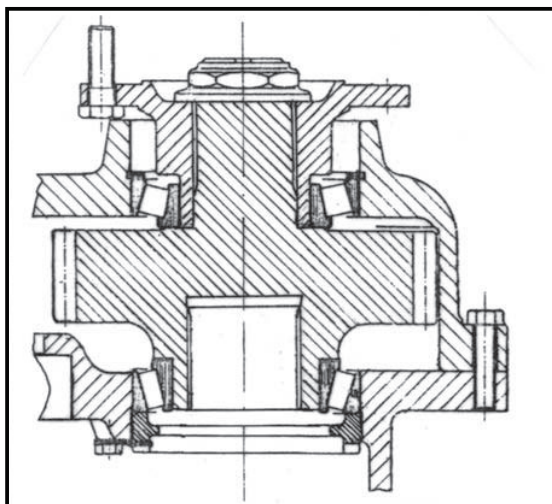


2. Fit the disk (6) into the differential carrier (3).
3. Press the outer ring of the taper roller bearing (5) into the differential carrier (3).
4. Install the drop gear housing (7).
5. Press the taper roller bearing (4) into the drop gear housing (7).
6. Insert the drive pinion shaft (1) with the pulled on taper roller bearing (5).
7. Tighten the safety nut (2) to a small bearing roll resistance.
8. Place the differential with the outer rings of the taper roller bearings on the differential carrier and adjust the teeth side play (see assembly of drive assembly).
If the gear meshing is not correct, modify the thickness S of the adjustment disk.
9. Detach differential, drive pinion and drop gear housing.

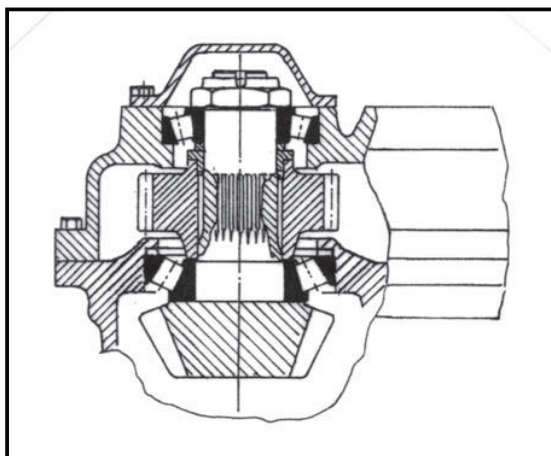
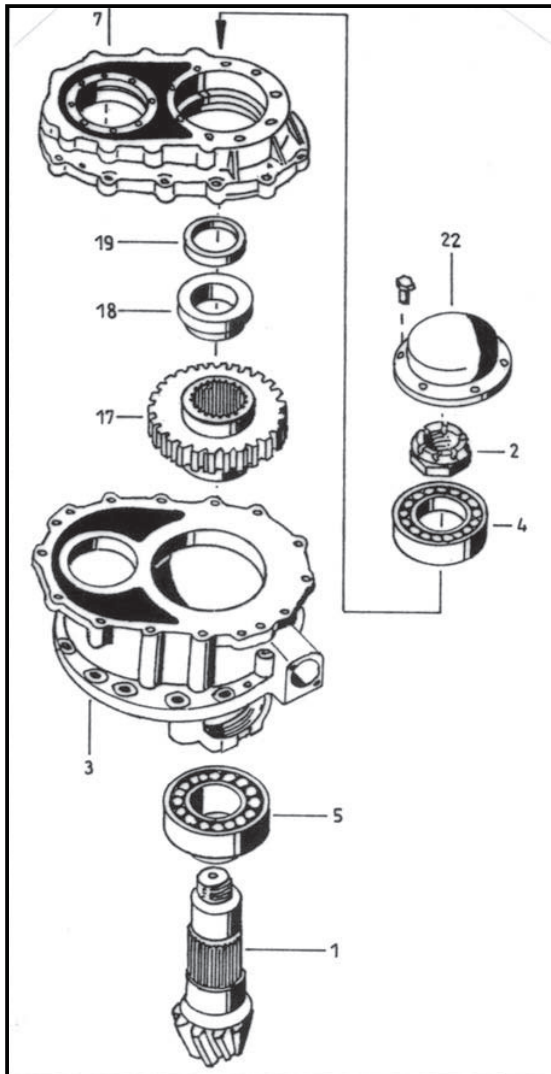
Assembly and bearing adjustment of the drive gear wheel



1. Heat the taper roller bearing (8) to about 100 C and install it onto the drive gear wheel (9).
 2. Install the complete drive gear wheel into the differential carrier (3).
 3. Put on the drop gear housing (7) and bolt it.
 4. Place the taper roller bearing (10) into the drop gear housing and install the circlip (11). Push the drive flange (12) onto the gear wheel resp. into the taper roller bearing and tighten the safety nut (13).
 5. Tighten the thread ring (14) until there is a bearing roll resistance of 1,0 Nm, measure the bearing roll resistance by using a torque wrench. Back off the thread ring 2 teeth.
 6. Bolt the lock plate (15) for the thread ring with screws (16), secure with Loctite 270, if need be bend the lock plate.
- Detach drop gear housing and drive gear wheel.

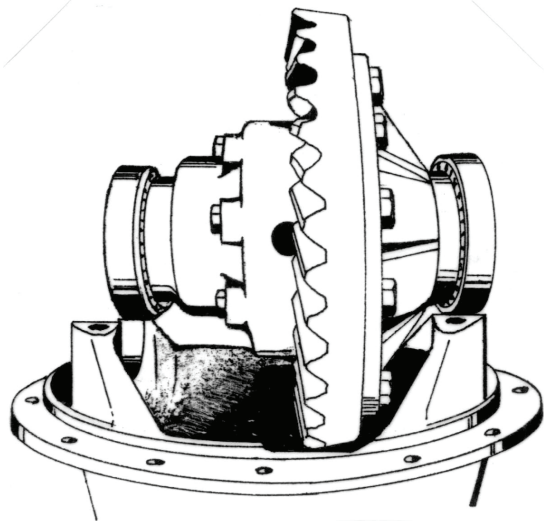


Assembly and bearing adjustment of the drive pinion with side gear wheel



1. Install the drive pinion (1) with taper roller bearing into the differential carrier (3).
2. Push the side gear wheel (17) onto the drive pinion.
3. Install the spacer rings (18 + 19) onto the drive pinion.
4. Put the drop gear housing (7) with mounted outer ring of the taper roller bearing onto the differential carrier (3) and bolt it.
5. Install the outer taper roller bearing (4) onto the drive pinion.
6. Tighten the safety nut (2). Adjust the roll resistance of the taper roller bearings to about 1,5 to 1,8 Nm by modification of the thickness of the spacer ring (19). Measure the roll resistance of the bearings by using a torque wrench.
Attention:
Block the side gear wheel while tightening the safety nut.
7. Detach the drop gear housing. Install the radial seal rings (20 + 21) with Loctite 572 applied into the drop gear housing. Fill the radial seal rings with bearing grease.
8. Install the drive gear wheel (9).
9. Coat the contact surface of the differential carrier with Epple 33 or Loctite 510, put on the drop gear housing and bolt it.
10. Tighten the safety nut. Lock the nut by striking the nut brim into the slot of the drive pinion and Loctite 262 in the thread.
11. Put the cover (22) coated with Epple 33 or Loctite 510 onto the drop gear housing and bolt it. (Install the cover after adjusting of gear meshing).
12. Place the cardan screws (23) into the drive flange. Push on the drive flange and tighten the safety nut. Lock the nut by striking the shoulder into the slot of the drive gear wheel.

Dimension of backlash



Place the differential with the outer rings of the taper roller bearings on the differential carrier which is in a vertical position, with mounted drive pinion.

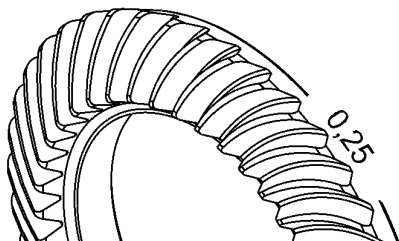
Mount the differential straps and align them with the thread rings.

During this operation be careful of the alignment marks on the differential straps with respect to the differential carrier. (Do not interchange the differential straps.)

Backlash

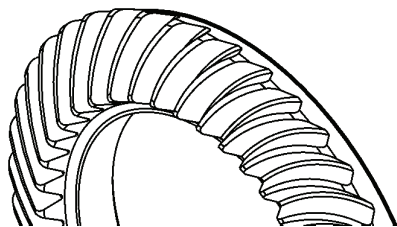
Version 1

The smallest admissible value at the closest place is marked on the circumference of the ring gear.



