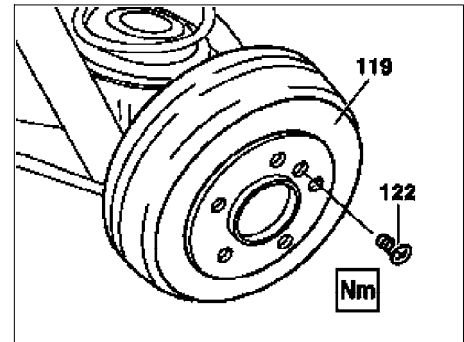
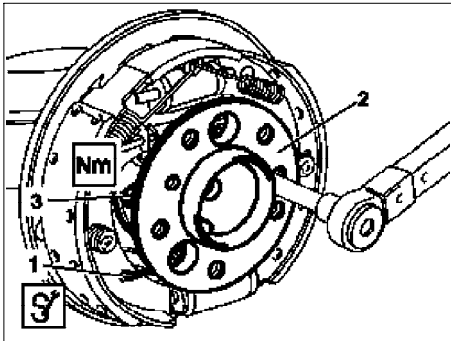


MODELS 460, 461.217 /219 /227 /229 /238 /239 /249 /266 /267 /302 /327 /328 /329 /332 /337 /338 /341 /342 /3 67 /368 /401 /402 /403 /405 /450 /451 /452 /454 /455 /456 /458 /459, 463.200 /204 /207 /208 /220 /221 /224 /225 /227 / 228 /230 /231 /300 /304 /307 /320 /321 /324 /325 /327 /328 with REAR AXLE 741 (except 741.52)
on vehicles with rear drum brakes

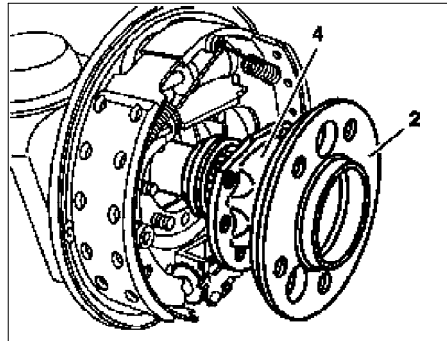
119 Brake drum
122 Security bolt



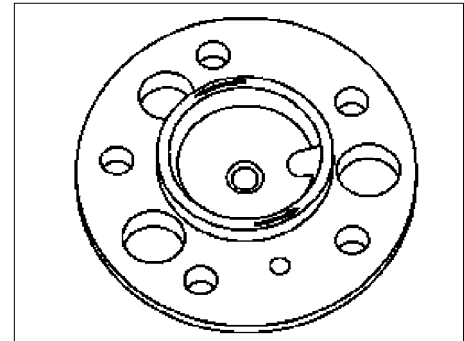
P42.10-0339-01



P35.30-2008-01



P35.30-2011-01














P35.30-2010-01

- 1 Lower return spring
2 Remove/install
3 Securing nuts

- 4 Bearing cap

Arrow Rear halfshaft direction of rotation

	Remove		
1	Remove rear wheel		
	Remove/install wheels, rotate if necessary		AP40.10-P-4050G
2	Unscrew locking bolt (122) at brake drum (119).		
3	Detach brake drum (119)	The parking brake must be disengaged completely. Should it prove impossible to remove the brake drum (119), turn back the automatic adjuster to release the brake shoes. Adjust automatic brake adjuster	AR42.10-P-0169-01GG *BE42.10-P-1001-12A
4	Remove the lower return spring (1) from the brake shoe		*116589016200
5	Unscrew the attachment nuts (3) holding the bearing cover (4) to the axle tube		
6	Pull out rear axle shaft (2)	Use caution to avoid damaging the sensor's reluctor ring on vehicles equipped with an Antilock Braking System (ABS).	
7	Remove gasket between the bearing cap(s) (4) and brake carrier plate		
	Install		
8	Insert gasket between bearing cap(s) and brake carrier plate	Install new gasket.	
9	Install rear axle shaft (2).	The mark indicating the halfshaft's direction of rotation (arrows) must correspond to the actual direction in which the shaft turns when the vehicle is moving forward. If the indicated direction is not correct, substantial axle damage can result. Before sliding into place ensure that the O-ring is mounted on the locating ring.	

