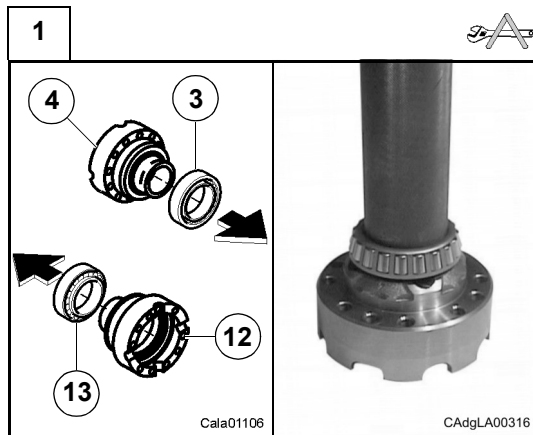
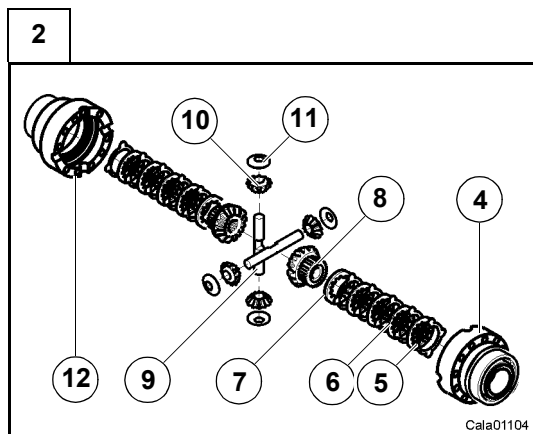


Assembly

Some of the following pictures may not show exactly your axle, but the indicated operations are correct anyway.



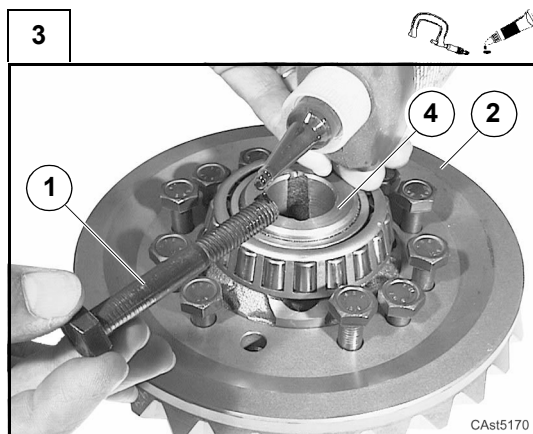
Assemble the bearing cones (3) and (13) on the half housings (4) and (12), using the special tool 380002216 and a hammer.



See: limited slip differential disks specifications (Par. 4.5.2). Position a half housing (4) or (12) on a workbench and assemble all inner components (locking differential counterdisks (5), locking differential discs (6) and (7), sun gears (8), spiders (9), spider gears (10), thrust washers (11), as shown in figure.

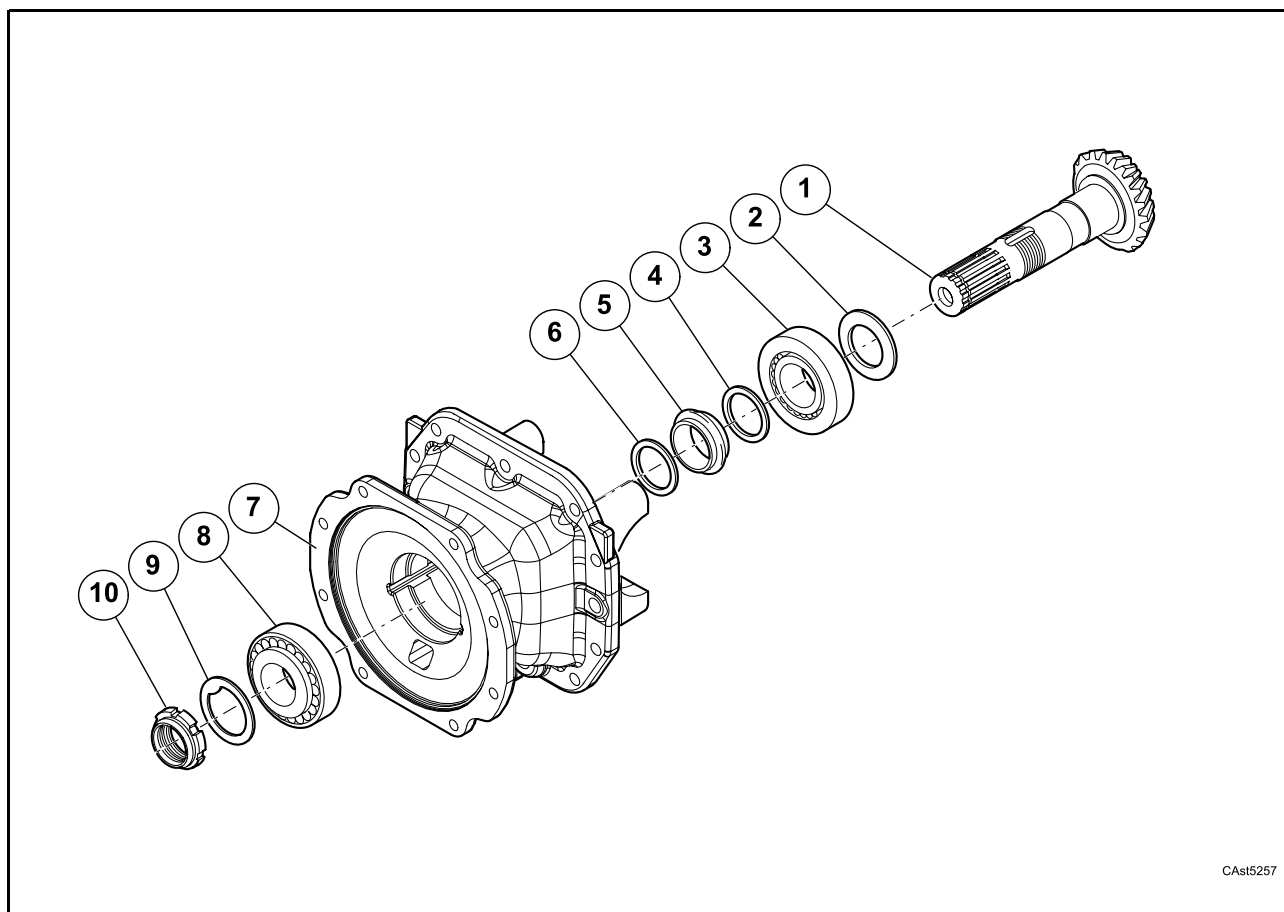
NOTE - the first disk (7) must be assembled with friction material on the disks side and the flat surface on the sun gear (8) side.

