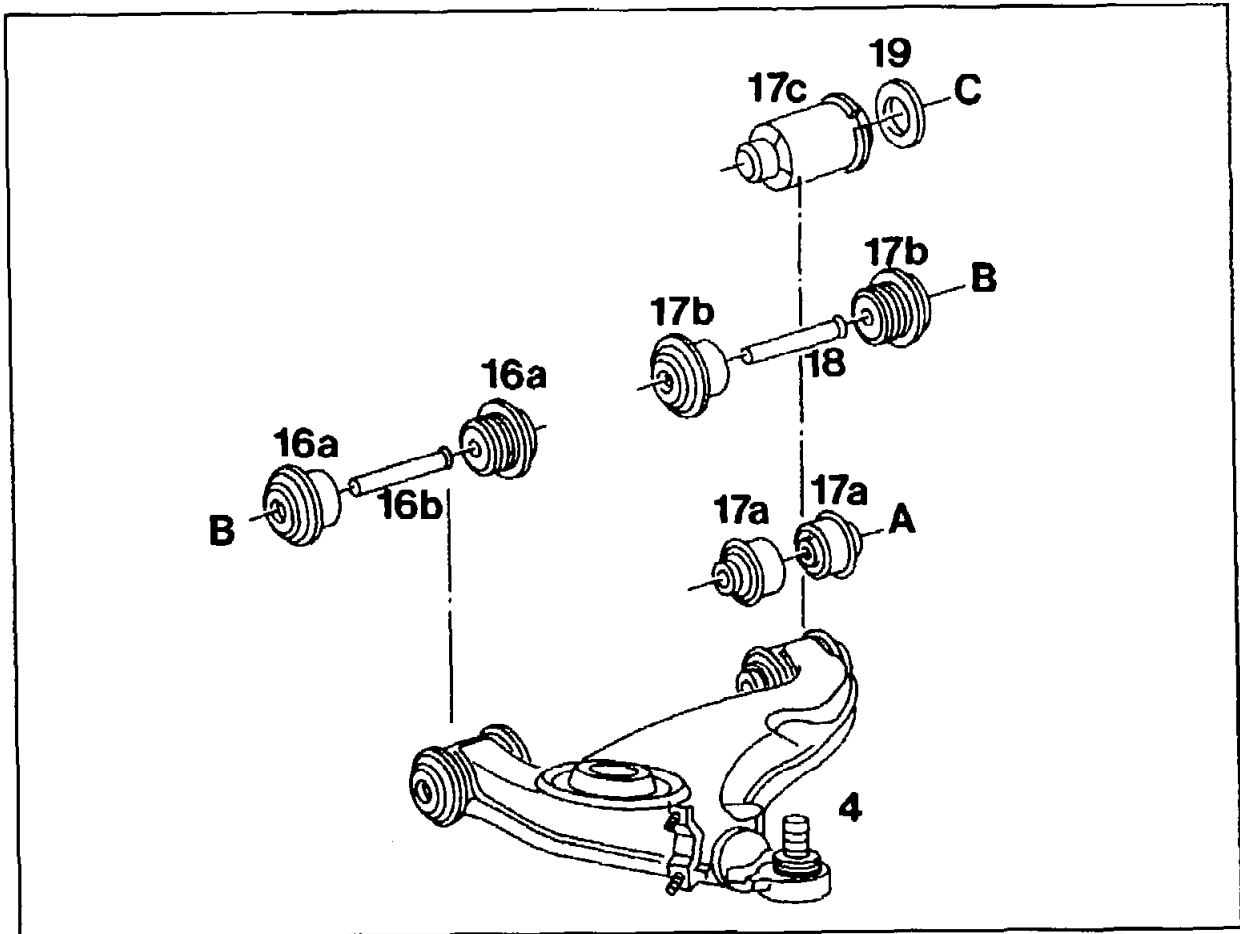


33-0526 Replacing control arm mounting

Preceding work:
Removing and installing control arm (33-0510)