10	Screw on the bearing cover attachment nuts (3)	 Tighten the attachment nuts (3) evenly in a cross pattern, continuing until the bearing cover is against the axle tube. Then tighten an additional one half turn to obtain the specified torque, once again working in a cross pattern.  	*BA35.30-P-1004-01C *001589672100
	Check		
11	Check axial play of rear axle shaft	 End float on new rear halfshaft.  End float on rear halfshaft after considerable milage. If it is necessary to replace defective components on the input shaft: Disassemble, assemble rear axle shaft	*BE35.30-P-1001-01A *BE35.30-P-1002-01A AR35.30-P-7351G
12	Install bottom return spring (1) of the brake shoes		*116589016200
13	Install brake drum (119)		
14	Screw lock bolt (122) into brake drum (119)	 Use new locking bolt (122)  	*BA42.10-P-1001-16A *001589512100
15	Remount the rear wheel Remove/install wheels, rotate if necessary		AP40.10-P-4050G
	Adjust automatic brake adjuster		AR42.10-P-0169-01GG
			*BE42.10-P-1001-12A

Inspection data of rear axle drive

Number	Designation	Model 460, 461, 463
BE35.30-P-1001-01A	Axial play of rear axle shaft (new condition)	mm 0.15-0.25
BE35.30-P-1002-01A	Axial play of rear axle shaft (after increased mileage)	mm ≥ 0.5

Test values for drum brake

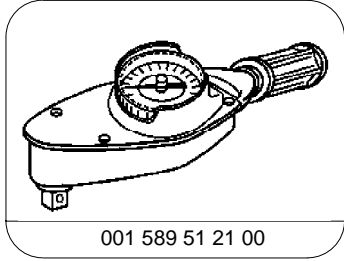
Number	Designation	Model 460, 461, 463
BE42.10-P-1001-12A	Adjustment value for automatic adjuster	Installation Dimension "a" mm 82
		Dimension "b" mm 11
		Fig. see AR42.10-P-0169-01GG

Rear axle shaft

Number	Designation	Model 460, 461, 463 with drum brake
BA35.30-P-1004-01C	Nut securing bearing cap to axle tube	Nm 85

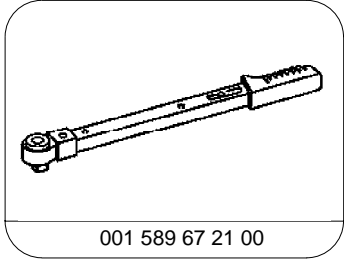
Nm Drum brake

Number	Designation	Model 460, 461, 463
BA42.10-P-1001-16A	Locking bolt, brake drum to wheel hub	Nm 20



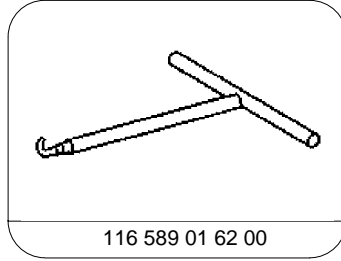
001 589 51 21 00

Torque wrench



001 589 67 21 00

Torque wrench

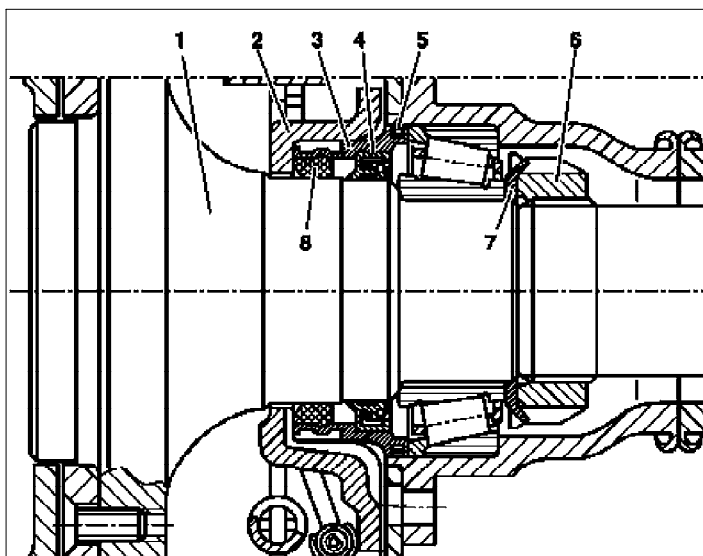


116 589 01 62 00

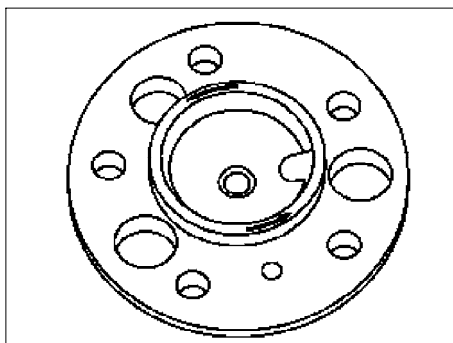
Removal and installation tool

MODELS 460, 461.217 /219 /227 /229 /238 /239 /249 /266 /267 /302 /327 /328 /329 /332 /337 /338 /341 /342 /3 67 /368 /401 /402 /403 /405 /450 /451 /452 /454 /455 /456 /458 /459, 463.200 /204 /207 /208 /220 /221 /224 /225 /227 / 228 /230 /231 /300 /304 /307 /320 /321 /324 /325 /327 /328 with REAR AXLE 741 (except 741.52)
on vehicles with rear drum brakes

