

**Data**

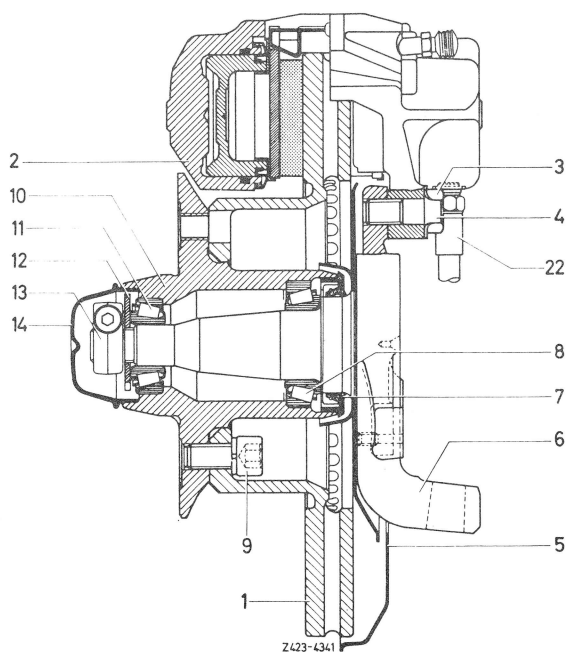
Thickness of brake disc	22
Perm. refinishing on each brake surface	0.5
Wear limit	20.05
Brake disc dia.	$273 \pm 0.2$
Fitted bore dia.	$80.046$ $80.000$
Surface roughness	$R_t = 6.3$
Lateral runout	max. 0.12

**Tightening Torque in kpm**

Hex. socket bolts for attaching brake disc to front wheel hub	11.5
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**Special Tool**

Measuring device	001 589 28 21 00
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**Removal**

1 Remove caliper (42.1–100).

2 Remove front wheel hub (33.1–310).

3 Screw three hex. bolts M 12 x 1.5 into front wheel hub. Then clamp front wheel hub into a vise using aluminum jaws (Fig. 2).

Fig. 1

- |                          |                                    |
|--------------------------|------------------------------------|
| 1 Brake disc             | 9 Hex. socket screw with snap ring |
| 2 Caliper                | 10 Front wheel hub                 |
| 3 Fitted hex. bolt       | 11 Tapered roller bearing          |
| 4 Lock washer            | 12 Disc                            |
| 5 Cover plate            | 13 Clamping nut                    |
| 6 Steering knuckle       | 14 Wheel cap                       |
| 7 Sealing ring           |                                    |
| 8 Tapered roller bearing |                                    |



# 42.1 Removal and Installation of Brake Disc on Front Axle

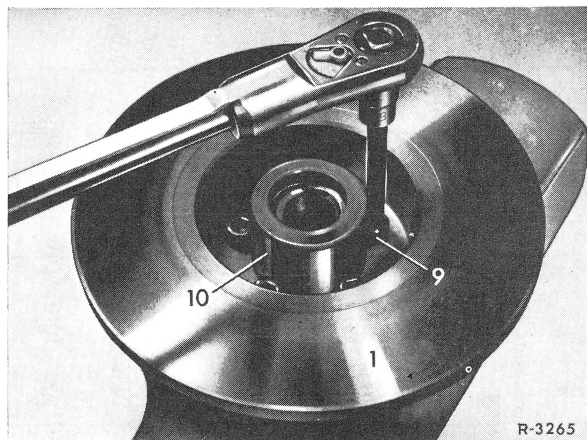


Fig. 2

- 1 Brake disc
- 10 Front wheel hub
- 9 Hexagon socket screw with snap ring 000 990 37 12

**4** Unscrew hexagon socket screws (9) holding brake disc (1) to front wheel hub (10).

**5** Check brake disc and replace in the event of score marks (approx. 0.5 mm deep) or heavy cracks.

## Installation

**Caution!** Prior to installing brake disc, remove rust on flange of brake disc and front wheel hub, if any. Make sure that there is no burr on adapter of brake disc.

If a new brake disc is installed, remove corrosion protection from brake disc.

**6** Attach brake disc (1) to front wheel hub (10) with new hexagon socket screws (9) with captive snap ring (Fig. 2).

Tighten hexagon socket screws to. 11.5 mkp.

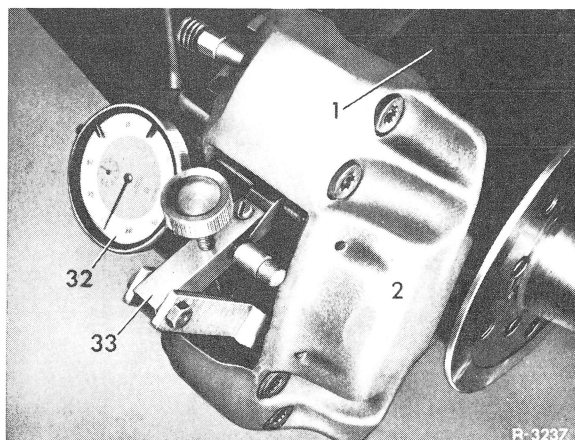


Fig. 3

- 1 Brake disc
- 2 Caliper
- 32 Dial gauge
- 33 Measuring device 001 589 28 21 00

**7** Install front wheel hub (33.1–310).

**8** Measure lateral runout of brake disc on outer dia. (Fig. 3).

If the lateral runout is too high, shift brake disc on front wheel hub.

**9** Install caliper (42.1–100).

**10** Bleed brake system and check for leaks (42.0–010 and 42.1–015).