

## 46–510 Removal and installation of pitman arm

### Data


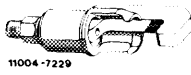
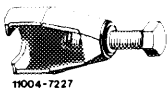
| Part no.      | Version | Code no. | Remarks  |
|---------------|---------|----------|--|
| 123 463 41 01 | LL      | 2341     | 1st version<br>for manual steering<br>(with stop lug)  |
| 123 463 42 01 | RL      | 2342     |  |
| 123 463 48 01 | LL      | 2348     | 2nd version for manual steering, with stop<br>lug, changed ball point location and<br>replacement for 123 463 41 01 and<br>123 463 42 01 |
| 123 463 49 01 | RL      | 2349     |  |
| 123 463 44 01 | LL      | 2344     | 1st version<br>for power steering<br>(with stop lug)   |
| 123 463 45 01 | RL      | 2345     |  |
| 123 463 50 01 | LL      | 2350     | 2nd version for power steering<br>(without stop lug, changed<br>ball point location)   |
| 123 463 51 01 | RL      | 2351     |  |
| 123 463 55 01 | LL      | 2355     | 3rd version for power steering, with stop<br>lug, changed ball point location and<br>replacement for 123 463 50 01/51 01                 |
| 123 463 56 01 | RL      | 2356     |  |

### Tightening torques

Nm

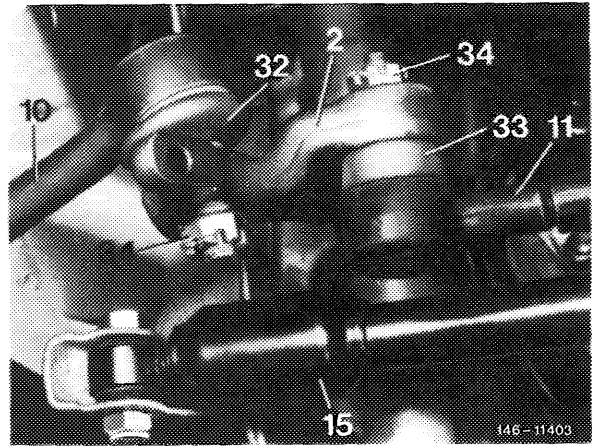
|   |   |         |
|---|---|---------|
| Self-locking hex. nut on steering<br>shaft (pitman shaft)         | manual steering<br>1st version<br>(steering shaft (pitman<br>shaft) dia. 30 mm)                   | 140–180 |
|   | manual steering<br>2nd version<br>(steering shaft (pitman<br>shaft) dia. 32 mm)<br>power steering | 160–200 |
| Castle nut or self-locking hex. nut<br>on track rod and drag link |   | 35      |

### Special tools

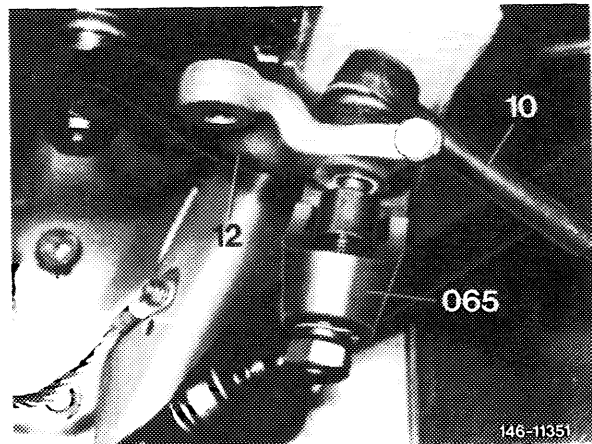
|   |   |                  |
|---|---|------------------|
| Puller for ball joint of track rod<br>on pitman arm | <br>11004-7226 | 186 589 10 33 00 |
| Puller for ball joint of drag link<br>on pitman arm | <br>11004-7229 | 123 589 09 33 00 |
| Puller for pitman arm                               | <br>11004-7227 | 100 589 04 33 00 |