- 1 Remove/install
- 2 Bearing cap
- 3 Compressed ring
- 4 Radial seal ring
- 5 O-ring
- 6 Grooved nut
- 7 Locking plate
- 8 Polyurethane sealing ring

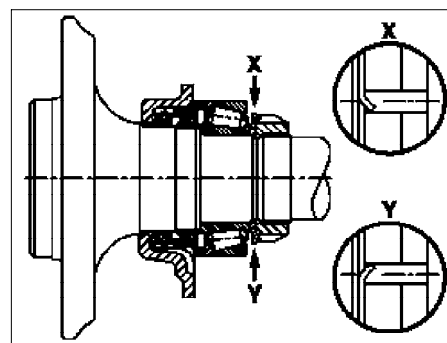


P35.30-2009-11



Arrow Rear halfshaft direction of rotation

P35.30-2010-01



Example Grooved nut

P35.30-2012-01

Modification notes

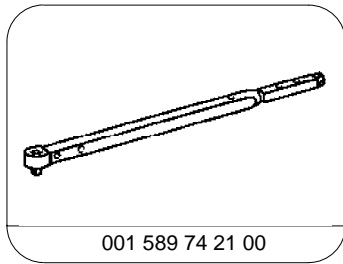
14.8.00	Specification changed from 350 Nm to 500 Nm	Value in BA35.30-P-1002-01C changed for model 460, 461, 463 with drum brake	*BA35.30-P-1002-01C
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Icon	Remove		
1	Remove rear axle shaft (1)		AR35.30-P-0620G
Icon	Dismantling		
2	Clamp rear axle shaft (1) before disassembling	i Use caution to avoid damaging the reluctor ring on vehicles equipped with Antilock Braking System (ABS). Screw in two lug bolts, then clamp these in a vise.	
3	Unlock and unscrew grooved nut (6)	i The grooved nut (6) with a milled groove has a left-hand thread. W	*460589010700
4	Remove locking plate (7)		
5	Press the tapered roller bearing, bearing cover (2), radial oil seal (4) and locating ring (3) from the rear halfshaft (1)	i The locating ring (3) is part of a single assembly including the cellular polyurethane ring (8) and the radial oil seal (4). W	*460589013500
Icon	Assembling		
6	Slide the bearing cover (2) and locating ring (3) onto the rear halfshaft (1)	i Fill the space between the dust seal and the extruded edge seal with grease, apply a light coat of grease to the cellular polyurethane ring (8).	*BR00.45-Z-1001-06A

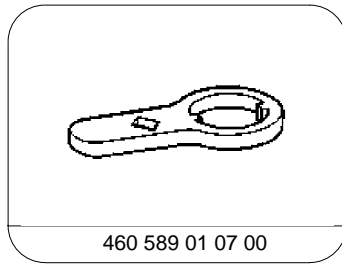
7	Press the tapered roller bearing onto the rear halfshaft (1)	<p>ⓘ The L-shaped edge of the bearing's race should be installed toward the locating ring (3). Failure to install in this position will lead to unacceptable changes in the factory-specified bearing float.</p> <p>ⓘ Start by warming the tapered roller bearing to approximately 80 °C.</p>	
8	Apply a light coat of grease to the O-ring (5) and place it against the locating ring (3)		*BR00.45-Z-1001-06A
9	Grease tapered roller bearing		*BR00.45-Z-1001-06A
10	Position locking plate (7)	ⓘ Replace locking plate (7).	
11	Screw on grooved nut (6)	<p>ⓘ Use caution to avoid damaging the reluctor ring on vehicles equipped with Antilock Braking System (ABS). The grooved nut (6) with a milled groove has a left-hand thread.</p> <p>Nm</p> <p>⚙</p> <p>⚙</p>	<p>*BA35.30-P-1002-01C</p> <p>*001589742100</p> <p>*460589010700</p>
12	Lock grooved nut (6) at both grooves using locking plate (7)	ⓘ When locking the grooved nut (6) ensure that the assembly will be locked in both directions of rotation (refer to arrows on the halfshaft and to the illustration above).	
13	Install rear axle shaft (1)		AR35.30-P-0620G

Nm Rear axle shaft

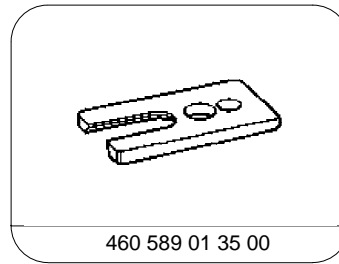
Number	Designation	Model 460, 461, 463 with drum brake
BA35.30-P-1002-01C	Grooved nut to rear axle	Nm 500



Torque wrench



Prong wrench



Mounting plate

Auxiliary repair materials

Number	Designation	Order number
BR00.45-Z-1001-06A	MB long-life grease	000 989 63 51