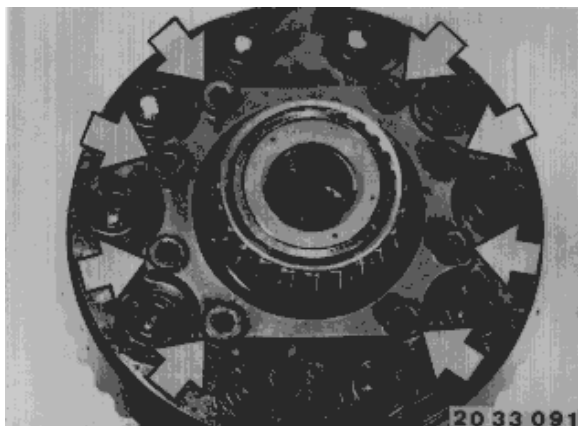
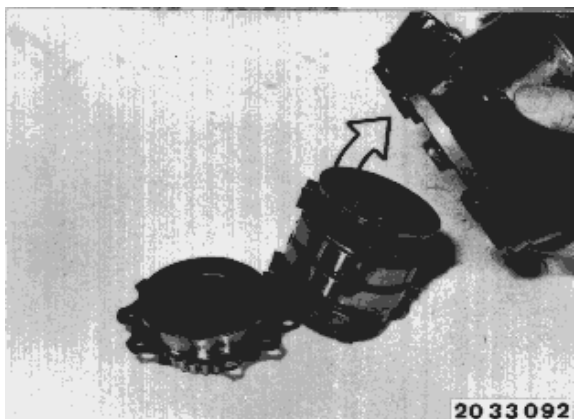


Removing limited-slip differential,
refer to Replacing complete limited-slip differential
33 14 520



Unscrew case cover mounting bolts.
Take off case cover.



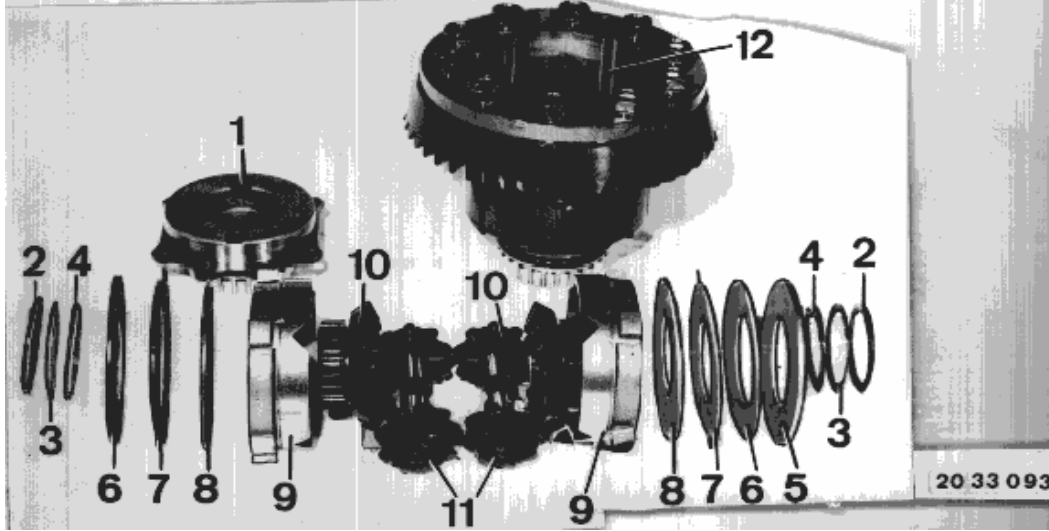
Carefully allow components to slide out of housing.

Installation:

Check all parts for wear, e.g. molybdenum coating, gear and spline teeth.

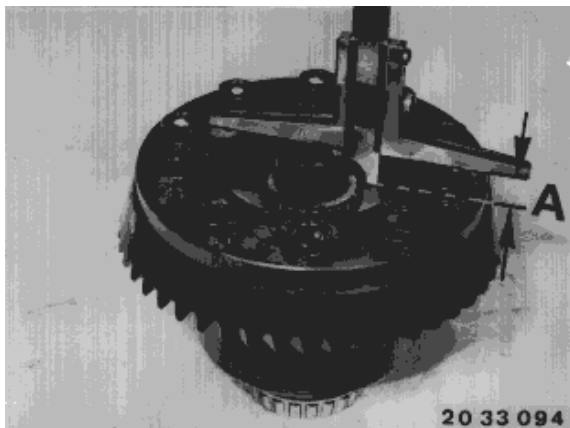
Installation:

Lubricating all parts before assembly with approved grade of final drive oil.