P33-5120-57

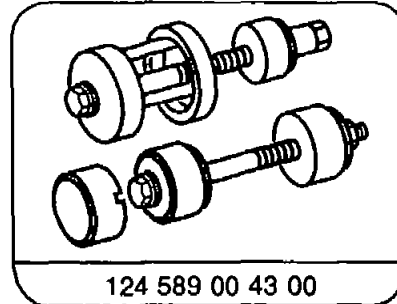
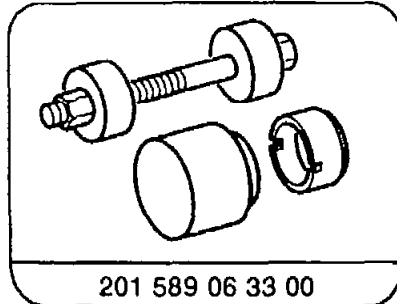
- A: Two-piece mounting (17a) without clamping sleeve
- B: Two-piece mounting (16a or 17b) with clamping sleeve (16b or 18)
- C: Single mounting (17c) with washer (19)

Lubricant

Naftolen fluid

Part no. 000 989 14 60

Special tools

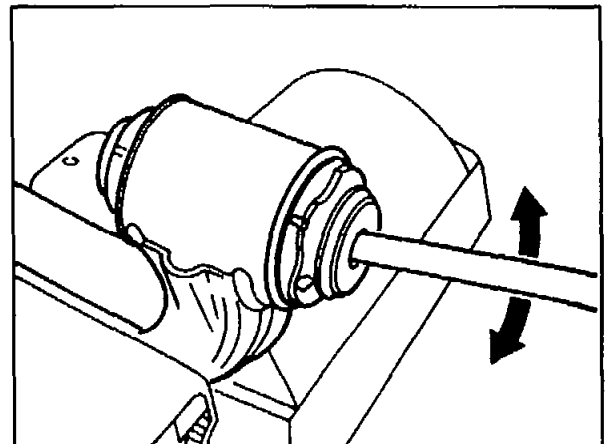


A. Two-piece mounting without clamping sleeve

(Installed in models 201.019/022/023/024/122/126)

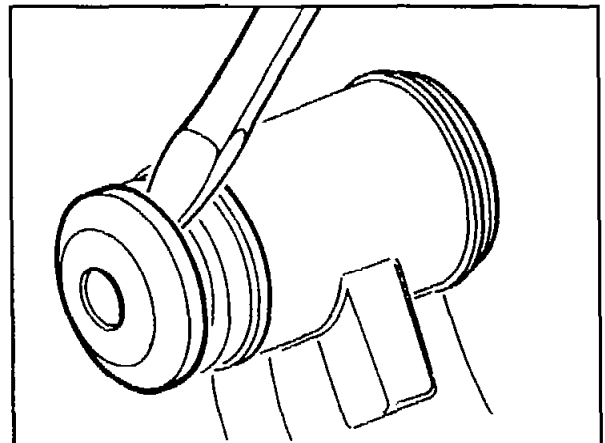
Removing

- 1 Clamp control arm in a vise (use light alloy clamping jaws).
- 2 Loosen rubber mount by rocking back and forth in control arm and remove.



Note

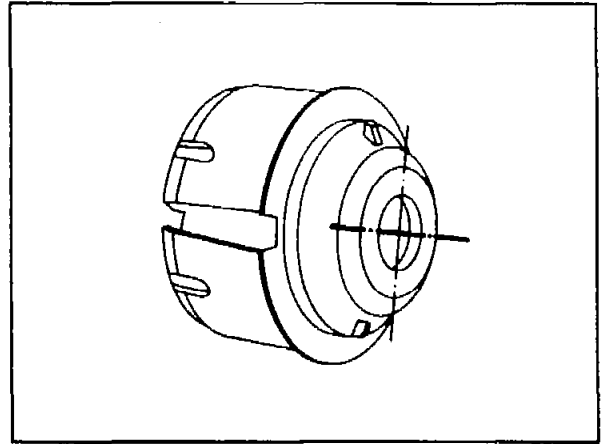
If the rubber mounts are too tightly seated, first loosen one rubber mount on the steel case using a flat chisel. Then drive out the second rubber mount on the inner sleeve from the inside using a drift.



