
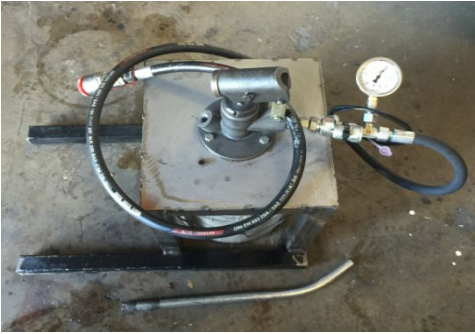


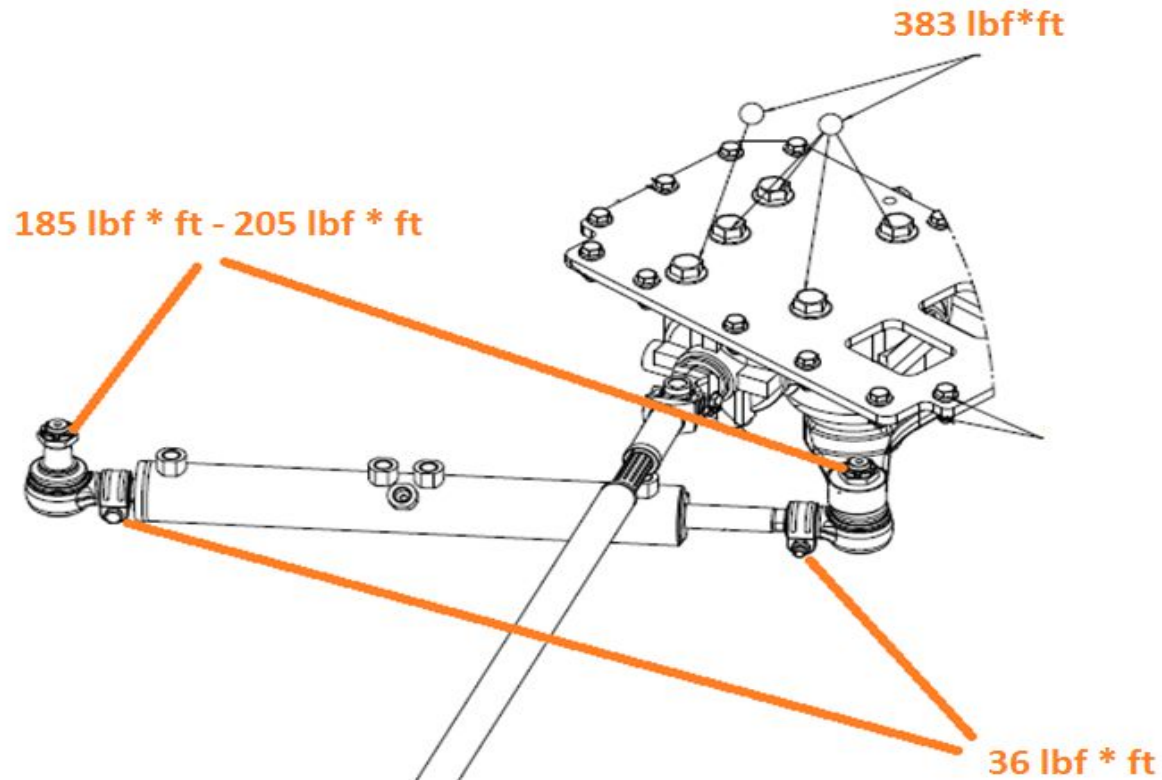


Part Number	Part Name	Picture
Tool 1	Guage	
Tool 2	Oil Pump	
Tool 3	Template	
Tool 4	Template	

Following document shows, how to set tag axle steering system cylinders and bleeding the tag axle steering system;

1) Please check all the connections on the front axle. Such as sway bar connections and bushings, axle arms, gear box fasteners, gear box bracket fasteners, master cylinder clamp torques.