- 1 Housing cover
- 2 Thrust washer
- 3 Plate spring
- 4 Lug disc
- 5 Spacer
- 6 Plate spring

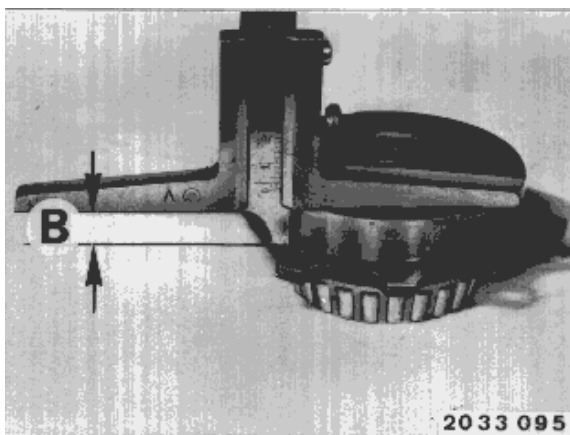
- 7 Outer disc
- 8 Inner disc
- 9 Compression ring
- 10 Differential side gear
- 11 Differential gears with differential shafts
- 12 Differential housing



Install following parts in correct installed order to measure the preload:

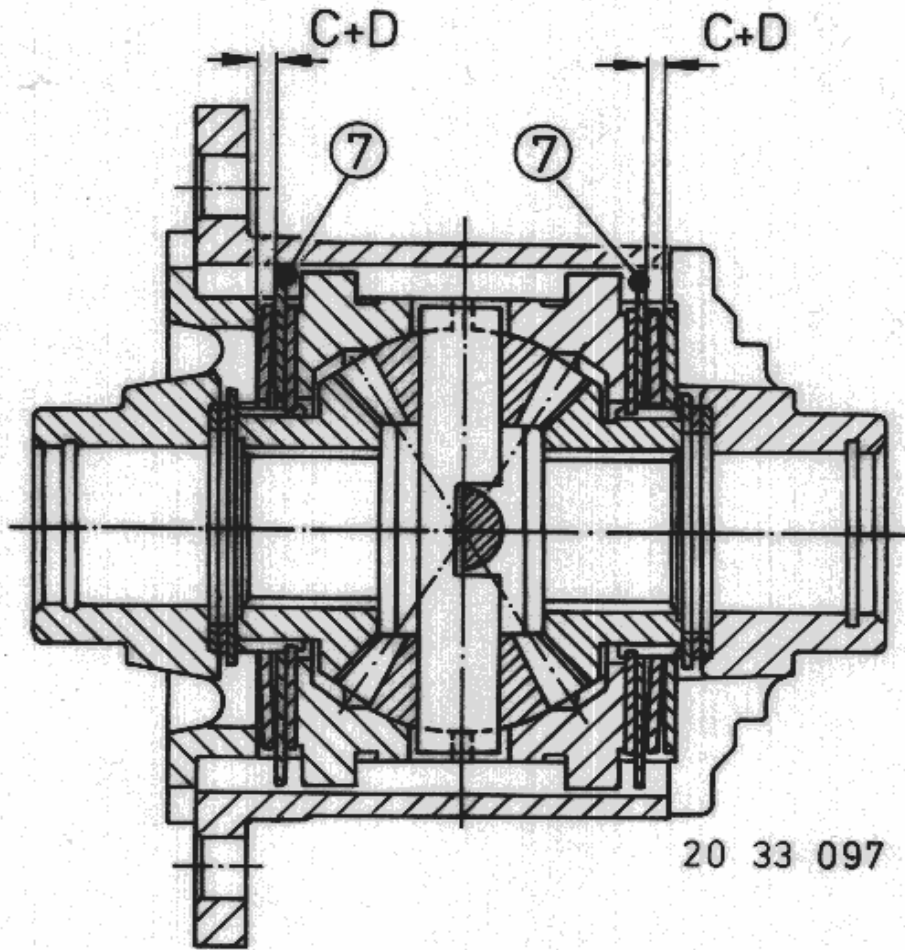
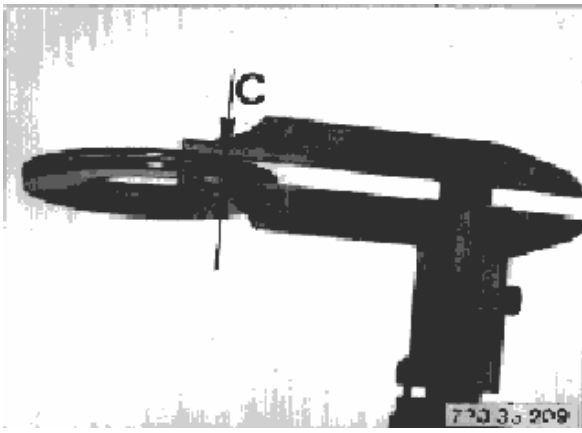
Spacer disc (5), outer discs (7), inner discs (8), compression rings (9), rear axle shaft gears (10) and differential bevel gears and differential shafts (11).