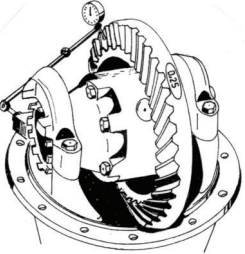
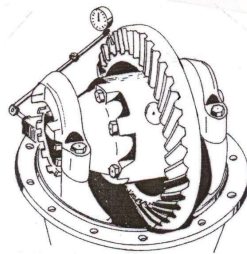
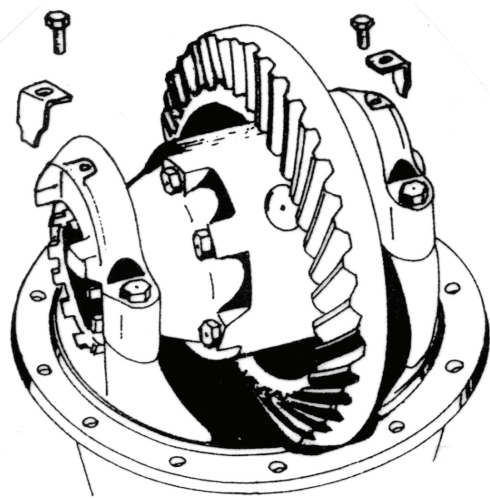
Version 2

Is no value marked on the circumference of the ring gear, the backlash is depend on the ring gear diameter (see following table).

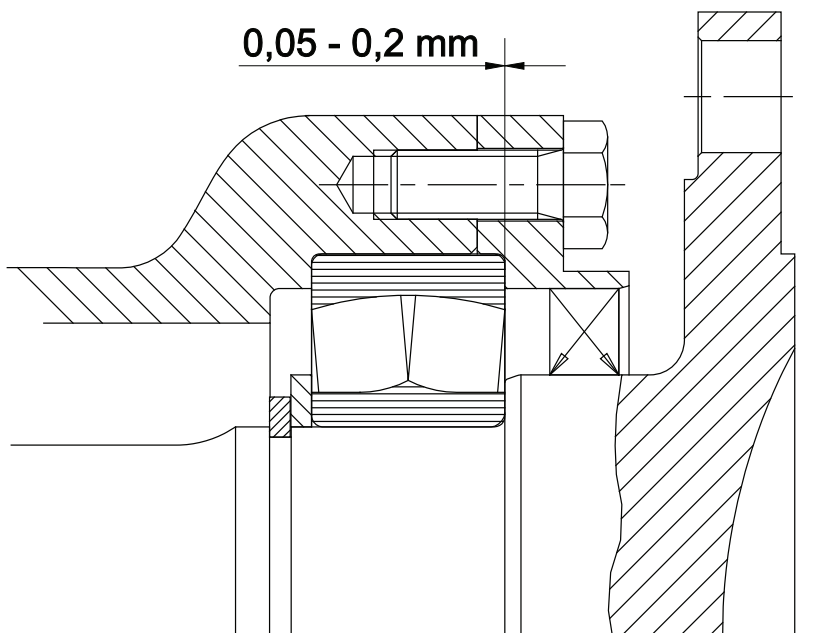


Drive description	Ring gear diameter	Backlash
Drive assembly 71	< 360	0,35

Adjustment of backlash

Version 1	Version 2	
		<p>Tighten the differential strap bolts by hand. By a counter rotation of the two thread rings, move the differential until the backlash is correct.</p> <p>Therefore hold the drive pinion at the drive flange. Check the backlash by careful forwards and rearwards rotating the ring gear. Use a dial indicator.</p> <p>Measure the backlash during a few times turns of the ring gear and if need correct the backlash, because of the smallest admissible value at the closest place must not be fall short of.</p>
		<p>Adjust the backlash according to sheet "Adjustment of contact pattern of bevel gear teeth".</p> <p>Tighten screws of the differential straps and lock them with Loctite 262.</p> <p>Adjust the bearing roll resistance trough tightening of the thread rings. Set value: 5.0 to 5.5 Nm. Check the value with a torque wrench. (measured with drive pinion and drive gear wheel assembled).</p> <p>Screw the lock plates for the thread rings and secure with Loctite 270, if need bend the lock plates.</p>

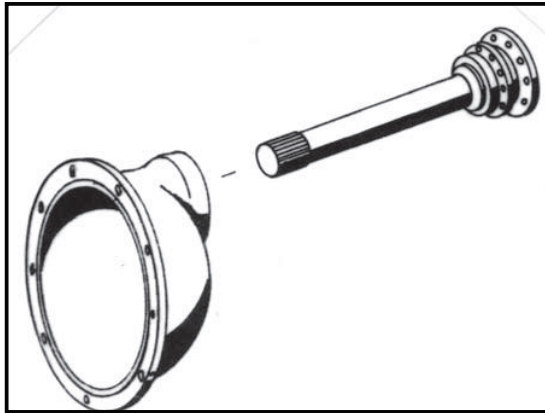
Pre-assembly of the drive-through shaft



Between cover and barrel-roller bearing must be a axial clearance of 0,05 to 0,2 mm. (Check the axial clearance by measurement, if necessary correct it).

- Install the radial seal ring with Loctite 572 applied into the cover.
Fill the radial seal ring with bearing grease.
- Place the cardan screws into the drive-through shaft.
- Push the cover with radial seal ring onto the drive-through shaft.
- Press the barrel-roller bearing onto the drive-through shaft.
- Install the support disc.
- Install the circlip into the slot of the drive-through shaft.

Assembly of the drive-through with shaft



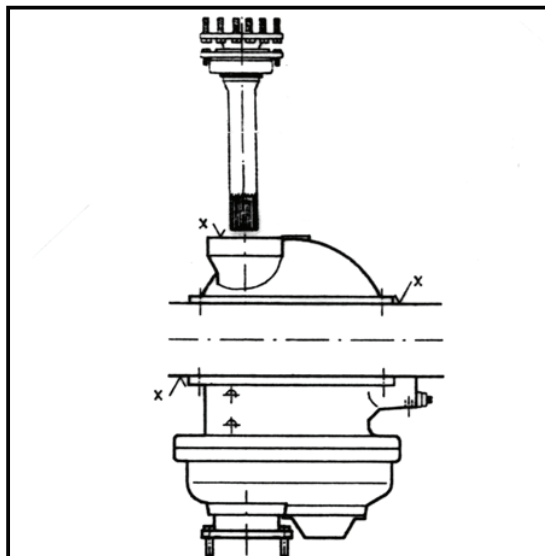
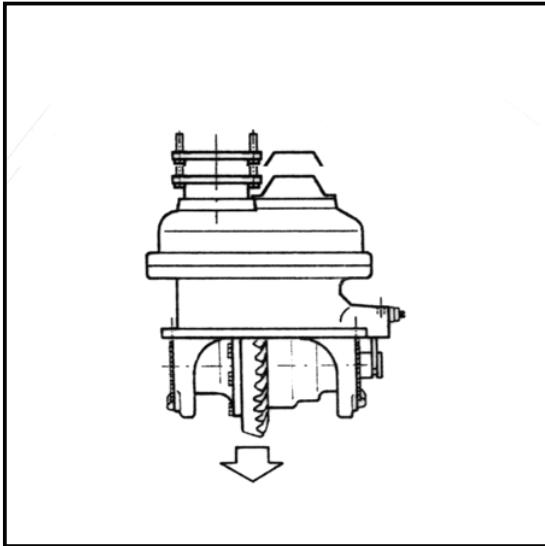
Assembly of the drive assembly onto the axle housing (see chapter 5).

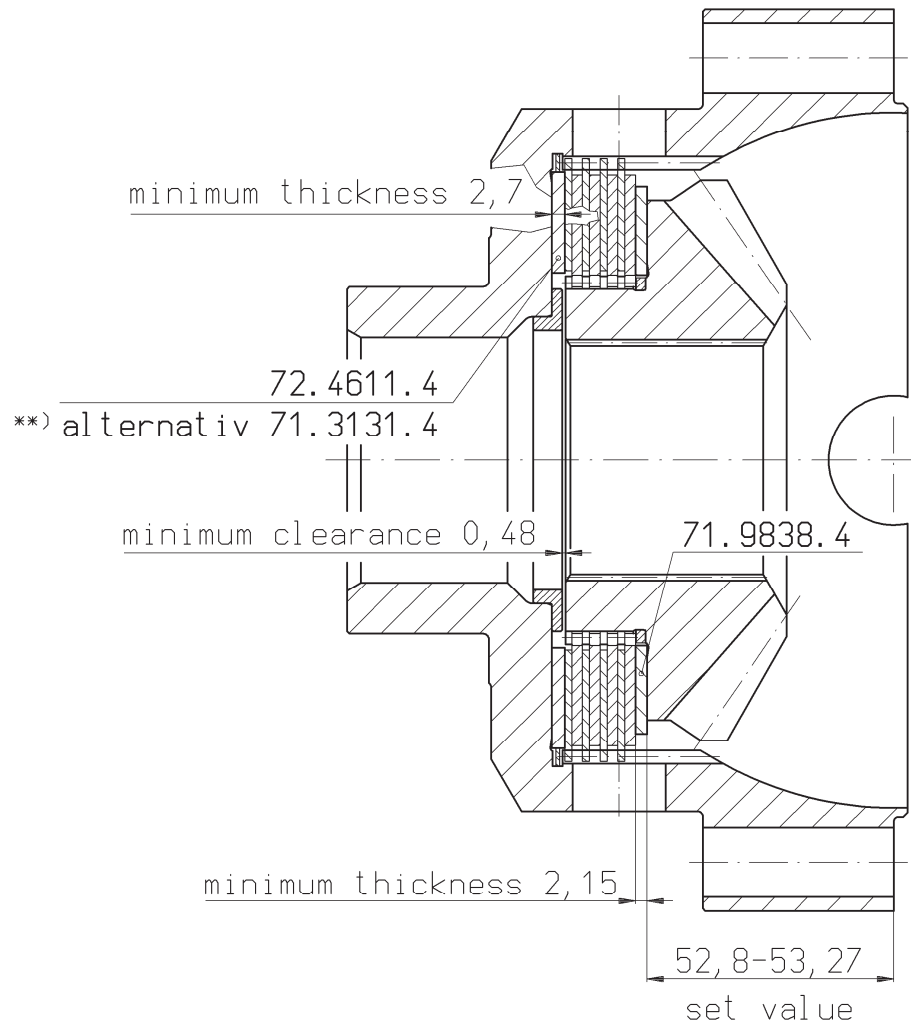
Turn the axle housing so that the drive assembly shows to the bottom.

