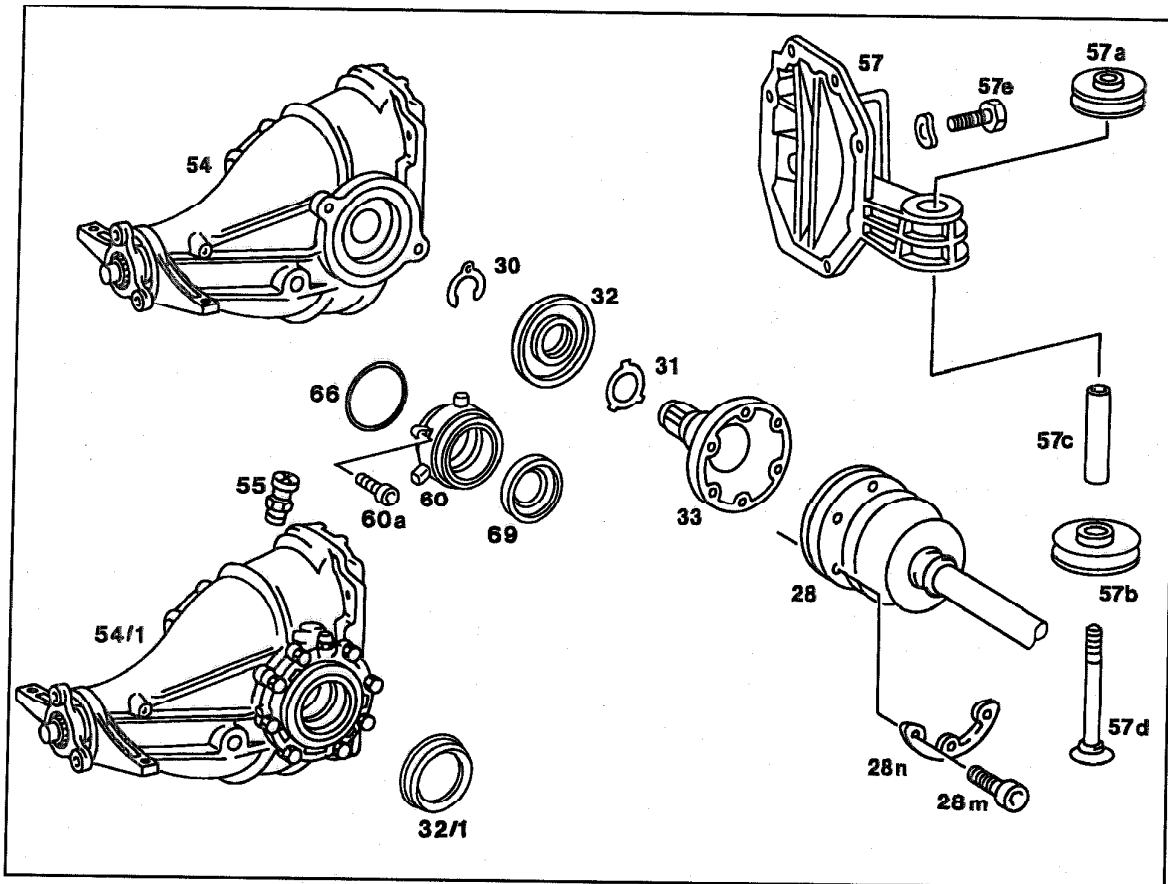


## 35-670 R and R rear axle shaft flange with differential housing installed



P35-0084-57

- Rear axle oil ..... drain and fill up to oil fill bore. Refer to factory approved service products list 1).
- Rear axle shaft (28) ..... disconnect at connection flange (33), install. Replace retaining bolts (28m) and washers (28n), M10 = 70 Nm, threads and bolt head contact surface oiled.  
M12 = 125-145 Nm.  
Torque wrench 001 589 66 21 00  
Press rear axle shaft together in axial direction and tie to rear spring with wire.
- Rear axle differential housing (54) ..... support.

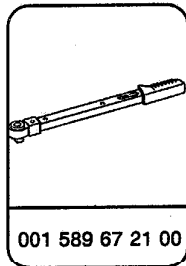
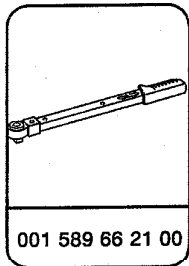
1) Supplied with owner's literature or available through your local authorized Mercedes-Benz Dealer.

## 35-670 R and R rear axle shaft flange with differential housing installed

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Roar differential housing mount (57a-d) .....	screw off, screw on. Replace self-locking retaining bolts (57d), 110 Nm (step 5).
End cover (57) .....	screw off, screw on. Clean sealing surfaces and coat with sealant. Hex. head bolts, strength class 8.8 = 45 Nm, 10.9 = 50 Nm.
Retaining ring (30) .....	remove, install and replace.
Connection flange (33) .....	pull off, install. Check axial play (steps 9, 10).

### Special tools



### Note

Clean rear axle housing thoroughly in area of bearing cap to prevent dirt from getting into rear axle housing.