## Removal

1 Unscrew castle nut of drag link and track rod on pitman arm. Unscrew castle nut or self-locking hex nut.



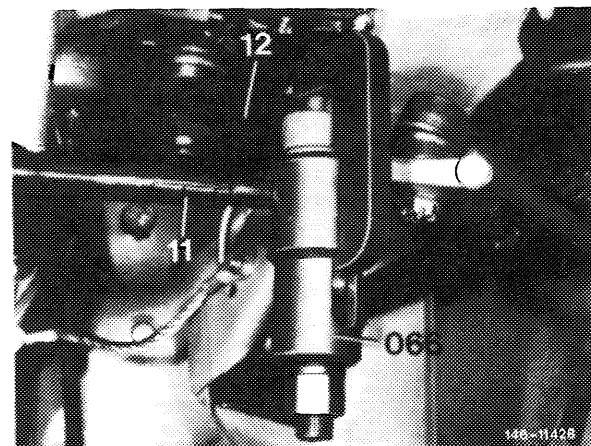
2 Force ball joint of track rod (10) from pitman arm by means of puller (065).



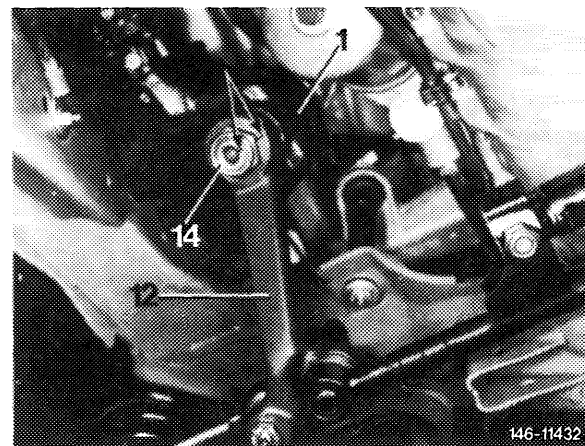
3 Force ball joint of drag link (11) from pitman arm by means of puller (066). On 1st version of drag link, pay attention to plastic cover ring and sealing washer.

**Note:** To prevent damaging rubber sleeve on drag link 2nd version, force-off drag link with modified puller 123 589 09 33 00 only.

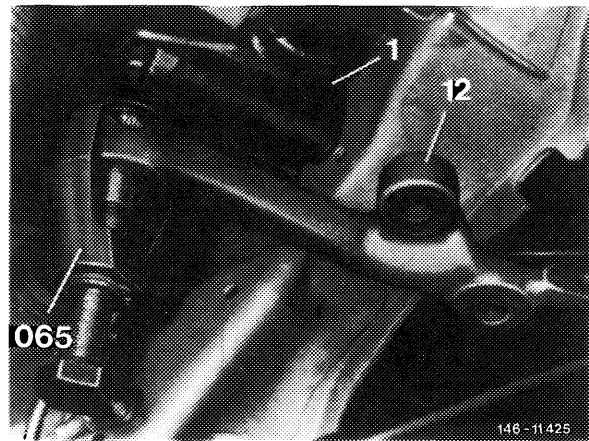
Use puller 123 589 00 33 00 only if the puller bell has been refinished.



4 Unscrew self-locking hex nut (14) from pitman shaft.



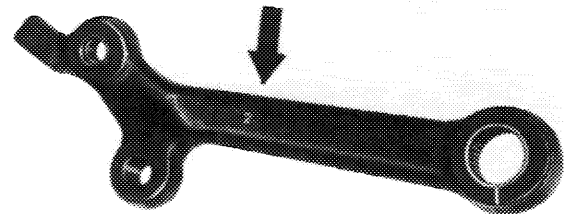
5 Pull pitman arm (12) from pitman shaft by means of puller (065).



### Installation

6 The pitman arm cannot be checked with conventional workshop tools. **When in doubt**, particularly following an accident, replace **pitman arm**.

Pay attention to correct code number (arrow) of pitman arm.