Join the two half boxes, aligning the reference marks made upon them.



Position the bevel gear (2) on the half box (4). Apply the specified sealant on the thread (Par. 4.5.2) and tighten the bolts (1) to the requested torque (Par. 4.5.5).

4.6.13 PINION GROUP

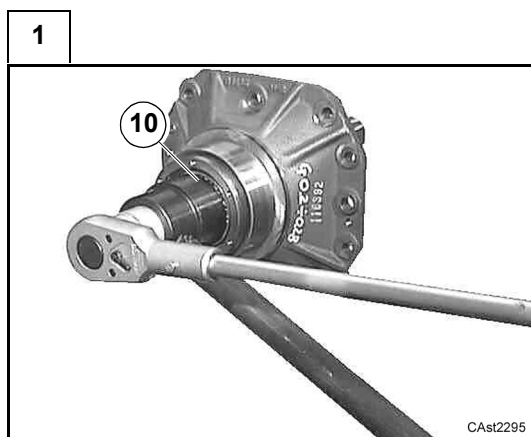


CAst5257

Disassembly

Some of the following pictures may not show exactly your axle, but the indicated operations are correct anyway.

Vedi: Par. 4.6.10 before disassemble the pinion group.



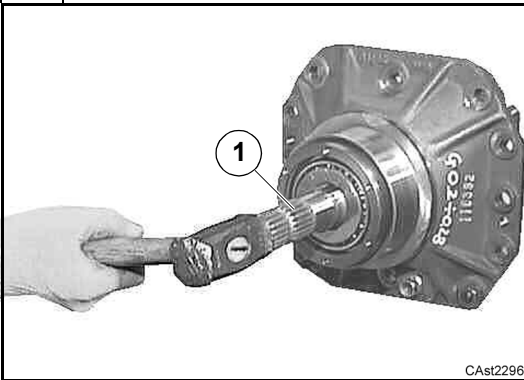
CAst2295

Lock the differential carrier in a vice.

Unscrew the lock nut (10) using special tools 380002212 and 380002218.

NOTE - This is a destructive operation for the ring nut.

2



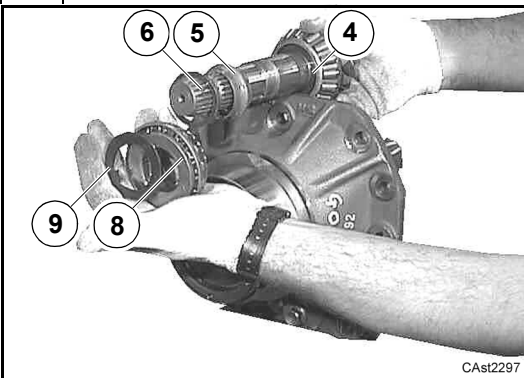
CAst2296

Tap the shaft with a soft hammer to remove the bevel pinion (1).

**WARNING**

Take care not to drop the pinion.

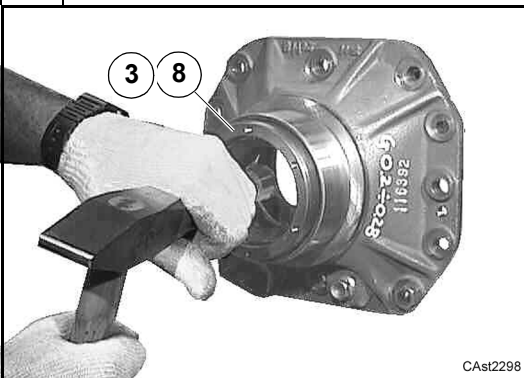
3



CAst2297

Collect the washer (4) and (6), the collapsible spacer (5), the bearing cone (8) and the retaining washer (9).