Installing

3 Thoroughly clean mounting bore for rear mounting in control arm. Rub down with emery cloth if necessary.

4 Insert puller (012) 201 589 06 33 00 together with the two rubber mounts in the mounting bore in the control arm.

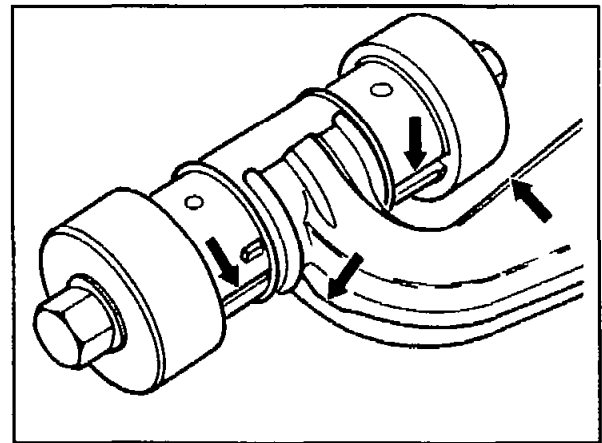


P33-5122-13

Note

Align the rubber mounts so that the slot in the steel case (arrows) points towards the weld seam on the two halves of the control arm housing (arrows).

5 Use puller (012) to draw in rubber mount as far as it will go.



P33-5131-13

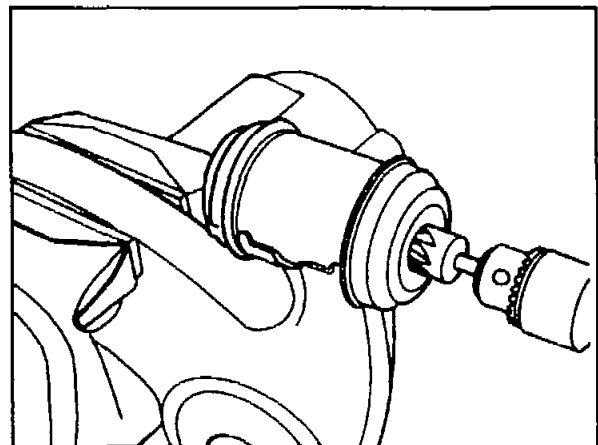
B. Two-piece mounting with clamping sleeve

(Installed in model 201 at the front and models 124, 129 and 201.03 at front and rear)

Removing

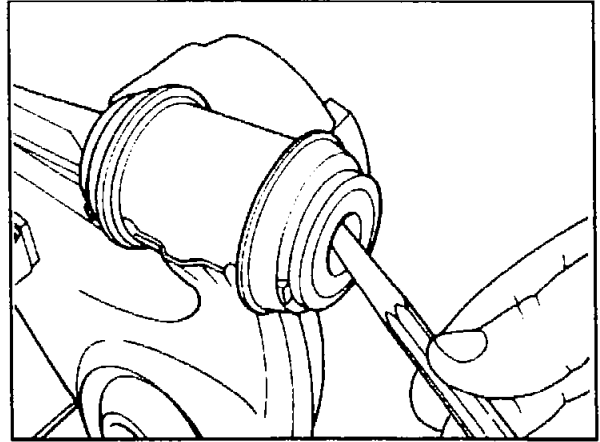
1 Clamp control arm in a vise (use light alloy clamping jaws).