Put on the housing cover and bolt it, secure the screws with Loctite 262.

Install the drive-through shaft equipped with its parts into the spline of the drive gear wheel and bolt it with the housing cover.

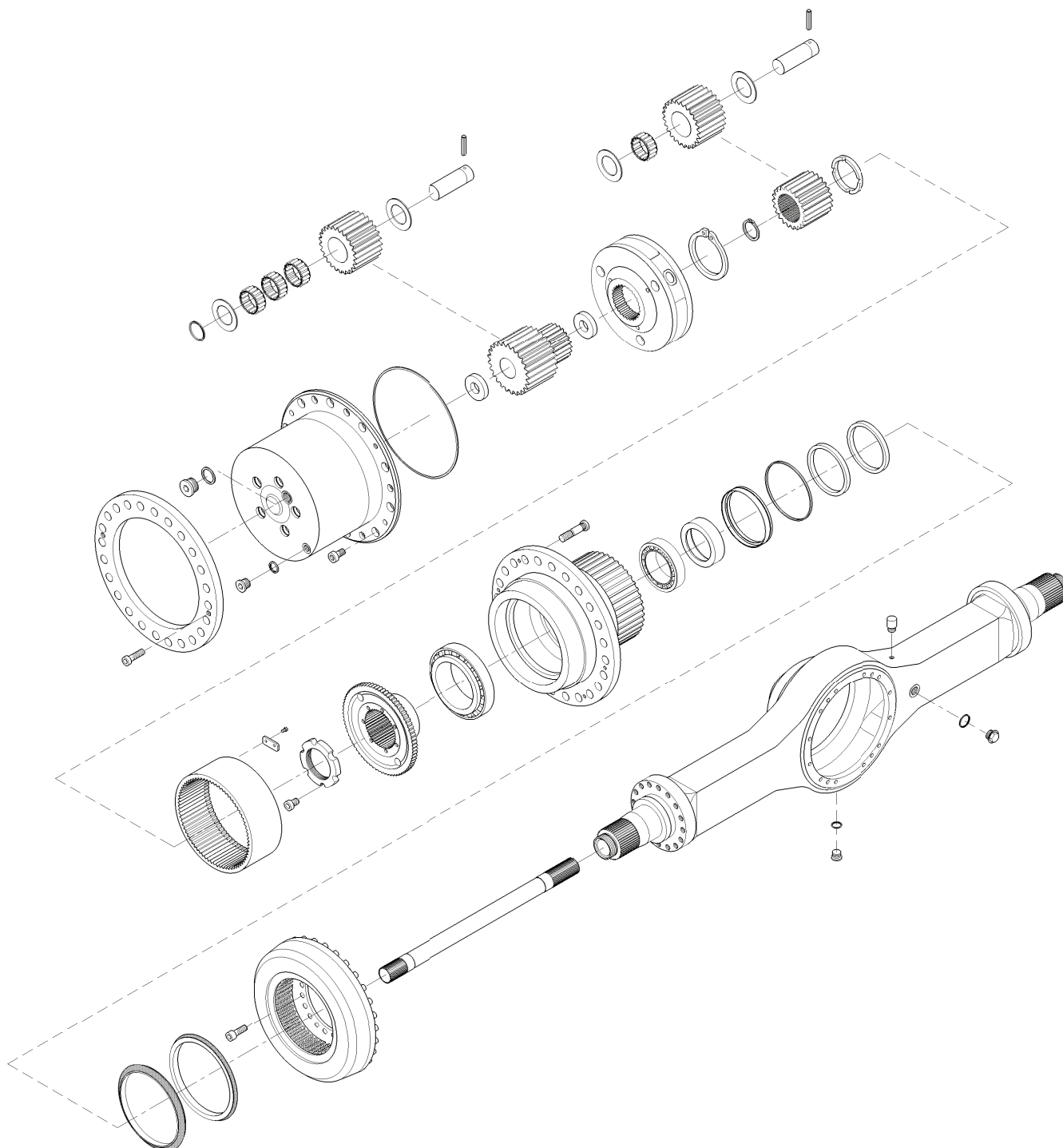
Coat the contact surfaces (x) with Loctite 510.



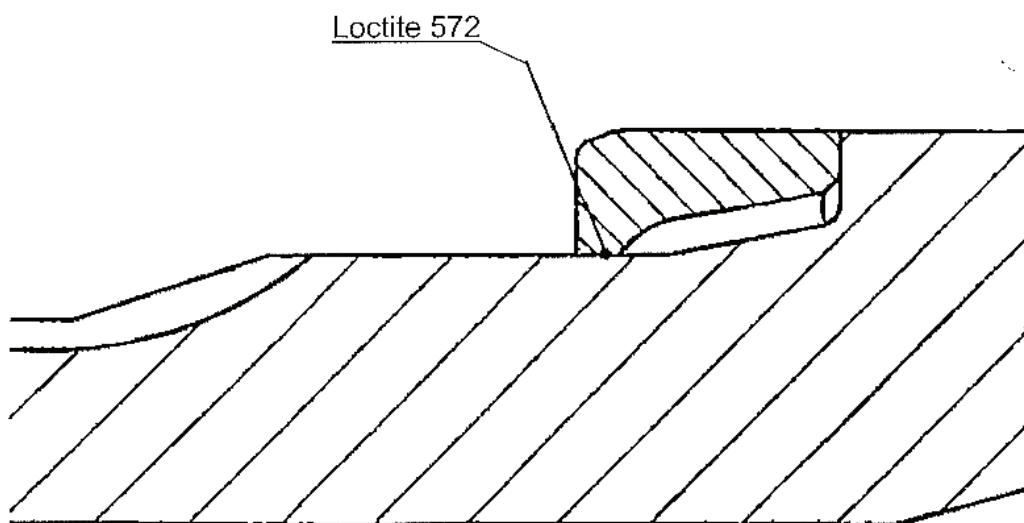


- if necessary grind off 71.9838.4
 - **) if disc thickness are not sufficient, exchange 72.4611.4 by 71.3131.4 and grind off if necessary
- (don't fall below minimum values!)**

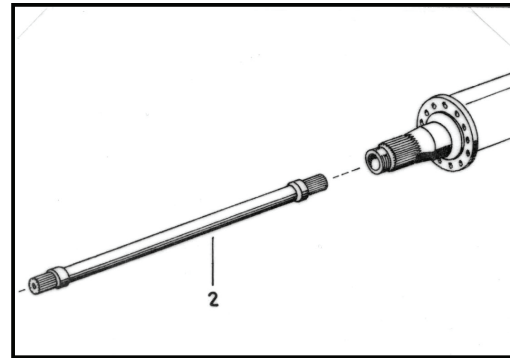
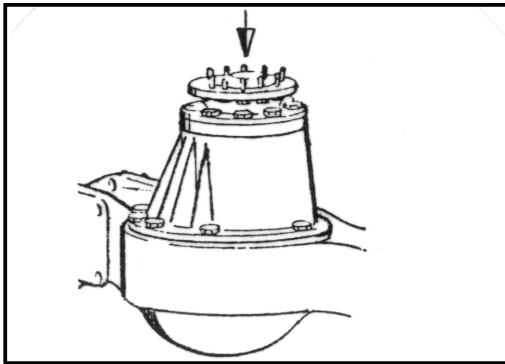
Hub assembly drive axle



Coat the seat of the spacer ring on the steering knuckle resp. axle spindle with Loctite 572. Heat the spacer ring to about 100°C and push it by gently striking onto the steering knuckle resp. axle spindle. (The steering knuckle resp. axle spindle must be free of corrosion). Oil the seal ring tread onto the spacer ring.



Assembly of the differential and carrier assembly onto the axle housing



Coat the contact surface of the axle housing with Epple 33 (at version through drive with Loctite 510), and mount the complete drive assembly. The axle housing being placed in a horizontal position, secure the screws with Loctite 262. Mount the pol wheel (if present) onto the axle shaft (see 5.1.7).

Engage the axle shaft into the axle housing.

The axle shaft should be able to be moved easily (by hand) in the toothing of the differential side gear.

At version with differential lock on the outside (D 71/ D 109) the differential lock must always be actuated when assemble or disassemble the axle shaft.

Direction:

Actuating of the differential lock is necessary to prevent the sliding sleeve to drop out of the shifter fork into the axle housing when pulling out or sliding in the axle shaft. This would entail disassembly of the axle.