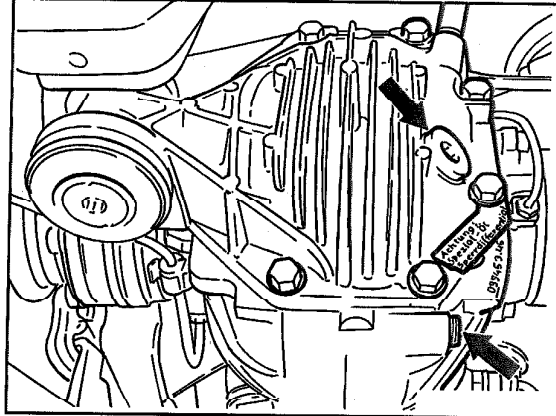
## 35-670 R and R rear axle shaft flange with differential housing installed

### Removal, installation

- 1 Drain oil in rear axle, fill (arrows).

#### Installation note

Fill with hypoid gear oil up to bottom edge of oil fill hole (Refer to factory approved service products list).



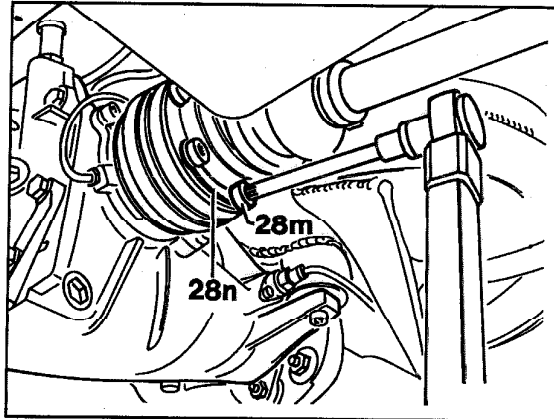
P35-2239-13

- 2 Remove rear axle shaft at connection flange, install.

#### Installation note

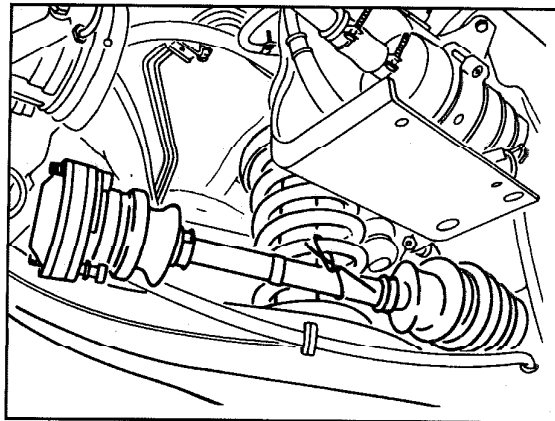
Replace retaining bolts (28m) and washers (28n). Retaining bolts M10 = 70 Nm, oiled on threads and bolt head contact surface, M12 = 125-145 Nm.

Torque wrench 001 589 67 21 00.



P35-2219-13

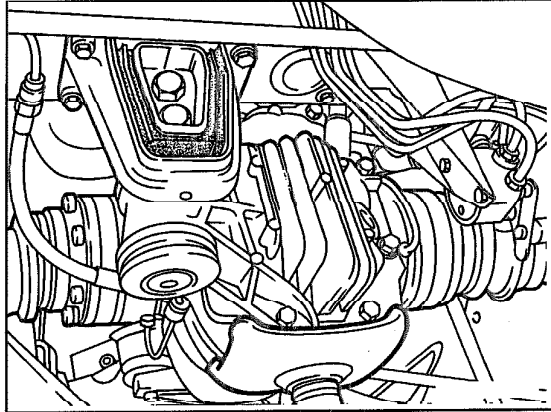
- 3 Press rear axle shaft together in axial direction and tie to rear spring with wire.



P35-2220-13

## 35-670 R and R rear axle shaft flange with differential housing installed

- 4 Support rear axle differential housing.

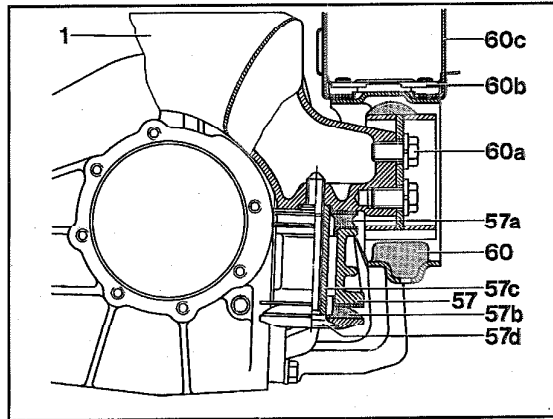


P35-2183-13

- 5 Screw rear self-locking serrated bolt (57d) out of end cover (57), screw in and remove together with rubber supports (57a, 57b), install.

### Installation note

Replace self-locking serrated bolts (57d), 110 Nm. Check rubber supports (57a, 57b) for wear, replace, if required.