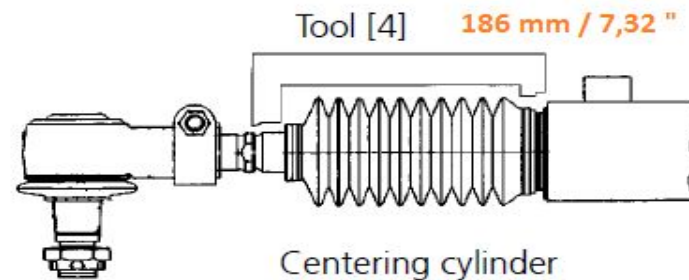
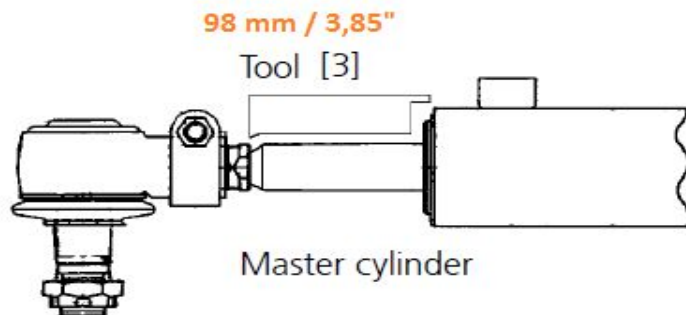
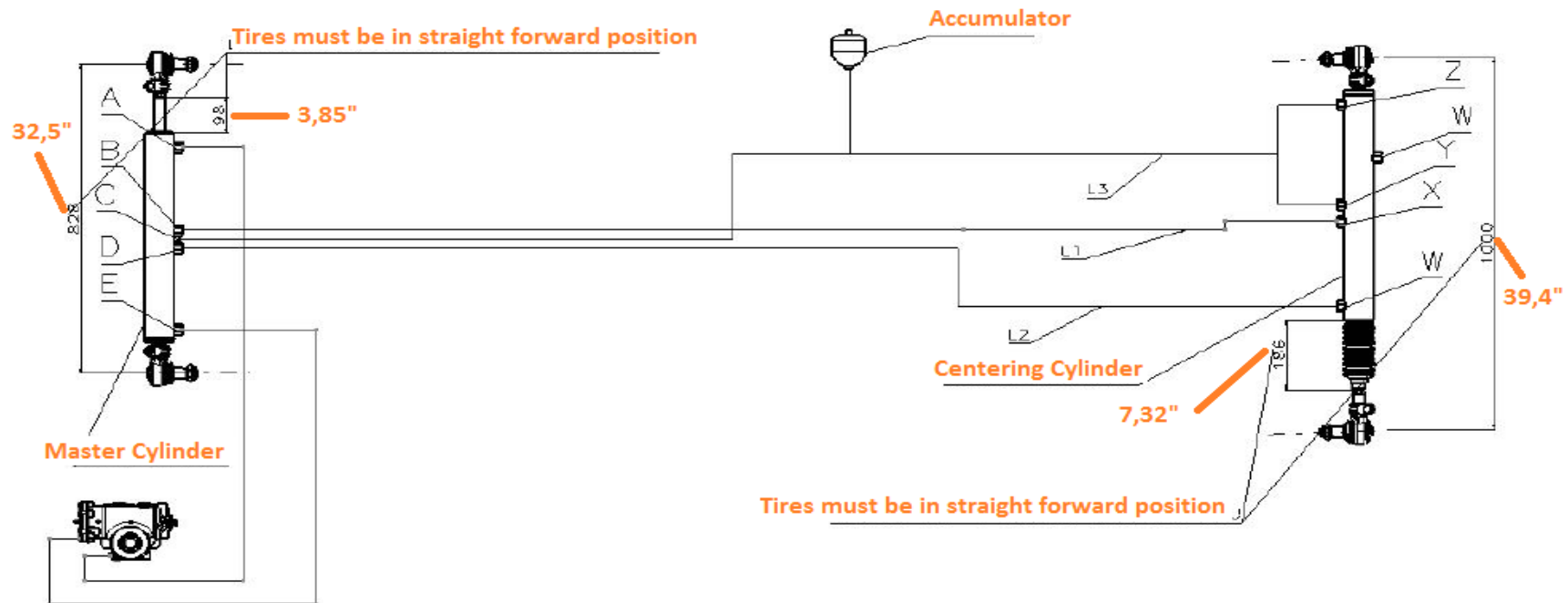


2) Drain all the oil from the tag axle steering system.