- Assembly of the spacer ring (if present) see sheet 5.1.6.
- Install the brake onto the axle spindle, be careful of the brake control position and bolt it.
At version with disc brake install the brake carrier (if present), then mount the wheel hub with the brake disc, and after this operation install the brake.
- Prepare and mount the wheel hub see chapter 5.5.
Attention: Hold the wheel hub with a hoist until the outer bearing with ring gear carrier is mounted.
- Assembly of the planetary gear drive see chapter 6.
- At version with drum brake mount the brake drum.
- Assembly of the ABS - sensor installation (if present) see 5.1.7.

Attention:

At version with ABS resp. ABS - preparation (the pol wheel is mounted onto the axle shaft) the thrust ring of the sun gear in the axle spindle must be dismounted for disassembly the axle shaft.

Prepare and mount the wheel hub

NOTICE



At irregular assembly of the radial seal ring.

The sealing of the oil chamber is not guaranteed.

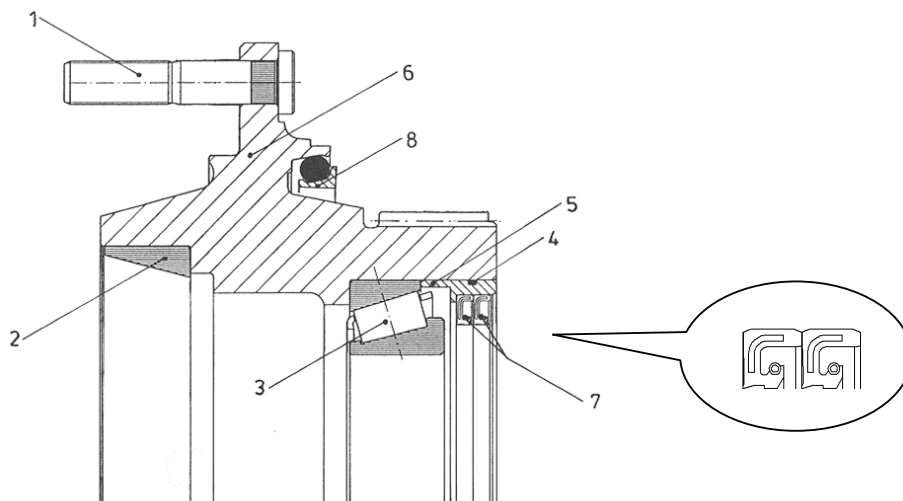
- Observe the fitting position of the sealing lip from the radial seal ring!
- Do not damage the sealing lip.
- Use a special tool – seal ring sleeve driver.

Prepare wheel hub



- Install the wheel studs (1).
- Press in outer rings of taper roller bearings (2 + 3), do not hammer them.
- Install inner ring of taper roller bearing (3).
- Install the O - ring (4) into the slot of the ring (5).
- Press the ring (5) with Loctite 572 applied into the wheel hub (6).
- Press the radial seal rings (7) with Loctite 572 (rubber cage) resp. Loctite 270 (steel cage) applied into the wheel hub (6).
- Fill the radial seal rings with bearing grease.
- Install the face seal (8) into the wheel hub (6) (see 5.8).

Mount wheel hub

- Push the pre - assembled wheel hub (6) parallel onto the axle spindle resp. steering knuckle.
- **Important:** Be careful not to damage the radial seal rings (7).



Adjustment of wheel bearings

 DANGER	
	<p>Wrong assembly and incorrect locking of the wheel bearing adjustment nut</p> <p>The wheel together with the complete hub assembly becomes detached from the axle.</p> <ul style="list-style-type: none"> ➤ The wheel bearing adjustment nut must absolutely be tightened and locked as described!

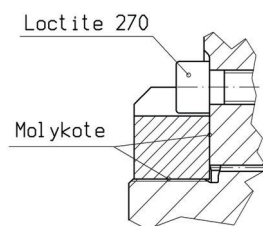
Tightening torque of the wheel bearing adjustment nut

readjustment <u>used</u> bearings (Nm)	<u>new</u> bearings (Nm)
550	650

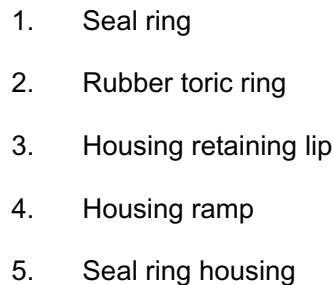
Assembly wheel bearing adjustment nut

- Completely coat the contact surface and the thread of the wheel bearing adjustment nut with assembly paste.
 - **Assembly paste with solid lubricants**
- Screw on the wheel bearing adjustment nut and tighten with 1.5 to 2 times of the later tightening torque.
 - **Customer service tool: Wrench for wheel bearing adjustment nut**
 - **Lightly knock on the wheel hub with a plastic hammer and turn it repeatedly during tightening**
- Loosen the wheel bearing adjustment nut again (unscrew it approximately 180 °).
- Tighten the wheel bearing adjustment nut.
 - **Turn the wheel hub repeatedly during tightening.**
 - **Tightening torque see the table.**
 - **If it is not possible to lock in this position, the wheel bearing adjustment nut must turned forward to the next possible locking position.**

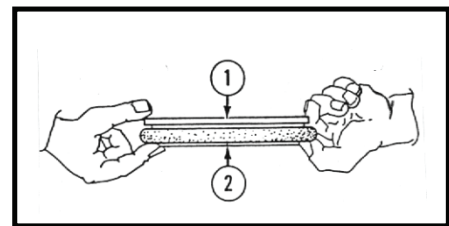
Locking wheel bearing adjustment nut



- Lock the wheel bearing adjustment nut with a screw.
 - **Screw locking: Loctite 270**
 - **Tightening torque: 72 Nm**



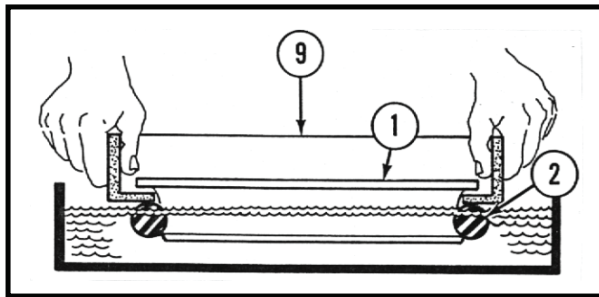
After all components have been wiped clean, the torics should be installed on the metal seal rings so that they rest in the radius on the tail of the metal ring. Insure that the torics are not twisted by inspecting the mold flash line on the outside diameter of the toric for true circumferential tracking around the seal. Twisted torics will cause nonuniform face load that can result in leakage of lubricant and pumping of debris past the toric. If a twist is apparent, it can be eliminated by gently pulling a section of the toric radially away from the metal seal ring and letting it “snap” back. Repeating this in several places around the ring will eliminate any twist in the toric ring.



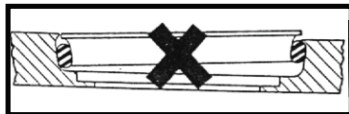
Eliminate toric twist by gently pulling a section of the toric (2) rapidly away from the seal ring (1) and letting it “snap” back.

Assembly of the face seal

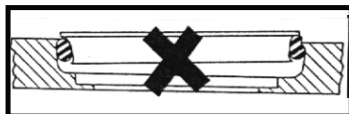
Place the installation tool around the seal ring and dip the seal ring into a pan of Isopropanol solvent to lubricate the toric ring. It is essential to lubricate the toric with Isopropanol so that the toric will slip past the housing retaining lip and seal uniformly in the housing nose radius. Insufficient lubrication can cause poor seal performance due to nonuniform loading (twisted torics or cocked seals). Use of solvents other than Isopropanol can leave a residue on the toric or ramps and allow the toric to slide rather than roll in seat. This can also result in poor seal performance due to nonuniform loading.



Put the installation tool (9) onto the seal ring (1) with toric ring (2). Lower the rings into a container with Isopropanol until all surfaces of the toric (2) are wet.



Toric sliding on retainer ramp.

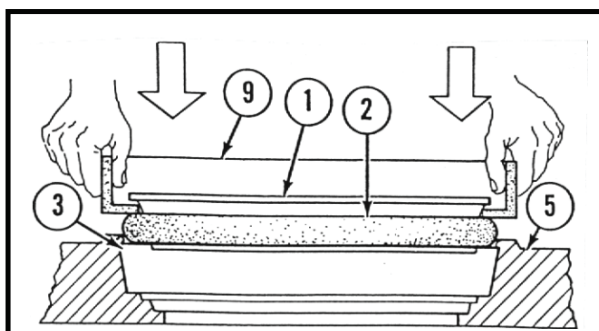


Toric caught on housing retainer lip.



Toric sliding on seal ramp.

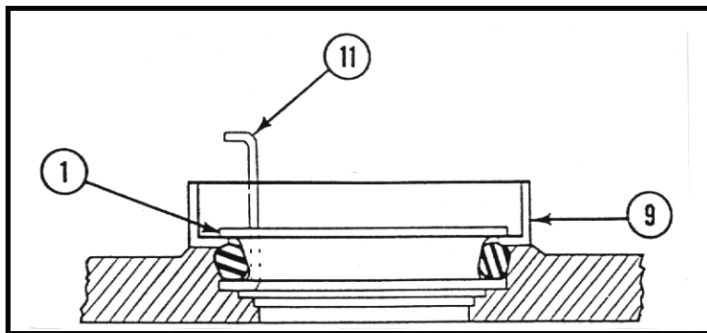
After dipping the seal assembly in the solvent, shake the excess solvent from the seal assembly and immediately “pop” the seal into the housing with a firm push of the installation tool. Remove the installation tool and check the seal stantout height at several places around the circumference of the ring to verify an accurate installation. If the seal does not meet the height specification, inspect the toric for twists or obvious bulges.