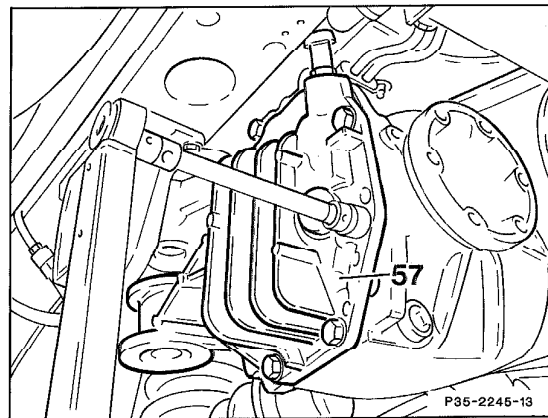
P35-0079-13

- 6 Lower rear axle differential housing, raise.

- 7 Remove end cover (57), install.

### Installation note

Clean sealing surfaces on end cover and on rear axle housing and coat with sealant. Hex. head bolts, strength class 8.8 = 45 Nm, 10.9 = 50 Nm.



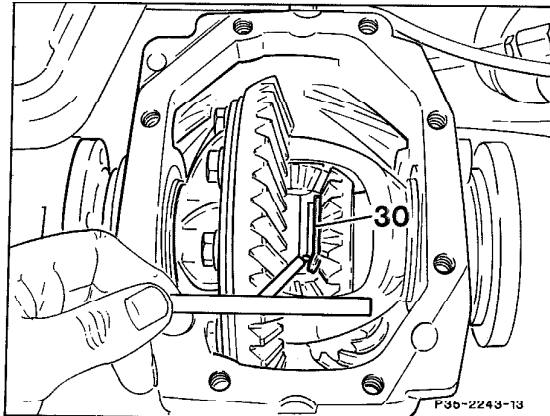
P35-2245-13  
P35-2245-13

## 35-670 R and R rear axle shaft flange with differential housing installed

8 Pull retaining ring (30) off of connection flange with pliers or suitable hook, install.

### Installation note

Replace retaining ring (30).

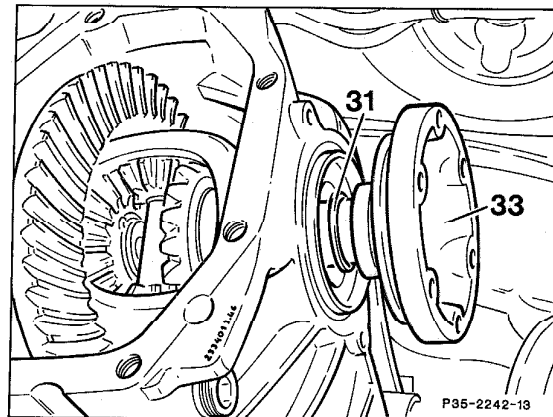


P35-2243-13

9 Pull connection flange (33) together with shim (31) out of rear axle shaft gear, insert.

### Installation note

Check running surface for radial shaft seal on connection flange, replace connection flange if required when running surface is worn heavily.



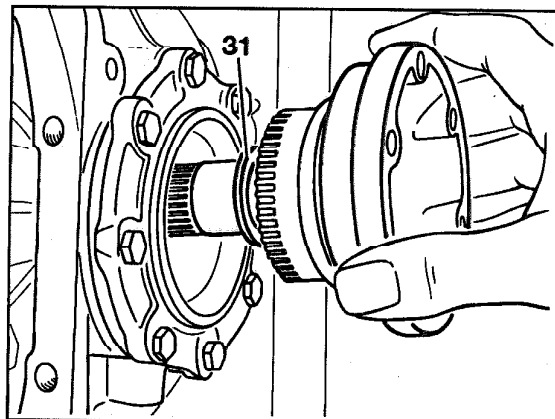
P35-2242-13

Arrangement without lateral bearing caps

10 Check axial play between connection flange and rear axle shaft gear.

### Installation note

It should not be possible to feel any axial play, however it should still be possible to turn the retaining ring in the groove. Install thicker shim (31) if required (see table).



P35-2082-13

Arrangement with lateral bearing caps and ASR

## 35-670 R and R rear axle shaft flange with differential housing installed

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### Shims (mm)

Thickness from - to (rear axle differential housing without lateral bearing caps)	0.7-1.5
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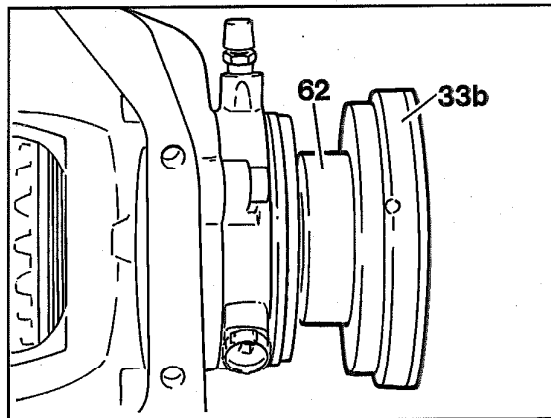
Thickness from - to (rear axle differential housing with lateral bearing cap)	2.6-3.4
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Increments from/to	0.1/0.1
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### Note

On vehicles with ASD adjustment of the axial play is not required.

Arrangement without lateral bearing caps with ASD



P35-2126-13

11 Install in opposite order.