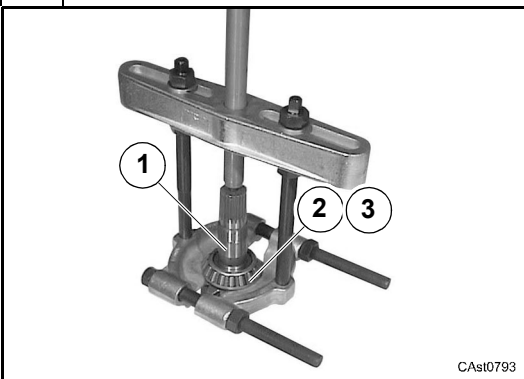
4



CAst2298

Remove the bearing cups (3) and (8) using a driver and a hammer.

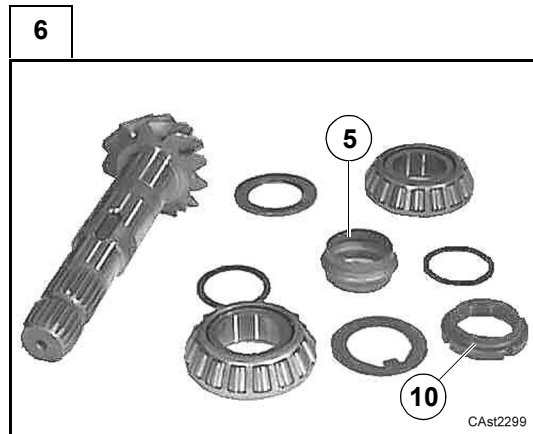
5



CAst0793

To remove the bearing cone (3) of the pinion (1), use a standard extractor.

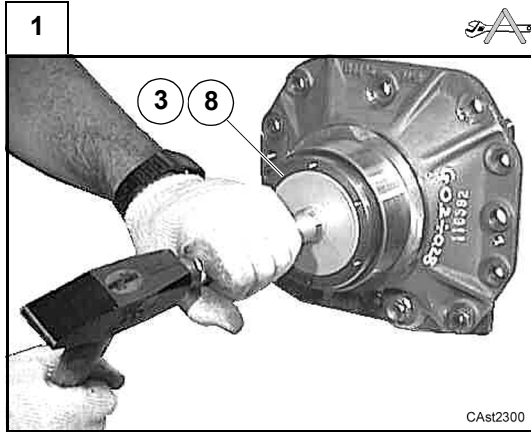
Collect the bearing cone (3) and the underlying shim (2).



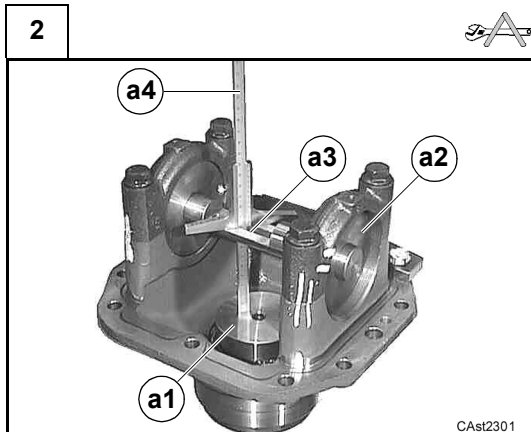
Check all pinion components for wear.
The ring nut (**10**) and the collapsible spacer (**5**) must be replaced when reassembling the unit.

Assembly

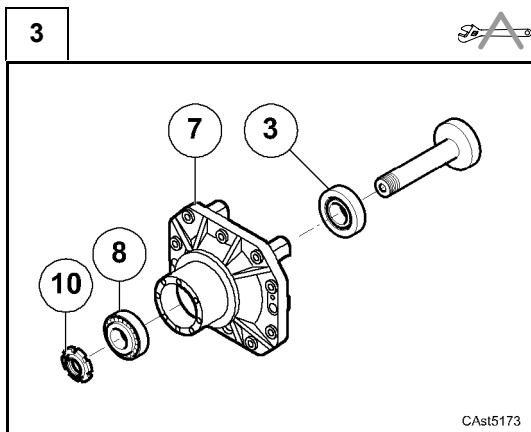
Some of the following pictures may not show exactly your axle, but the indicated operations are correct anyway.



Fit the bearings cups (3) and (8) using the special tool 380002215 and a hammer.



Prepare the kit consisting of the special tools called "false pinion" (a1) 380002219 and "false differential box" 380000407 (a2) and 380002214 (a3) and a depth gauge (a4).



Insert the bearing cones (3) and (8) in their seats. Assemble the "false pinion" and its ring nut (10). Tighten without exceeding the ring nut, till the backlash is eliminated.