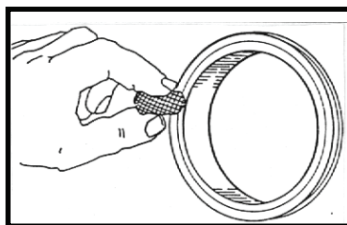
With all surfaces of the toric ring (2) wet with Isopropanol, use the installation tool (9) to position the seal ring (1) and the toric ring (2) squarely against the housing (5) as shown. Use sudden and even pressure to pop (push) the toric ring (2) under the retaining lip (3) of the housing (5).

Assembly of the face seal

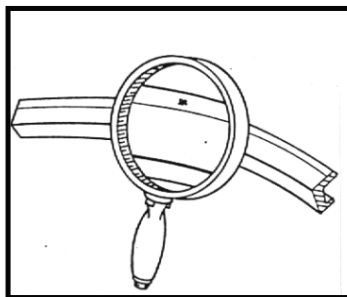
The seal can be adjusted by gently pushing the toric into position by hand or by using a fabricated adjustment hook.



If small adjustments are necessary, do not push directly on the seal ring (1); use the installation tool (9) to push down or the adjustment tool (11) to pull up.



A thin film of light oil should be applied to the seal faces prior to assembly. Use an applicator, a disposable tissue or a clean finger to distribute the oil evenly. Be careful not to get any oil on the rubber toric rings.



Be sure there is no visible debris on either of the seal faces - even a small piece of lint can hold the seal faces apart and cause leakage.

After successful installation, wait one minute for the Isopropanol to dry before assembling the two seal halves in the final loaded position. This delay is to allow any excess solvent to dry so that the torics roll, rather than slide, in the housing as the faceload is increased. If the torics slide, this can produce a nonuniform load that can result in poor seal performance.

Results of incorrect assembly :

Point "A" and point "B" remain stationary.

Points "X" and "Y" rotate 180°.

This causes high pressure at "A"/ "Y" and possible galling.

When rotated, points "B"/ "X" has low pressure and possible leakage.



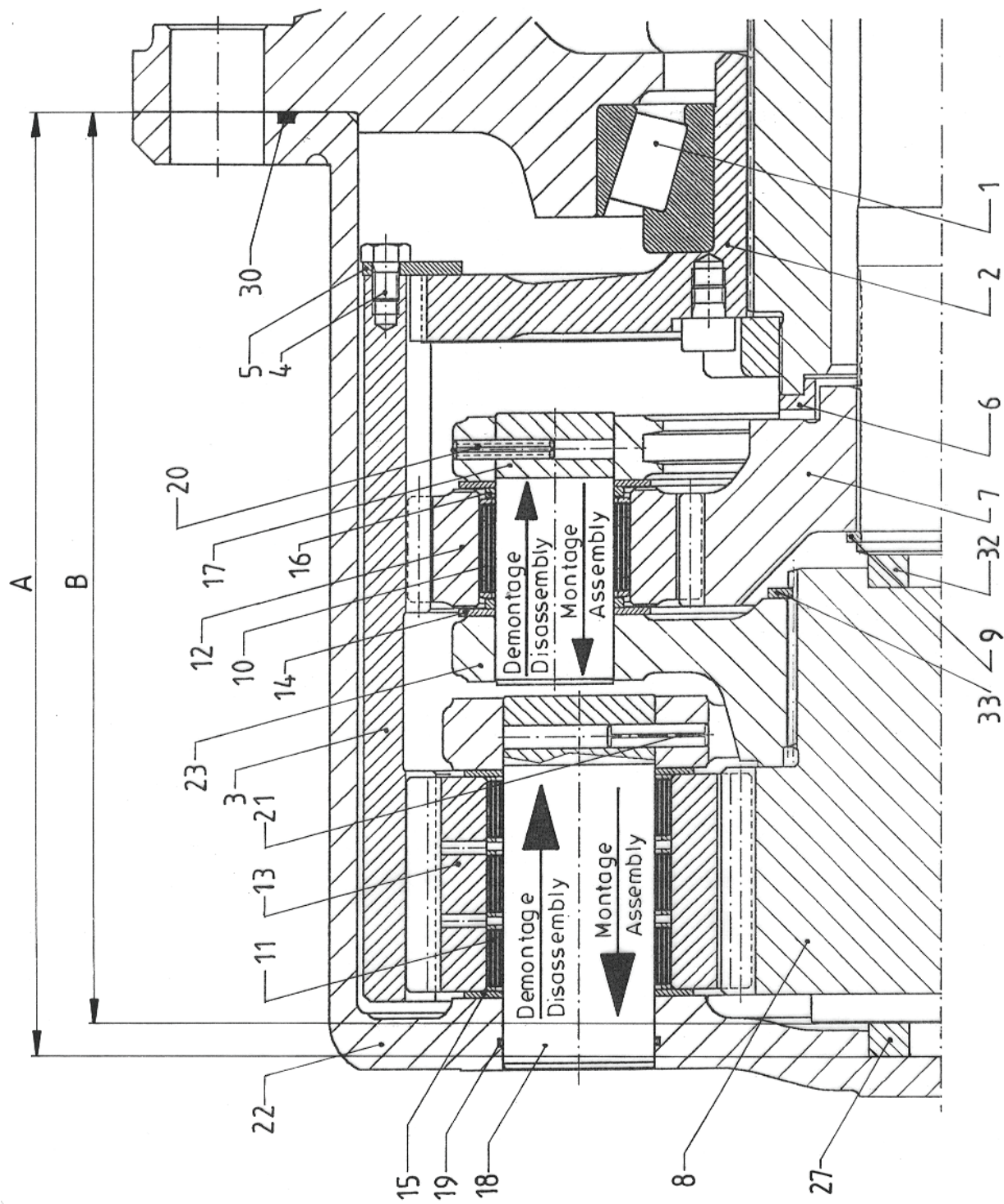
Original assembled position



Rotated 180°

After the unit to be sealed is assembled, a post - assembly leakage test can be performed to insure the seal is properly installed. A vacuum check is recommended rather than a pressure check as vacuum checks are more sensitive. Many users find this an easy check to combine with a vacuum fill technique for the lubricant. It is recommended the compartment be filled to the correct level with lubricant and then rotated slowly several revolutions to seat the seals. A vacuum test will catch big seal damage such as broken seal rings or cut torics that may be caused in the last phases of assembly. The Duo - Cone seal is not designed to seal air, so some leakage can be expect using such a procedure.

Following these guidelines and recommendations should insure optimum performance from the Duo - Cone - seals.

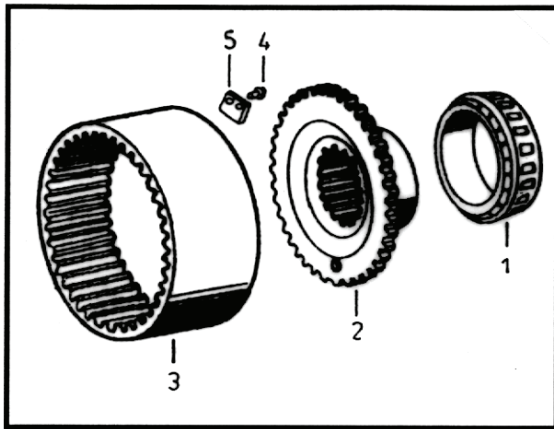


Assembly of the ring gear and ring gear carrier

Assembly of the sun gear

Section
6
6.0.1

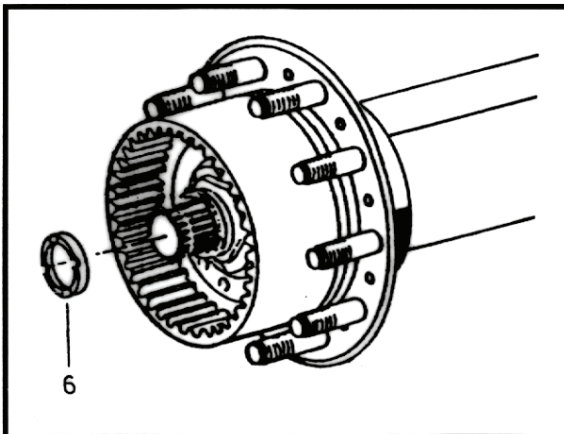
Prepare the ring gear and the ring gear carrier



Heat the taper roller bearing inner ring with cage (1) to about 100°C and install it onto the ring gear carrier (2). Place the ring gear (3) onto the ring gear carrier. Bolt the retainer (5) with the screws (4), secure the screws with Loctite 270. At PL417/510 the ring gear has to be mounted after installation of the fast planetary gear stage, reverse the ring gear has to be disassembled before disassembly of the fast planetary gear stage.

