

7.2 Mounting the bellows (124)

As an assembly aid, spread the bearing surfaces of the bellows (124) with grease. Slide the bellows (124) onto the tie rod (131) (**Fig. 35**).

7.3 Versions without an additional tie rod (131) securing device

Using tool [1], screw the tie rod (131) in; at the same time support the rack (3) at its spanner flat.

If the rack (3) does not have a spanner flat, the rack teeth can also be clamped in a vice (with soft jaws) to serve the purpose of supporting the rack.

Tightening torques:	Types 7830/7831/7832:	80±8 Nm	(M14x1.5/M16x1.5)
	Type 7852:	100±10 Nm	(M14x1.5/M16x1.5)

7.4 Versions with locking collar

Screw the tie rod (131) in, using tool [1], and at the same time support the rack (3) at its spanner flat.

If the rack (3) does not have a spanner flat, the rack teeth can also be clamped in a vice (with soft jaws) to serve the purpose of supporting the rack.

Tightening torques:	Types 7830/7831/7832:	80±8 Nm	(M14x1.5/M16x1.5)
	Type 7852:	100±10Nm	(M14x1.5/M16x1.5)

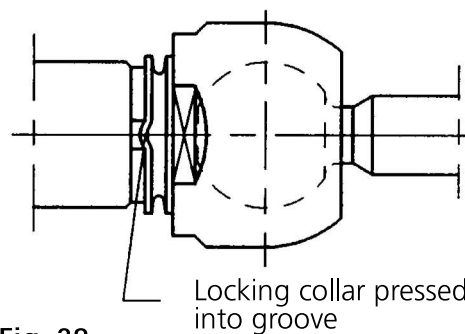


Fig. 38

Press the locking collar into the groove (**Fig. 38**).



Attention:

Material that had already been deformed during first peening may not be pressed into the groove again.

To avoid this, continue to screw the tied rod (131) in until an unpeened material can be pressed in.

7.5 Fastening the bellows (124)

Fasten the bellows (124) with the hose clips (123.1) (**Fig. 35**).