

4. Press out race of outer taper-roller bearing on VW Press 400 F, using special tools VW 407, VW 418, VW 447f, Spacer 1, and VW 401.

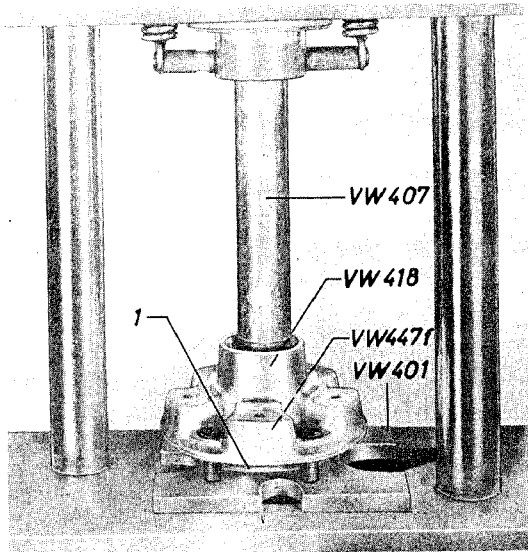


Fig. 19

Sketch for local manufacture of Spacer 1

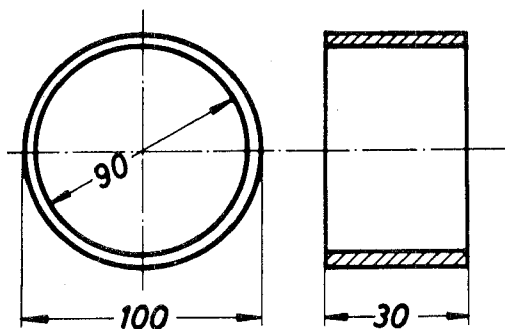


Fig. 20

90 mm = 3.54 in., 100 mm = 3.94 in., 30 mm = 1.18 in.

Installation

The following should be observed during installation:

General

Taper-roller bearings of various brands (SKF, FAG, and Timken) are used during assembly at the plant.

New bearing components, such as the outer race or the inner race with rollers, may be interchanged within a given brand but care must be taken that the complete bearing consists of components manufactured by the same company.

1. Thoroughly clean both taper-roller bearings and check for wear or damage, replace if necessary.
2. Heat wheel hub to 120 - 150° C (248 - 270° F).
3. Press in the race of the inner taper-roller bearing on VW Press 400 F, using special tools VW 407, VW 447i, Spacer 1, and VW 401.

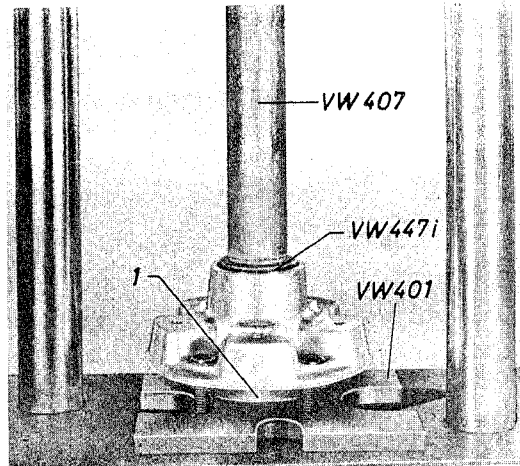


Fig. 21

4. Insert the inner race into the inner taper-roller bearing and press oil seal on VW Press 400 F, using special tools VW 410, VW 433, Spacer 1, and VW 401 until the oil seal is flush with the wheel hub housing.
5. Press in the outer race of the outer taper-roller bearing on VW Press 400 F, using special tools VW 407, VW 447h, and VW 401.

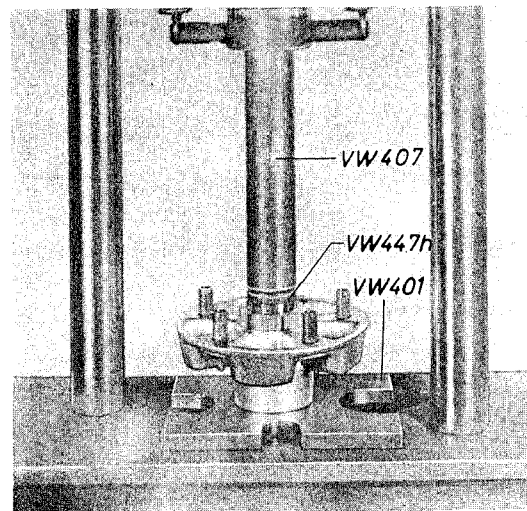


Fig. 22