Assembly

1. Inspect cleaned parts for wear and material failures. The sliding studs must not vary in length more than 0, 05 mm (. 002 in).
2. Apply molykote G paste lubricant to the curved tracks and sliding studs. Parts must first be free of oil.
3. Insert sliding studs in the driver plate.
4. Install brake rings on the axle joint bodies and place in differential carrier. Assemble carrier halves to driver plate fasten through bolts.
5. Measure the total axial play of the axle joint bodies within the carrier halves. Permissible play 0, 2 to max. 0, 3 mm (. 008 to . 012 in). If play is excessive use thicker brake rings to obtain the correct play.
6. With the correct axial play the differential gear must turn freely by hand.
7. When the differential is completely assembled check rotational play by holding one axle joint body fixed with the carrier housing and rotating the opposite joint. Free travel observed through the carrier housing openings should be from 1 to 1, 2 mm (. 040 to . 047 in) measured on the outer circumference of the curved track.
8. Tighten the nuts of the connecting screws with a tension wrench to Md = 2, 3 - 2, 5 mkg (ft lb = 16, 6 - 18) and secure with securing strip.

Note:

Through wear of the curved track the rotational play can become as great as 3 to 4 mm without affecting the function of the differential. However, such play will cause noises during power reversal which have no effect on the functioning of the unit.

Gear Lubricant:

The proper lubricant is SAE 90 Hypoid Gear Lubricant.

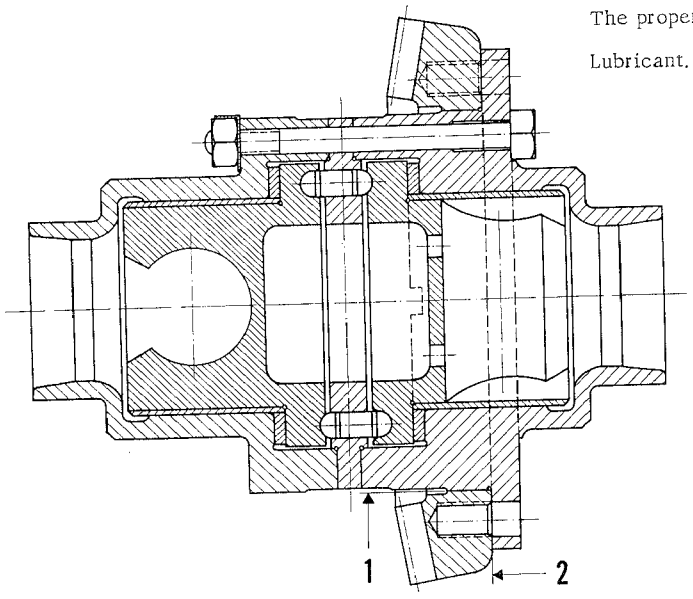

Fig. 9

1. Eccentricitiy max. 0, 05 mm (. 002 in)
2. Wobble max. 0, 003 mm (. 0012 in)