146 - 11417

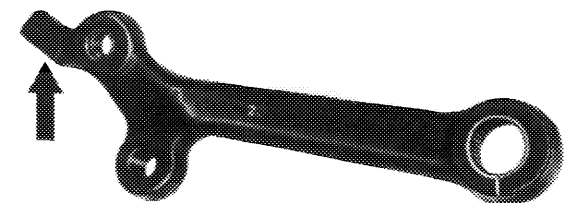
#### Note:

a) Pitman arm 1st version (with stop lug) for:

Manual steering, code No. 2341 lefthand steering/  
2342 righthand steering

Power steering, code No. 2344 lefthand steering/  
2345 righthand steering

Ball point position =  $117 \begin{matrix} + 4.5 \\ - 2.5 \end{matrix}$



146 - 11417/1

b) Pitman arm 2nd version (with stop lug) for:

Manual steering, code No. 2348 lefthand steering/  
2349 righthand steering

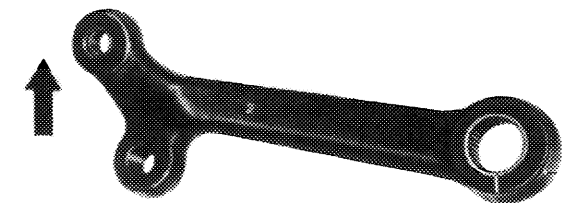
Ball point position =  $121 \begin{matrix} + 4.5 \\ - 2.5 \end{matrix}$

c) Pitman arm 2nd version (without stop lug) for:

Power steering with inside stop, code No.: 2350  
lefthand steering/2349 righthand steering

Ball point position =  $121 \begin{matrix} + 4.5 \\ - 2.5 \end{matrix}$

This pitman arm may be installed only if the steering is marked with an "A" = stop in steering housing.



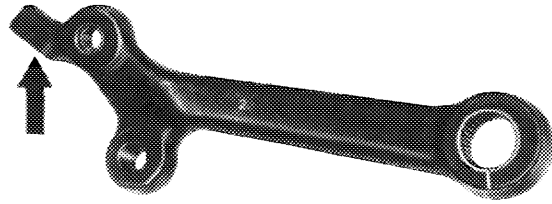
146 - 11417/2

d) Pitman arm 3rd version (with stop lug) for:

Power steering with inside stop, code No.: 2355  
lefthand steering/2356 righthand steering

Ball point position =  $121 \begin{matrix} +4.5 \\ -2.5 \end{matrix}$

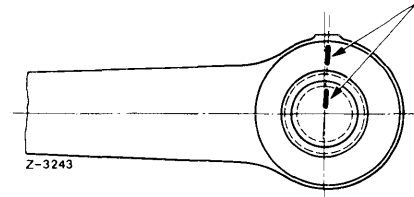
This pitman arm replaces lever 2nd version without stop lug.



146-11417/1

7 Clean splining on pitman shaft and on pitman arm.

8 Slip pitman arm on pitman shaft, mark on arm should be in alignment with mark on pitman shaft.



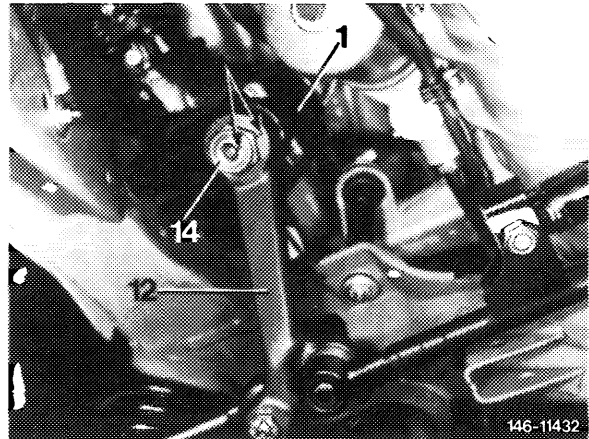
9 Screw new self-locking hex. nut (14) on steering shaft (pitman shaft) and tighten as follows:

Manual steering, steering shaft (pitman shaft)  
dia. 30 mm = 140–180 Nm

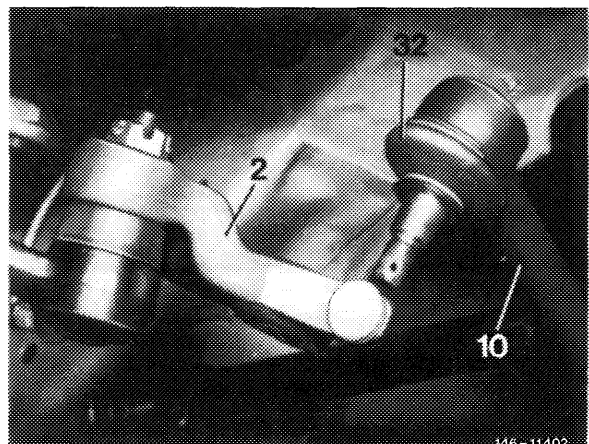
Manual steering, steering shaft (pitman shaft)  
dia. 32 mm and power steering 160–200 Nm

