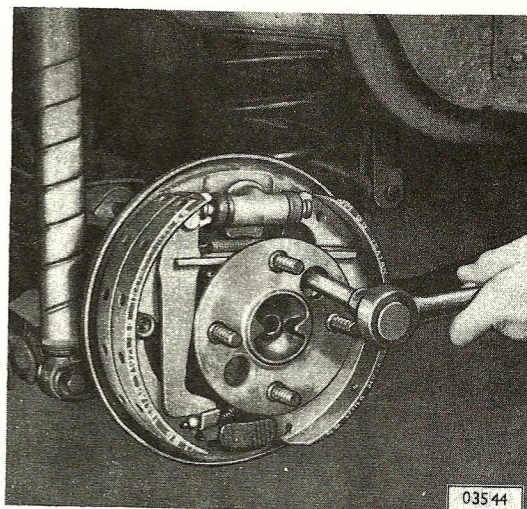


## Replacing One Rear Axle Shaft

Jack up vehicle, remove wheels and brake drum (refer to operation in group 5).

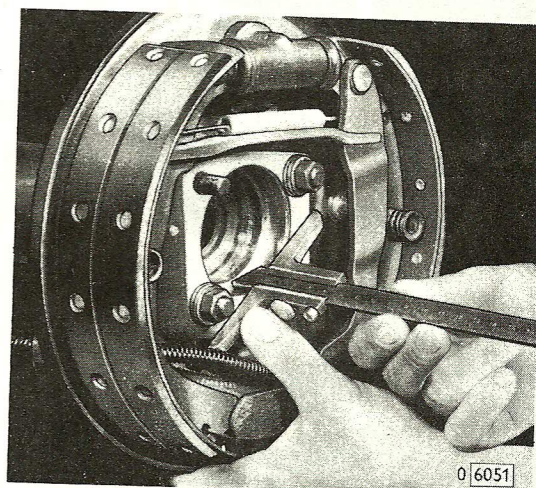
Unscrew rear axle shaft retaining plate and, if required, with tools SW-223 and SW-224 pull shaft out of rear axle housing.



On installation always use new paper gasket.

Check axial play of rear axle shaft:

a) Measure seat depth. To do this, install brake backing plate together with paper gasket.

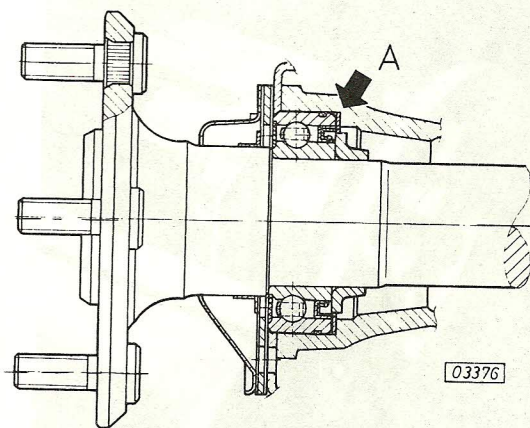


b) Measured depth minus roller bearing width = thickness of shims (A) to be installed.

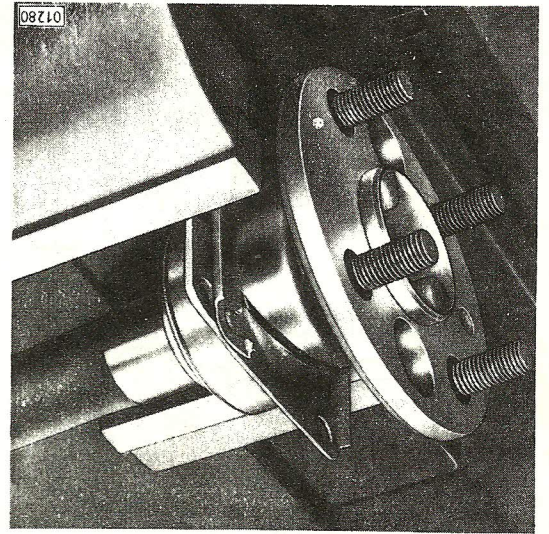
Width of roller bearing = .83 in. (21 mm)  
Permissible axial play = .002 in. (0.05 mm)  
Permissible pressing = .006 in. (0.15 mm)  
always aim at pressing.

If required adjust with 2.8 in. (71 mm) (2.4 in. (61 mm) + diameter and .004 in. (0.1 mm) thick shims. Replacing both rear axle shafts **Corresponds** to operation "Replacing One Rear Axle Shaft", however on both sides.