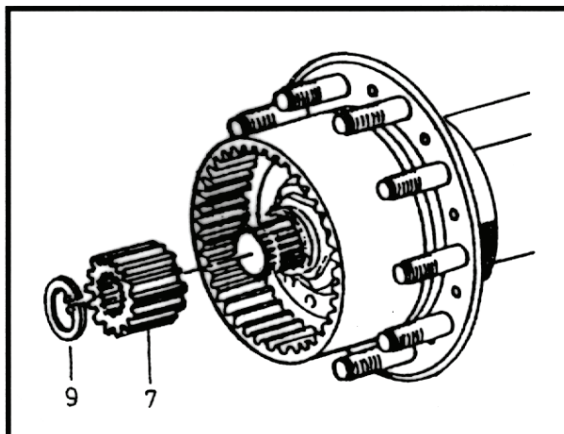
Assembly of the ring gear carrier

Install the ring gear carrier (2) with ring gear (3) into the wheel hub resp. onto the steering knuckle resp. axle spindle. The oil compensating hole in the ring gear carrier must be on the bottom. Subsequent adjust wheel bearings (see chapter 5.7).



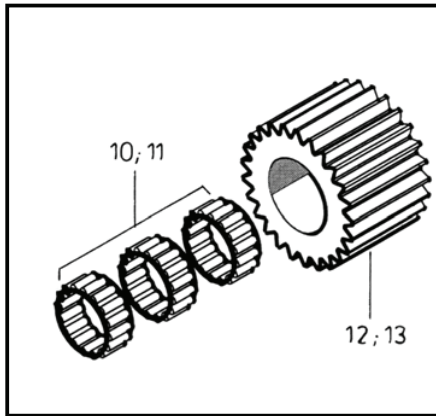
Assembly of the thrust ring

Press the thrust ring (6) into the steering knuckle resp. axle spindle. Secure with Loctite 270.



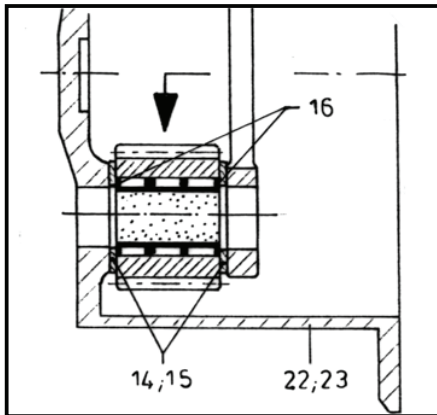
Assembly of the sun gear

Slip the sun gear (7) onto the universal joint resp. axle shaft, install the circlip (9) and push the universal joint resp. axle shaft towards the inside until the circlip contacts to the sun gear and the sun gear contacts to the thrust ring.

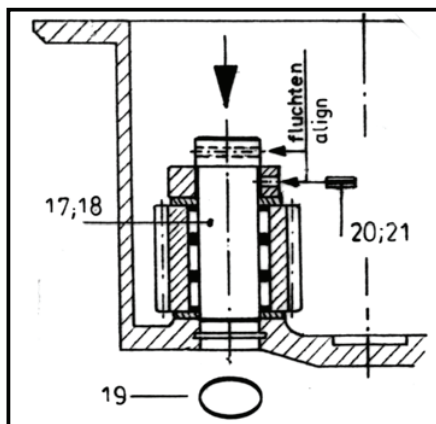


Prepare planetary gear:

Install the needle bearing (10 resp. 11) into the planetary gear (12 resp. 13).



Insert the preassembled planetary gears (12 resp. 13) with needle bearings (10 resp. 11), rings (16) (if present) and thrust discs (14 resp. 15) into the planetary housing (22 resp. 23) (planetary housing in horizontal position).



Place o - ring (19) into the slot of the planetary housing (22). Because of the difference of diameter of 0,1 mm press the planetary pin (17 resp. 18) in direction of arrow. Be sure, that the bore hole of the locking pin in the planetary pin and planetary housing are aligned. After inserting, secure the planetary pin with the locking pin (20 resp. 21).

Assembly of the planetary housing (23)

Press the thrust disk (32) into the sun gear (8), secure with Loctite 270.

Press the sun gear (8) into the planetary housing (23), secure with Loctite 270.

Install the circlip (33) into the slot of the sun gear. Insert the preassembled planetary housing (23) into the hub assembly (fix on the sun gear (7) and in the ring gear (3)).

Adjustment of the axial clearance

The axial clearance between sun gear (8) and thrust disc (27) in the planetary housing (22) must be 0,6 - 0,9 mm.

Measure distances:

Dimension A =

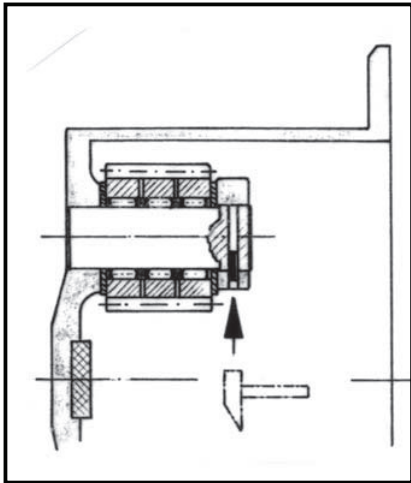
Dimension B =

Required disc thickness = A - B - axial clearance (0,6 - 0,9 mm)

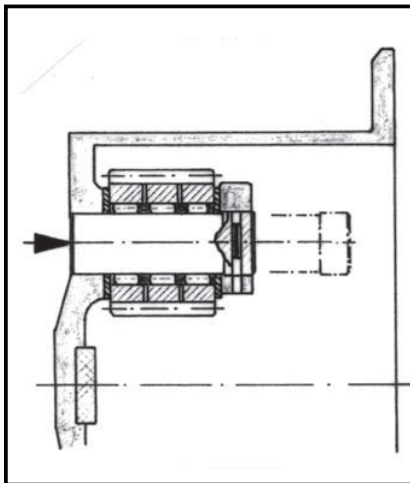
Mount the correctly dimensioned thrust disc (if necessary, make final correction on a lathe) into the planetary housing. Secure with Loctite 270.

Assembly of the planetary housing (22)

Place o - ring (30) into the slot of the planetary housing. Install the preassembled planetary housing (22) and bolt it.



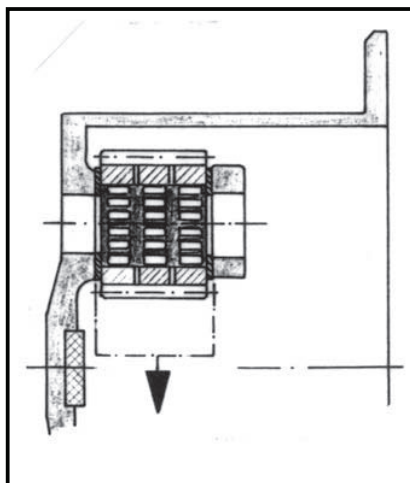
Knock the locking pin (20 resp. 21) completely to the inner side of the planetary pin.



Press the planetary pin in direction of arrow out of the planetary housing.

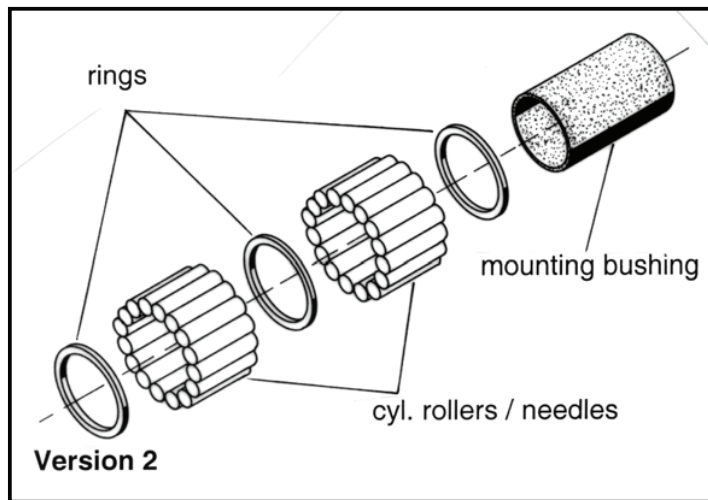
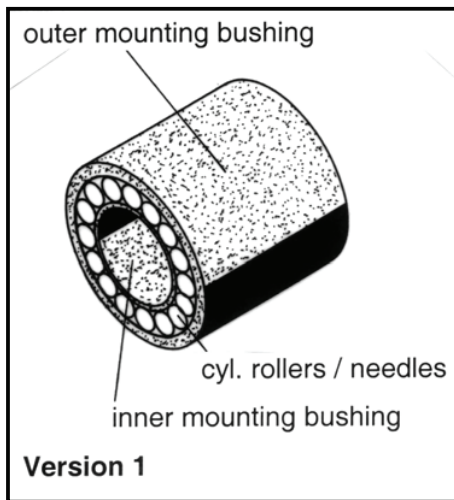
Attention:

Because of the difference of diameter of 0,1 mm do not press the planetary pin against the direction of arrow out of the planetary housing, to prevent damaging the bore.



Remove the planetary gears with the thrust discs and needle bearings.