2 Countersink flared rim of clamping sleeve with a countersink (dia. 25 mm, 90°).



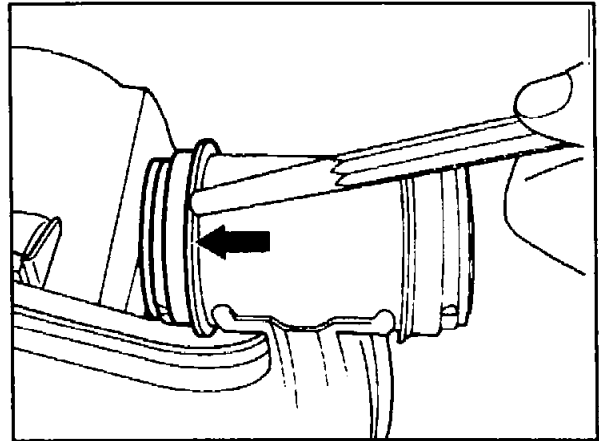
P33-2035-13

3 Drive out clamping sleeve. If tightly seated, drill out clamping sleeve halfway.



P33-2036-13

4 Drive rubber mount out of control arm using a suitable drift.



P33-2037-13

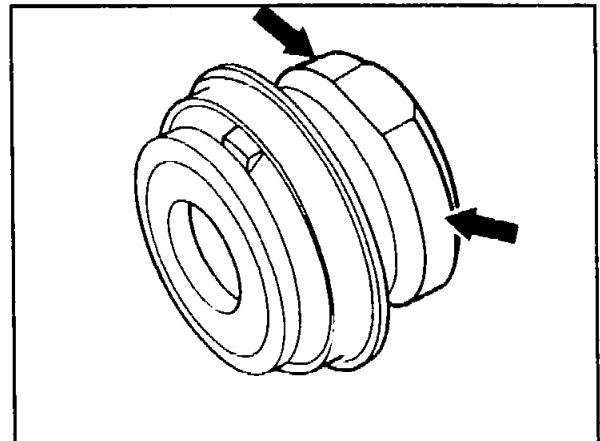
Installing

5 Thoroughly clean mounting bore for rear mounting in control arm. Rub down with emery cloth if necessary.

6 Coat circumference (arrow) of rubber mount and mounting bore in control arm with lubricating fluid, e.g. Naphtolen or soft soap.



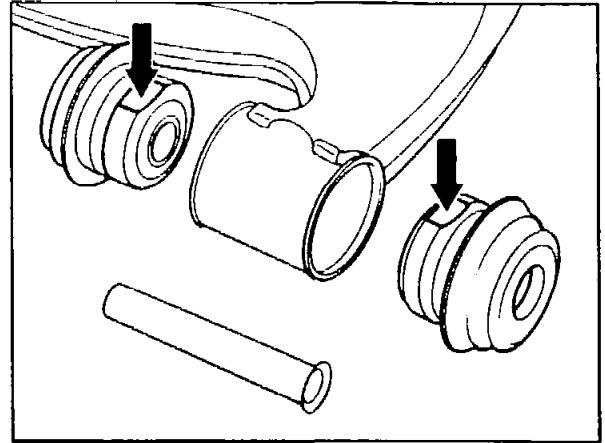
Do not use oil or grease.



P33-2043-13

**Installed position of rubber mounts
Model 201 (front mounting) and models 124
and 129 (rear mounting)**

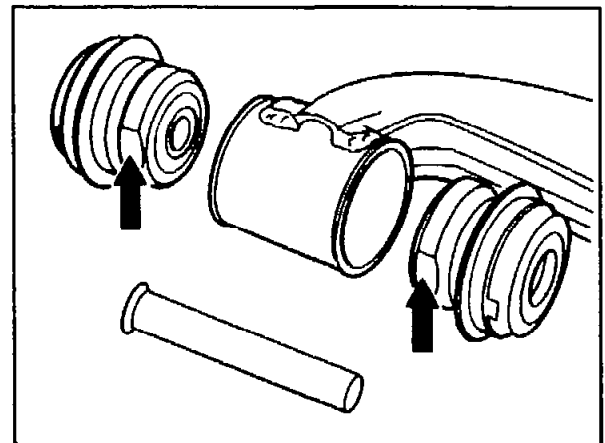
7 Install the rubber mounts so that the flats (arrows) are vertical.