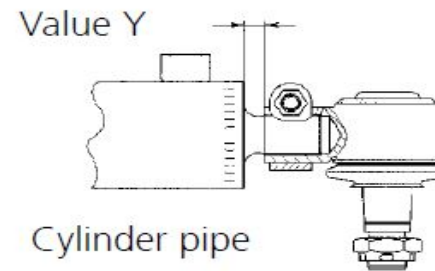
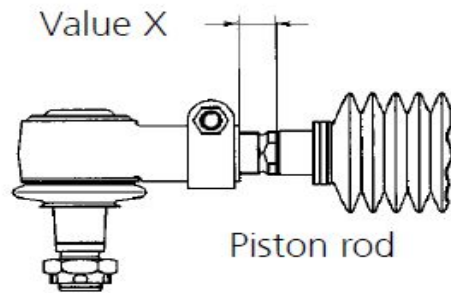
3) Check below given dimensions for the master and centering cylinder; if they are not correct please do the correction.

P.S 1: If you are changing the dimensions of the cylinders, you have to disconnect cylinders by removing the hydraulic hoses from the system !!!

P.S 2: Master & Centering cylinders need to be adjusted when the system pressure is zero !!!



4) Check Nuckle End Installation



Value X (piston rod):

Master cylinder:

max. 13 mm (for 8346 974 163: max. 31.5 mm)

Centering cylinder:

max. 31.5 mm — 1,25 "

Value Y (cylinder pipe):

Master cylinder:

max. 14 mm — 0,55 "

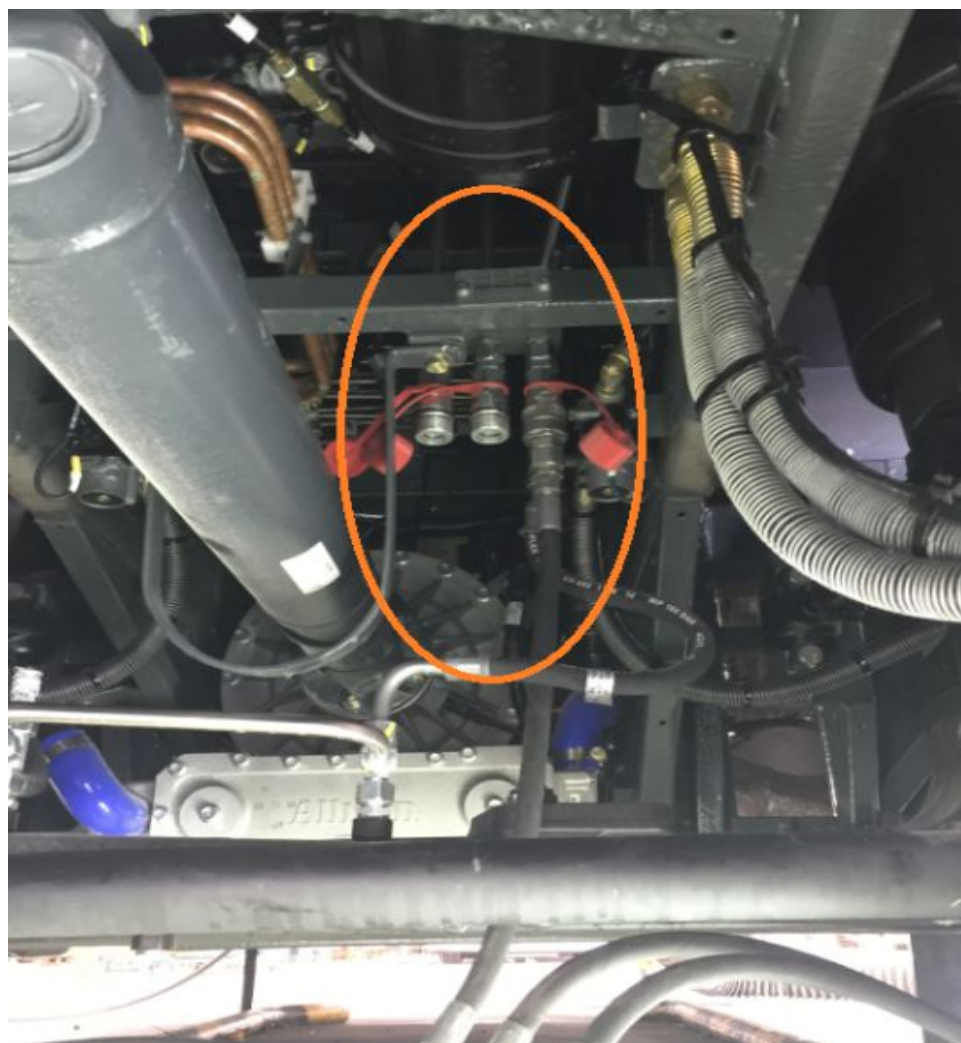
Centering cylinder:

max. 19 mm — 0,74 "

0,51 "

5) System filling and bleeding points shown below;

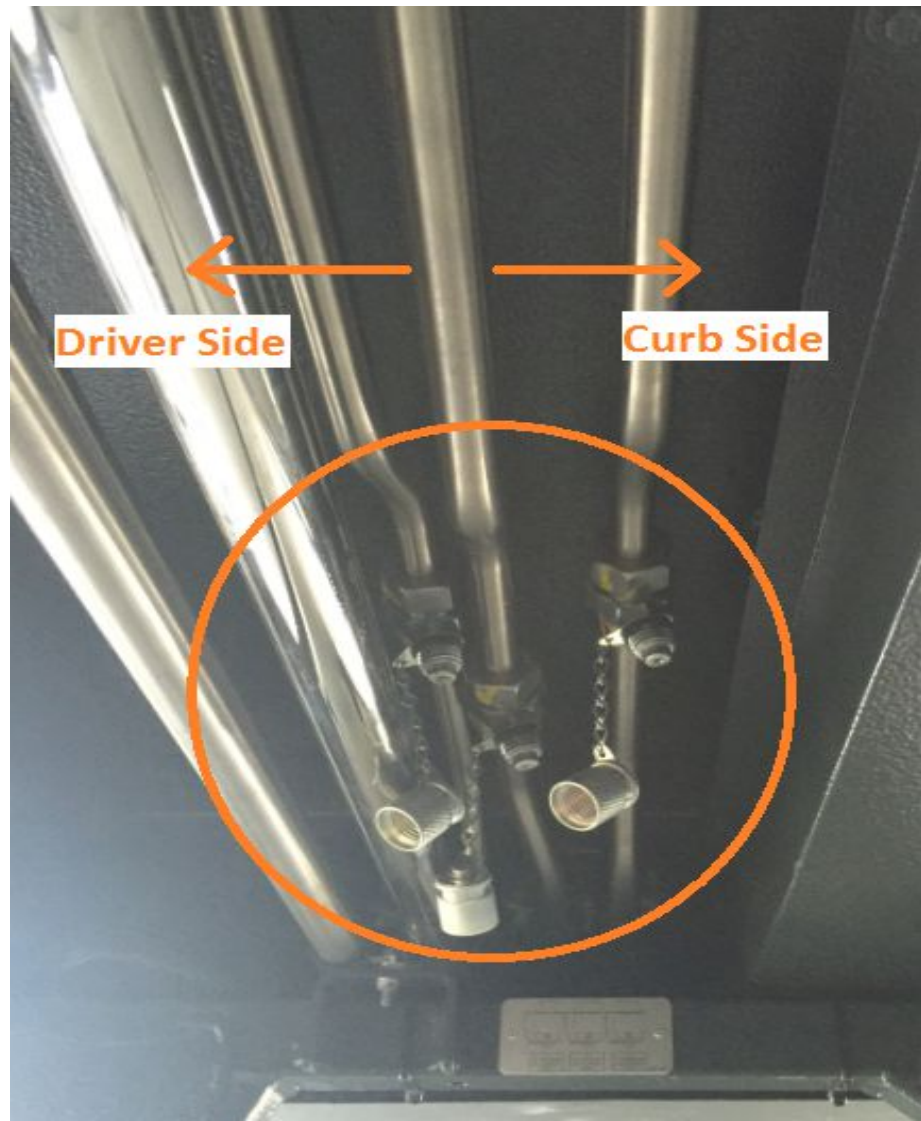
Filling points locates at the rear axle bogie area