Measure dimension A from edge of housing to outer disc, e.g. A = 19.5 mm.



Measure dimension B on cover, e.g. B = 14.4 mm.

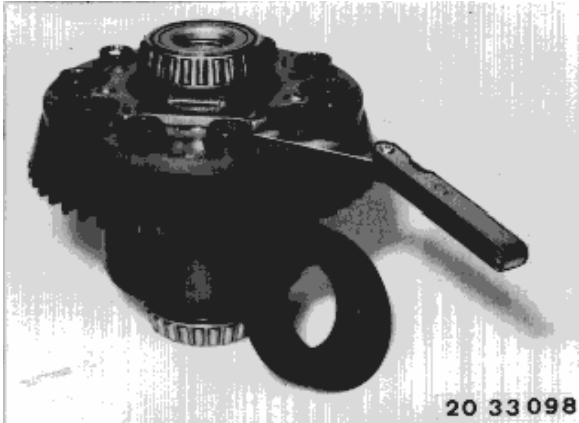
Place both diaphragm spring curved surfaces together.
Measure dimension C on the plate springs, e.g. C = 4.8 mm.



To ensure that the plate springs are not block-preloaded,
installation clearance of 0.1 ... 0.4 mm is required.

B (cover)	14.4 mrr
C (plate spring)	4.8 mm
A (housing)	19.2 mrr
Total of B + C	19.2 mrr
Installation clearance D	0.3 mm

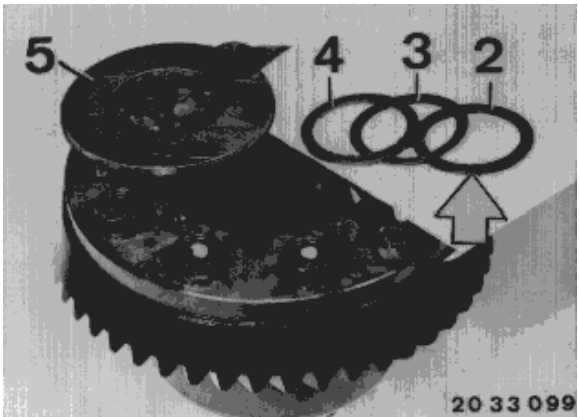
Correct any deviation in installed clearance D by installing outer plates of correct thickness.



Remove all parts from the housing and install with additional parts: thrust washers (2), plate springs (3) and lug discs (4). Mount case cover (12) and press on firmly, but do not bolt.

The preload on the small plate spring (3) should create an even gap all round (check with feeler gauge).

If there is no gap between cover and housing, check plate springs (3), thrust washers (2) and lug discs (4).

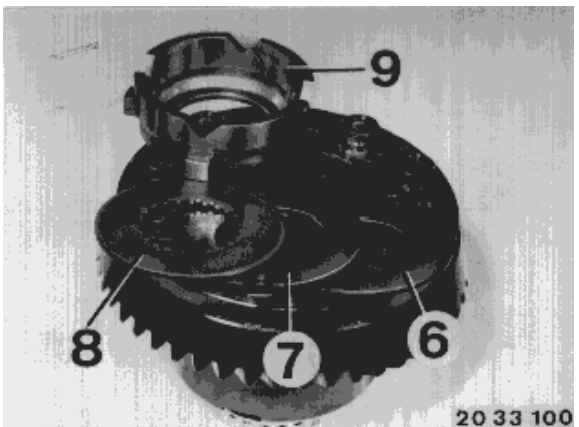


Installation:

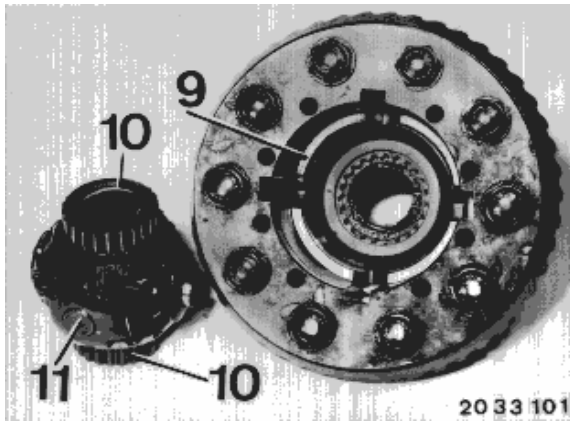
Thrust washer (2), with oil pockets facing the housing (downwards).

Diaphragm spring (3) with inside curved surface facing differential shaft (up).

The smooth side of the lug disc (4) faces the plate spring (downwards), the lug engages in the guide in the housing.

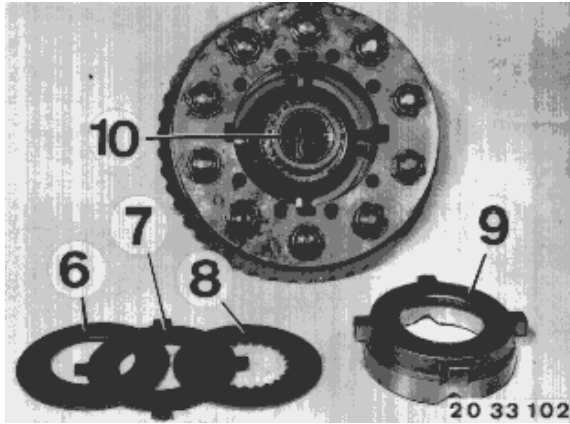


Install spacer disc (5), plate spring (6) with internal bulge facing differential shaft, outer disc (7) with the 4 lugs, then insert molybdenum-coated inner disc (8).



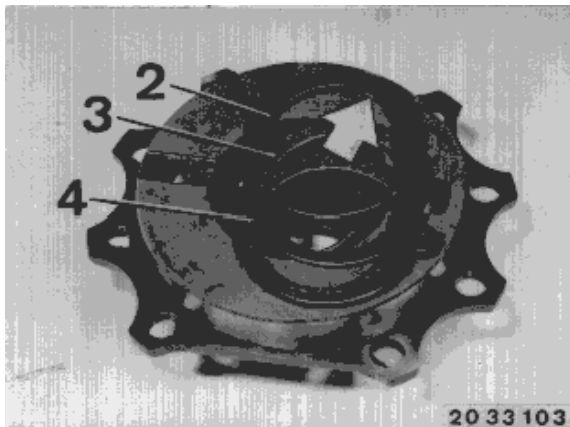
Install compression ring (9) and differential side gear (10) by twisting into the guide and/or spline of the inner disc.

Installing differential gears with shafts (11), second differential side gear (10) and compression ring (9).



Installing molybdenum-coated inner disc (8) and outer disc (7).

Insert diaphragm spring (6) with inside curved surface facing differential shaft (down).



Install thrust washer (2) with oil packet facing cover, plate spring (3) with inner bulge facing outwards and lug disc (4) with smooth side facing plate spring and lug in groove of housing cover with grease in housing cover.

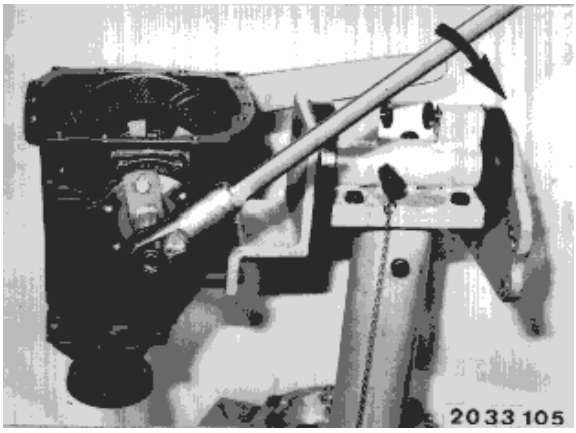


Fit housing cover with washers (do not allow lug disc to slide out of groove).

Install screws with Loctite No. 270 and tighten down cover evenly.

Installation:

For tightening torque, refer to Technical Data



Check slip torque, refer to Technical Data of limited slip differential at (a) stationary and (b) driven differential side gear.

Make up tool locally for this purpose by, for example, welding a nut on a drive flange which is no longer required.