P33-2053-13

**Installed position of rubber mounts
Models 124 and 129 (front mounting) and
model 201.03 (rear mounting)**

8 Install the rubber mounts so that the flats (arrows) on the front mounting are horizontal.

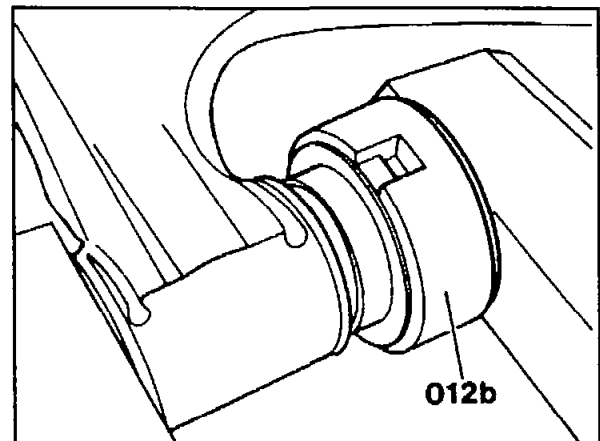


P33-2054-13



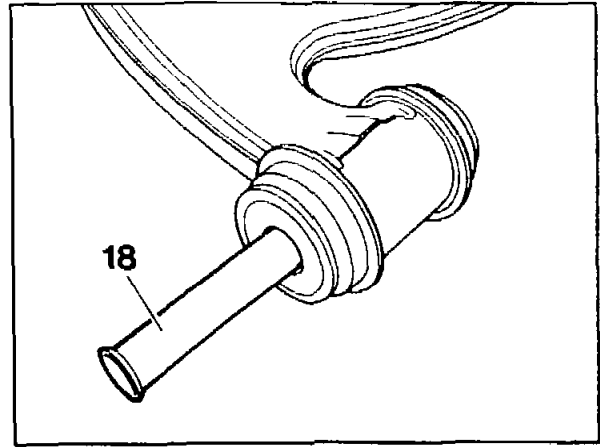
- Correct installed positions are absolutely essential
- Only replace rubber mounts in complete pairs
- Only install the same type of rubber mount (the Shore hardness of the rubber mount is determined by the number and shape of the lugs).

9 Individually press rubber mounts into control arm in a vise while ensuring that the lugs of the rubber mounts engage in the recess of the thrust piece (012b).



P33-2032-13

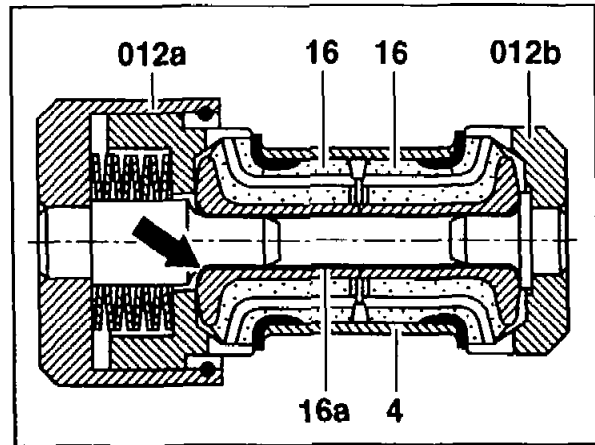
10 Insert clamping sleeve (18).



P33-5189-13

11 Attach puller 201 589 06 33 00 so that the thrust piece (012b) on the closed side and the unflared side of the clamping sleeve point towards the housing (012a) (arrow). Clamp in a vise and press together as far as they will go.