Assembly/ disassembly of cageless needle bearing (planetary gear bearing)



Assembly:

Version 1: Install the needle bearing with mounting bushings into the planetary gear, thereby the outer mounting bushing will be stripping.
Insert the planetary gear with thrust discs into the planetary housing.
Press in the planetary pin, thereby the inner mounting bushing will remove.

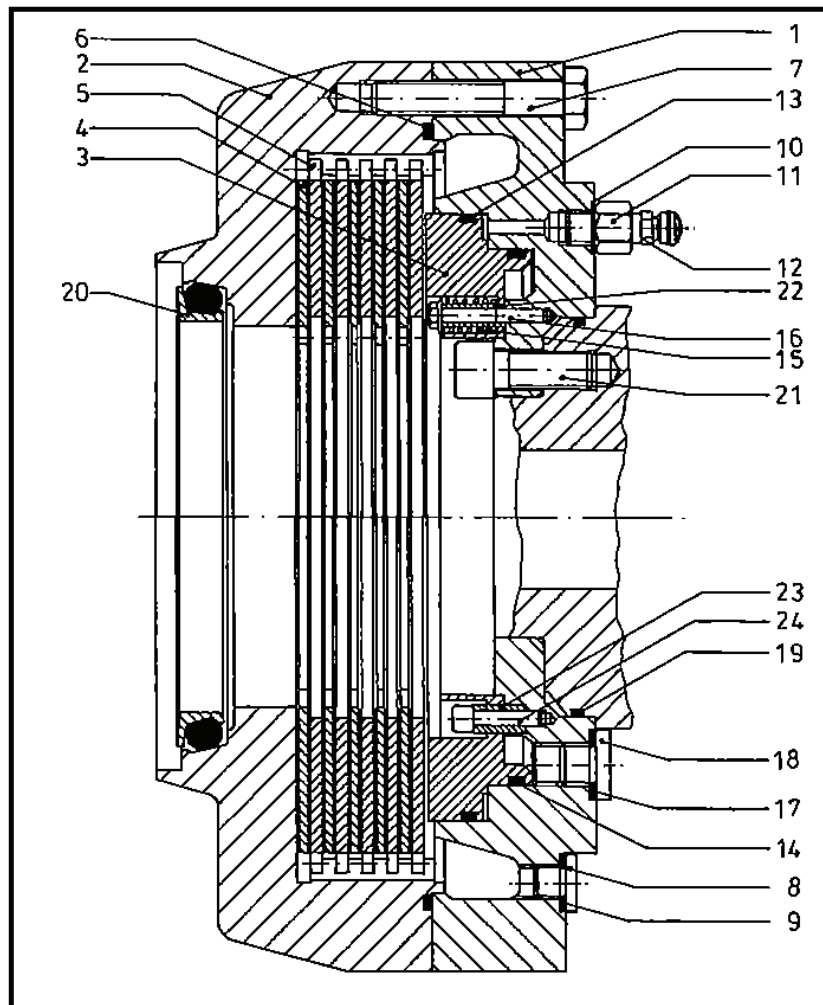
Version 2: Place one thrust disc on the work bench, place on the planetary gear and insert the mounting bushing.
Insert the cylindrical rollers/ needles alternately with the rings (according to the design).
Insert the planetary gear with thrust discs into the planetary housing.
Press in the planetary pin, thereby the mounting bushing will remove.

Hint: Note the passage "Assembly of the planetary gear"!

Disassembly:

At the disassembly of the planetary pin the cageless needle bearing will fall asunder, if not a mounting bushing will be pushing inwards at planetary pin removing.

Hint: Note the passage "Disassembly of the planetary gear"!

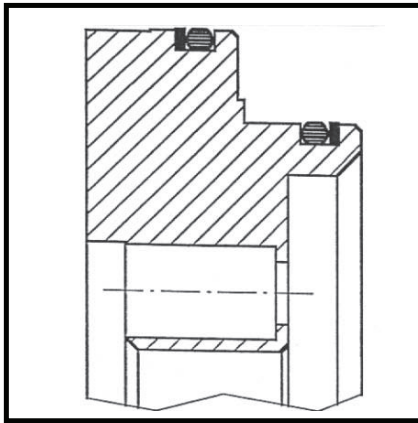


- | | |
|----------------------|------------------|
| 1. Brake carrier | 13. Sealing ring |
| 2. Brake housing | 14. Sealing ring |
| 3. Piston | 15. Spring |
| 4. Inner disc | 16. Screw |
| 5. Outer disc | 17. Seal ring |
| 6. O – ring | 18. Screw plug |
| 7. Screw | 19. O - ring |
| 8. Screw plug | 20. Face seal |
| 9. Seal ring | 21. Screw |
| 10. Seal ring | 22. Tube |
| 11. Connection peace | 23. Bushing |
| 12. Breather | 24. Screw |

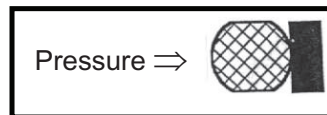
Assembly of the piston seals

Place piston with the larger diameter downwards. Note succession of the sealing parts at fitting.
Install o - rings free of torsion and loops.

Assembly of o - ring and supporting ring

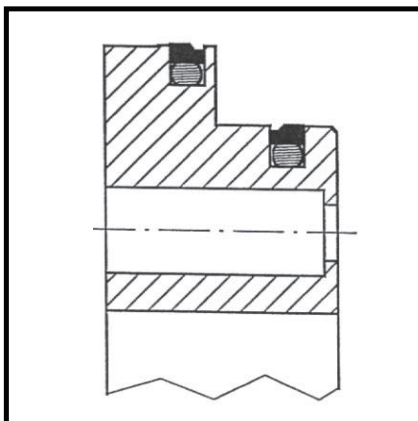


1. large supporting ring
2. large o - ring
3. small o - ring
4. small supporting ring

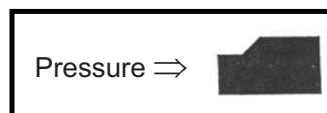


Install the supporting rings to the averting side of pressure!

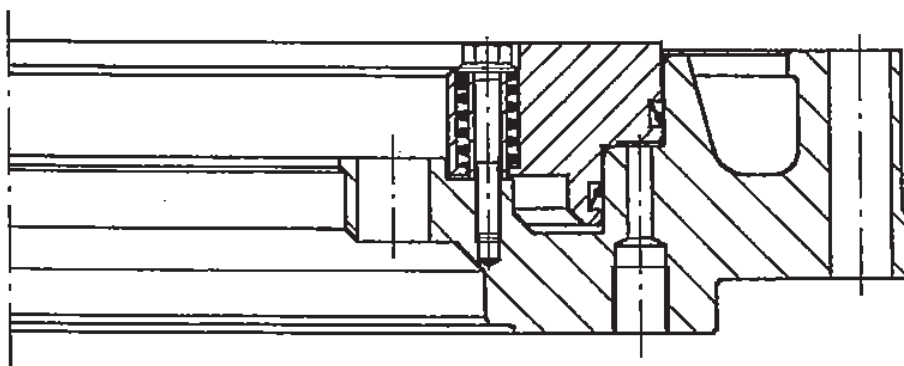
Assembly of the Omegat seal kit



1. large o - ring
2. small o - ring
3. large supporting ring
4. small supporting ring



Install the PTFE - profile rings with small diameter to pressure side!



- lubricate cylinder bore
- apply the thread holes at wet disc brakes with Loctite

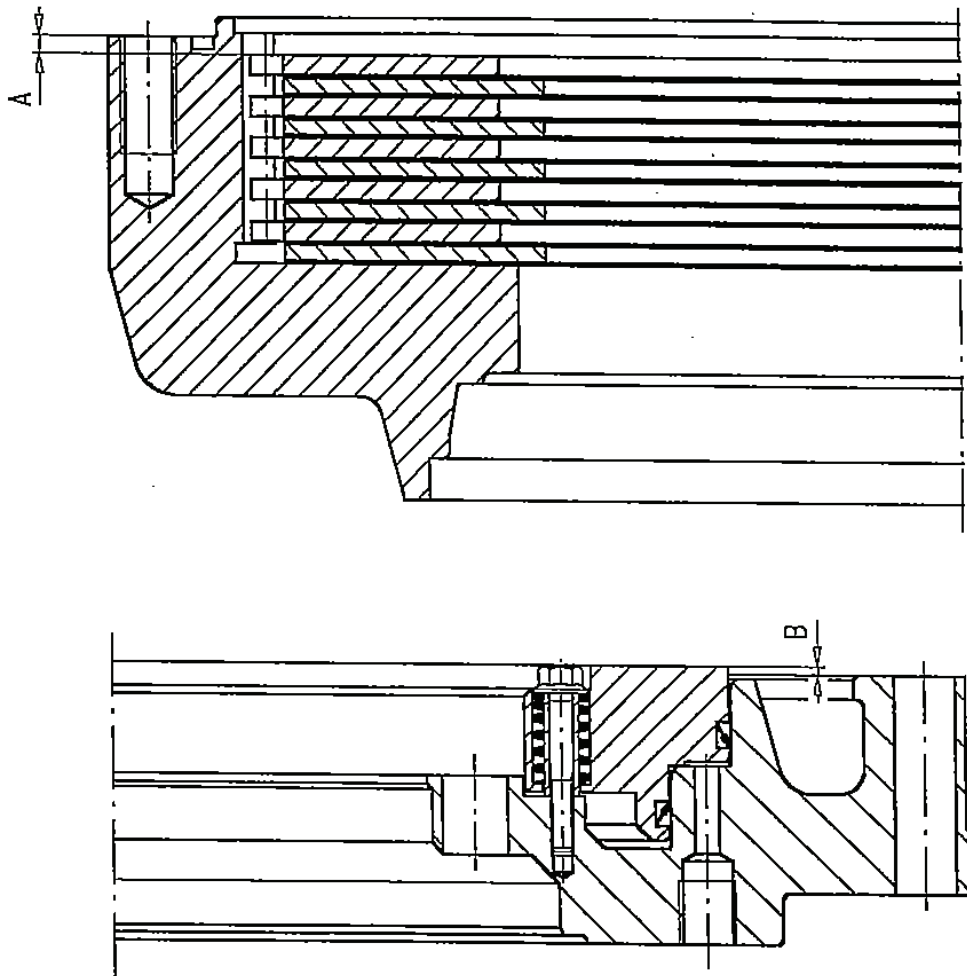
Wet disc brake (dimension X...)	X270 - X340	X460 – X550 – X650
use	Loctite 243	Loctite 262

- install and screw the bushing (if present)
- place the piston onto the brake carrier (do not cant it!)