**Attention!**

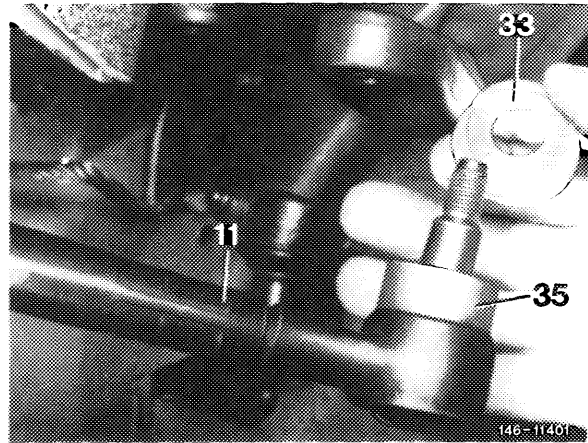
**Always replace self-locking hex. nuts on principle.**



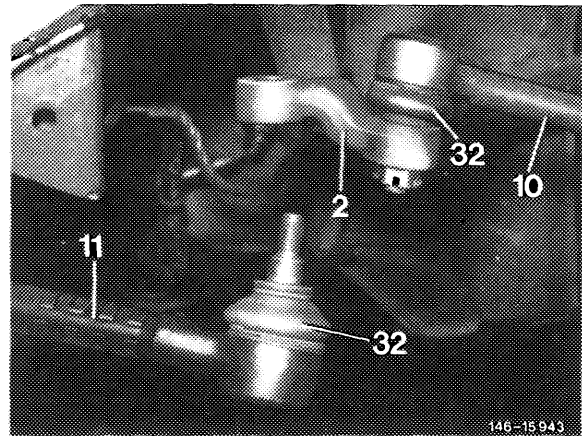
10 Check rubber sleeve (32) on joint of track rod.  
If sleeve is damaged, check joint for wear and replace,  
if required (46–540).



11 With drag link 1st version, check joint of drag link for wear and replace drag link, if required. Place sealing ring (35) and plastic cover (33) on ball joint (46–550).



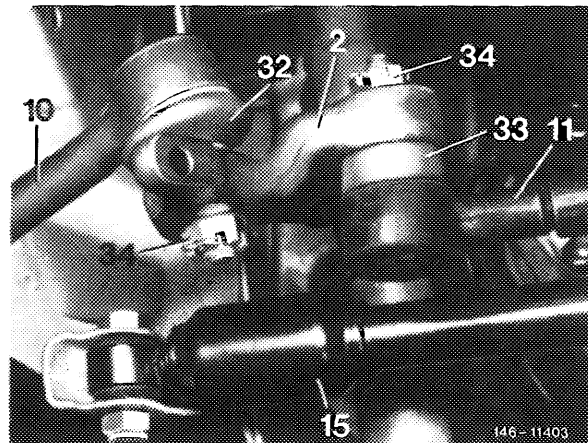
12 With drag link 2nd version, check rubber sleeve (32) on joint. If sleeve is damaged, check joint for wear and replace, if required (46–550).



13 Fasten track rod and drag link to pitman arm. Tightening torque 35 Nm – reference value.

**Note:** The track rod 1st and 2nd version is fastened to pitman arm by means of a castle nut and locked by a cotter pin. The 3rd version is fastened by means of a self-locking hex. nut.

The self-locking hex. nut must be replaced on principle.



14 On vehicles with manual steering and power steering 1st version check permissible steering lock, while measuring reference dimension "a" between pitman arm and intermediate steering arm and stop bracket on frame cross member (40–320).

**Note:** At max. steering lock on vehicles with manual steering and power steering 1st version, the respective arm should rest against stop bracket of frame cross member. On vehicles with power steering 2nd and 3rd version the stop is in steering housing.

15 Check wheel adjustment on front axle (40–320).