- 4 Control arm
- 16 Rubber mount
- 16a Clamping sleeve
- 012a Housing
- 012b Thrust piece

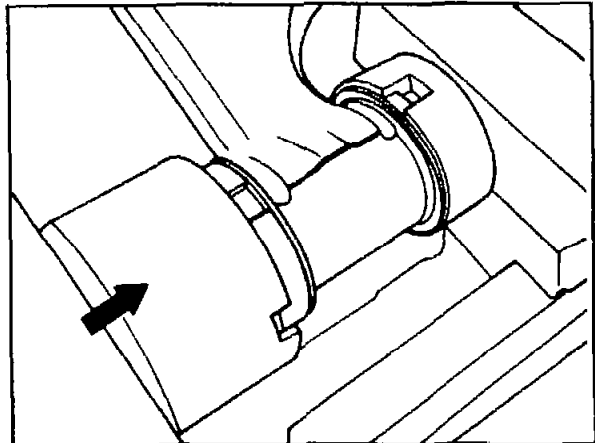


P33-0023-13

Note

The clamping sleeve is flared during the tightening process.

12 Check that rubber mount and clamping sleeve are perfectly seated against the contact surfaces.



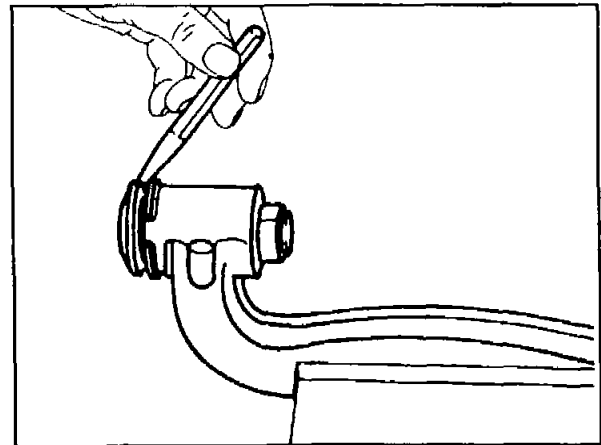
P33-2039-13

C. Single mounting with washer

(Installed in models 201.028/029/128)

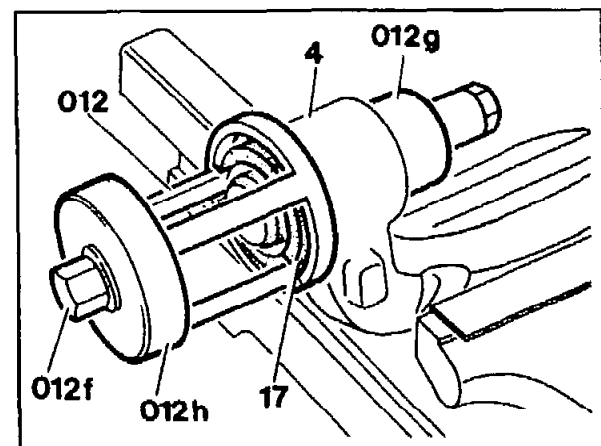
Removing

- 1 Clamp control arm in a vise (use light alloy clamping jaws).
- 2 Drive off washer.



P33-5132-13

- 3 Attach extractor (012) 124 589 00 43 00.
- 4 Pull out rubber mount and remove tool.



- 4 Control arm
- 17 Torsion rubber mount
- 012f Clamping screw
- 012g Thrust piece with nut
- 012h Thrust piece

P33-2132-13

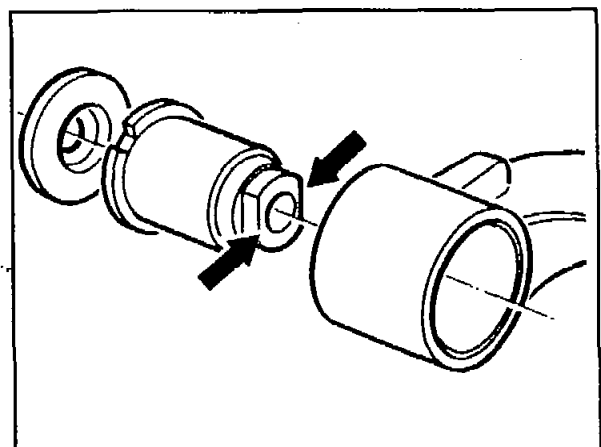
Installing

- 5 Thoroughly clean mounting bore for rear mounting in control arm. Rub down with emery cloth if necessary.