Wet disc brake (dimension X...)	X270 - X340	X460 – X550 – X650
Assembly of the piston	press the piston equal by hand into the brake carrier (do not cant it!)	press the piston equal with mounting screws into the brake carrier (do not cant it!)

- if necessary adjust the piston with easy hammer taps to the thread holes
- install first the springs, then the tubes in the bore holes of the piston
- screw in the hexagon head screws with flange

Prepare housing and check the air gap



Lay discs into the housing.

Check the air gap:

Air gap = measure A - measure B (measured without pressure)

Rated size about 0,5 mm smaller than the air gap pressurized (see table).

Install o - ring (brake housing/ brake carrier) free of torsion and loops.

Air gap and wear dimension

brake typ	air gap sL new (mm) (pressurized)	wear dimension (mm)
3270	$1,5 \pm 0,7$	1,5
4270	$1,5 \pm 0,7$	1,5
3340	$2,4 \pm 0,6$	1,5
3340-1	$1,8 + 0,5/ - 0,1$	1,5
3340-3	$1,5 \pm 0,6$	1,5
4340	$2,5 \pm 0,9$	2,0
5340	$2,4 \pm 0,9$	2,5
6340	$2,8 \pm 0,6$	3,0
3460	$2,5 + 0,7/ - 0,1$	1,5
4460	$2,5 + 0,7/ - 0,1$	2,0
4460-1	$2,25 + 1/ - 0,1$	2,0
5460	$3,0 + 0,5/ - 0,1$	2,5
6460	$3,0 + 0,5/ - 0,1$	3,0
7460	$3,0 + 0,5/ - 0,1$	3,5
8460	$3,3 + 0,5/ - 0,1$	4,0
10460	$4,0 + 0,5/ - 0,1$	5,0
5550	$3,0 + 0,5/ - 0,1$	2,5
8550	$3,5 + 0,5/ - 0,1$	4,0
4650-1	$3,5 + 0,5/ - 0,1$	2,0
6650-1	$4,0 + 0,5/ - 0,1$	3,0

Place the brake carrier onto the brake housing and bolt it. Mount breather with connection piece and seal ring, screw plugs with seal rings.

Check brake hydraulik system for leaks (see tightness checking instruction).

Install o - ring (Brake carrier/ axle spindle resp. steering knuckle) free of torsion and loops.

Check the air gap (pressurized):

Measure through the check hole the distance from brake carrier to the piston end face, while non actuated brake, actuate the brake and repeat the measure operation - the difference of the measured distances gives the air gap sL (pressurized), rated size sL see table.

Measure through the check hole the distance from brake carrier to the piston end face, while actuating the brake and knock the measured value with marking punches into the brake carrier.

Install the complete brake on the axle (coat the contact surface with Loctite 270).

Mount face seal see chapter 5.8.

Alignment of the discs

Wet disc brake dimension X270 and X340:

The alignment of the discs has to be made at mounting of the wheel hub by itself.

Wet disc brake dimension X460 and X650:

The alignment of the discs has to be made by a mounting device (see chapter 3.6). Clamp the discs by actuating the brake (hydraulic or air pressure).

Check brake hydraulic system for leaks

Before conducting the test, bleed the brake hydraulic system.

The pressure drop after applying 120 bar for a period of 15 minutes must not exceed 2% (leaving 117,5 bar).

Test medium: Motor oil SAE 10 W corresponding to MIL - L 2104.

Check cooling oil room for leaks

Brake with external cooling:

After assembly of the wheel hub with the face seal and adjusting of the wheel bearings check the tightness of the cooling oil room.

Install an air pressure gauge with shutoff valve.

Beload the hub assembly with 1,5 bar pressure air.

Turn the hub assembly several times.

The pressure drop after a period of 10 minutes must not exceed 0,1 bar.

Brake without external cooling:

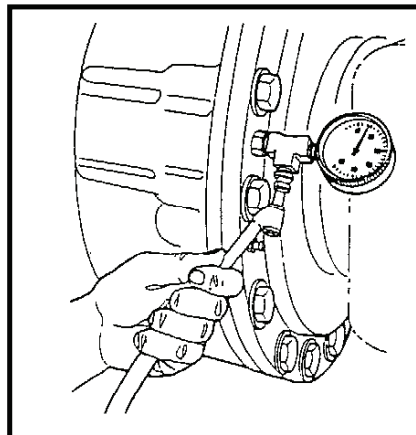
After assembly of the planetary gear drive check the tightness of the cooling oil room.

Install an air pressure gauge with shutoff valve.

Beload the hub assembly with 0,5 bar pressure air.

Turn the hub assembly several times.

The pressure drop after a period of 15 minutes must not exceed 0,1 bar.



Remarks to the wet disc brake

Permissible oil for brake with external cooling

Actuation fluid:

Do not use brake fluid at any time!

Use a mineral oil base hydraulic oil type fluid only!

- 1) Motoroil API SE/ CD
 MIL - L - 46152C/ MIL - L - 2104 C o. D
- 2) ATF C - 3 or Dexron ®
- 3) Hydraulicoil HLP DIN 51524 Teil 2

Viscosity:

For moderate climate ISO VG 22 - 32

For extremely cold climate ISO VG 15

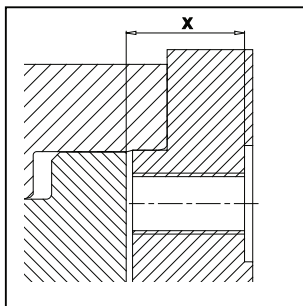
For extremely warm climate ISO VG 46

Cooling fluid: like actuation fluid.

Important: It is necessary to use oils with LS - additives (Limited Slip), according to the recommendation of the oil supplier.

For example: 3 - 6% Lubrizol LZ 6117/ LZ 9990 A or LZ 6279

Check measure:



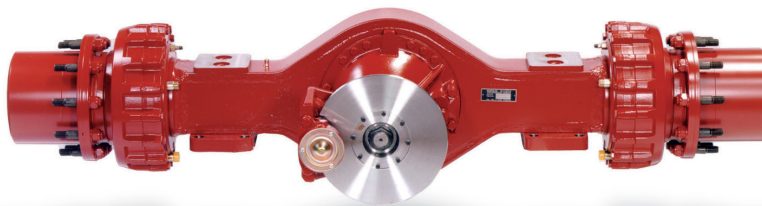
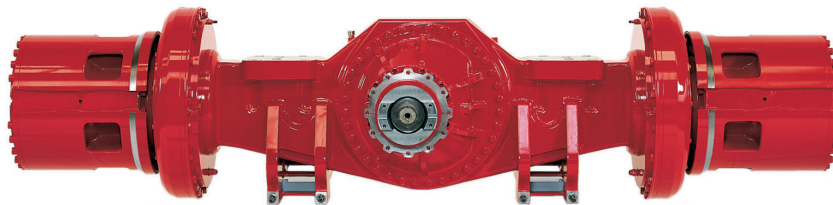
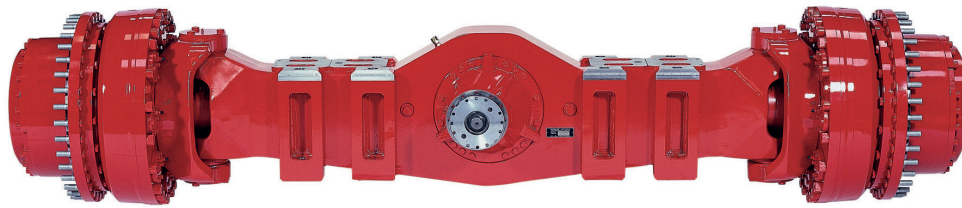
It is measured through the check hole, while actuating the brake.

The check measure, new, is marked in the housing below the hole.

Is the measured dimension bigger than the marked dimension and max. wear dimension, unconditional consult Kessler & Co.

After working at the brake, bleed the brake hydraulic system and check for tightness!

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