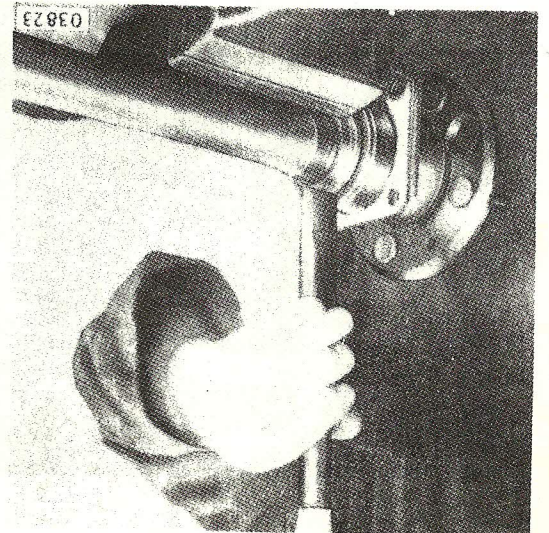
+ refer to "Introduction".







For replacement of the bearing parts of a rear axle shaft saw oil deflector plate as shown in the illustration and remove. To do this clamp oil deflector plate in a vise and support rear end of shaft.



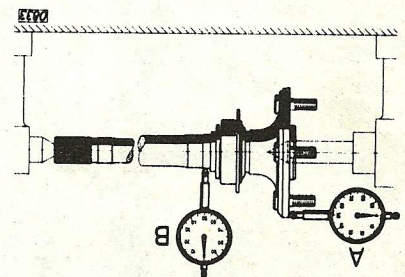
- Rear axle shaft removed
- Remove ball bearing retaining ring.

### Replacing Bearing Parts Of A Rear Axle Shaft

Permissible lateral runout A measured at largest flange diameter:  
Max. .004 in. (0.10 mm).  
Permissible radial runout B:  
Max. .0024 in. (0.06 mm)  
Straightening of the rear axle shaft is not permissible.

- Rear axle shaft removed

### Checking Rear Axle Shaft For Runout





### Caution

When sawing deflector plate, do not damage rear axle shaft.

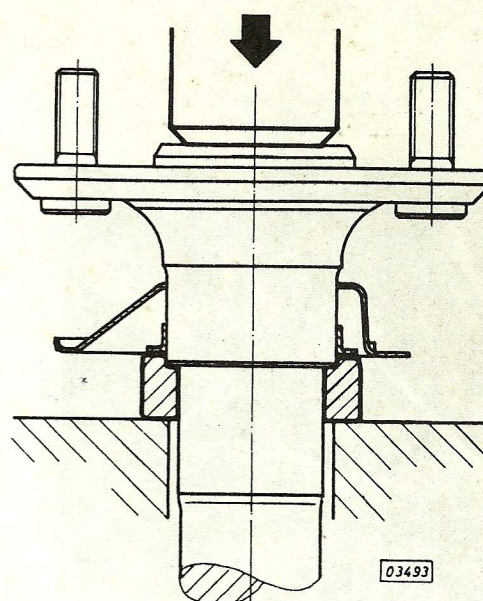
Prior to pressing off ball bearing remove retaining ring behind the bearing. For pressing off use smallest possible slot of slotted plate.

For installation of new bearing parts use tool SW-236 (S-1211 +).

Install ball bearing retaining ring in cold condition. A lubricant is not required.

Force required to press on: Ball bearing = 2645-4850 lbs. (1200-2200 kp), Retaining ring = 2205-6614 lbs. (1000-3000 kp).  
Repress with 8818 lbs. (4000 kp).

The waved seal ring in ball bearing cannot be replaced separately but only together with the ball bearing.



4

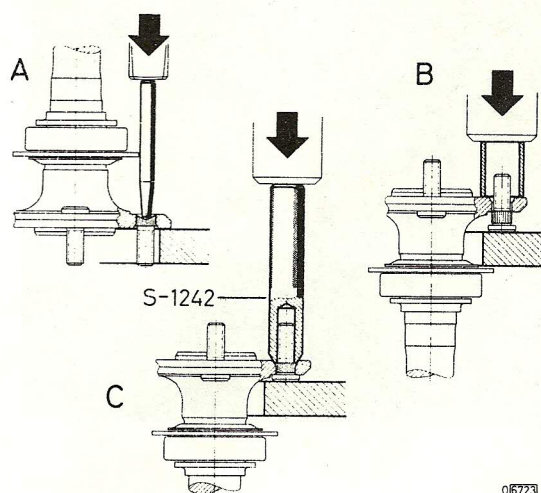
### Replacing Wheel Bolt On Rear Axle Shaft

- Rear axle shaft removed -

Rough-drill head of wheel bolt and strike off bolt, using a chisel. For rough-drilling use on angular-type drill with a .55 in. (14 mm) drill bit.

With a drift drive out wheel bolt (A), press in new bolt (B) and peen, using tool S-1242 (C).

Make sure that flange and splines of the shaft are not damaged.



+ Refer to "Introduction"