- 6 Insert rubber mount into control arm from the rear (viewed in the direction of travel).

Note

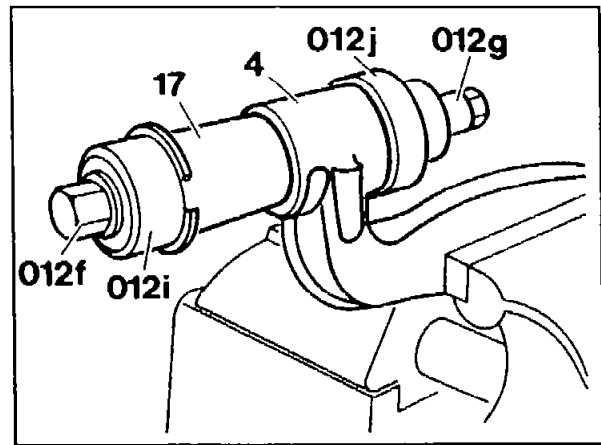
The two flats of the aluminium core (arrows) must be vertical when the control arm is installed.



P33-2133-13

7 Attach puller 124 589 00 43 00 with thrust piece (012i) and pull rubber mount into control arm as far as it will go.

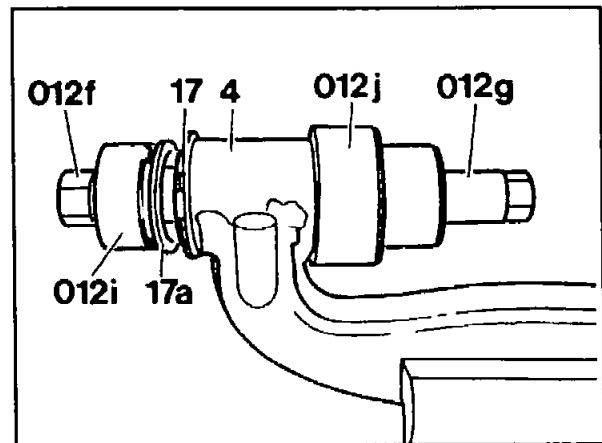
- 4 Control arm
- 17 Torsion rubber mount
- 12f Clamping screw
- 12g Thrust piece with nut
- 12i Thrust piece (with 3 pins)
- 12j Thrust piece



P33-5133-13

8 Fit washer (17a) onto aluminium core of rubber mount (17) and pull in as far as it will go using the puller.

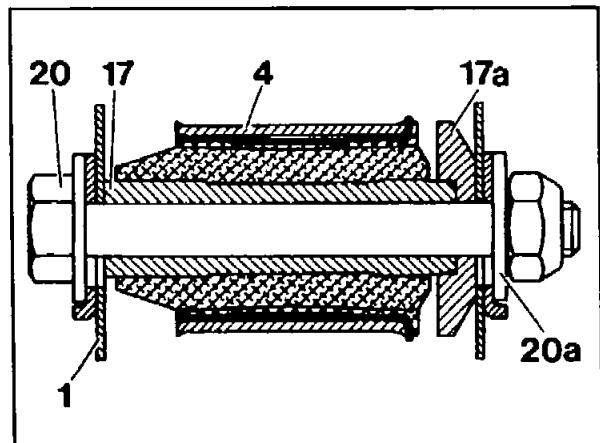
- 4 Control arm
- 17 Torsion rubber mount
- 12f Clamping screw
- 12g Thrust piece with nut
- 12i Thrust piece (with 3 pins)
- 12j Thrust piece



P33-5134-13

9 Remove puller and check that rubber mount and washer are correctly seated in the control arm.

- 1 Frame side member
- 4 Control arm
- 17 Torsion rubber mount
- 17a Washer
- 20 Eccentric bolt (caster adjustment)
- 20a Eccentric washer



P33-5190-13