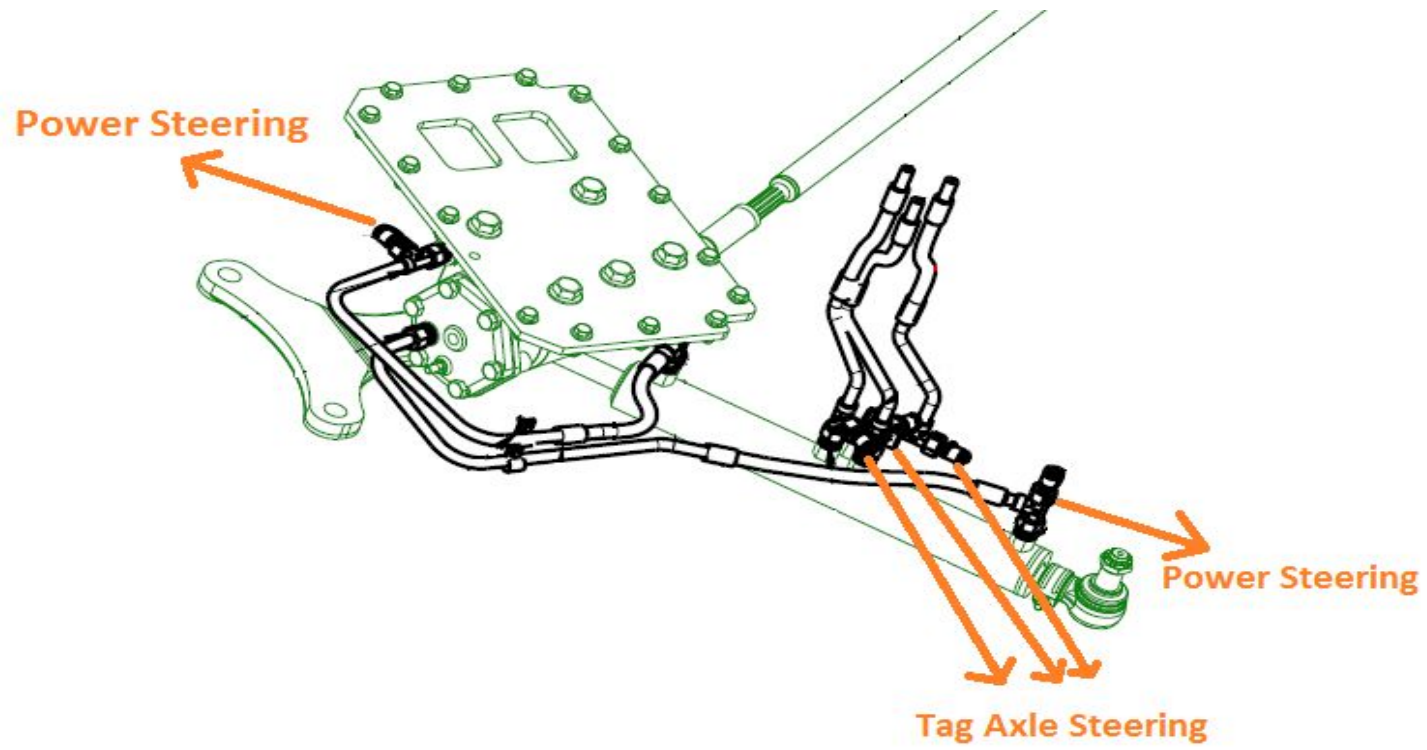
Bleeding ports;

a) Baggage Bay Area:

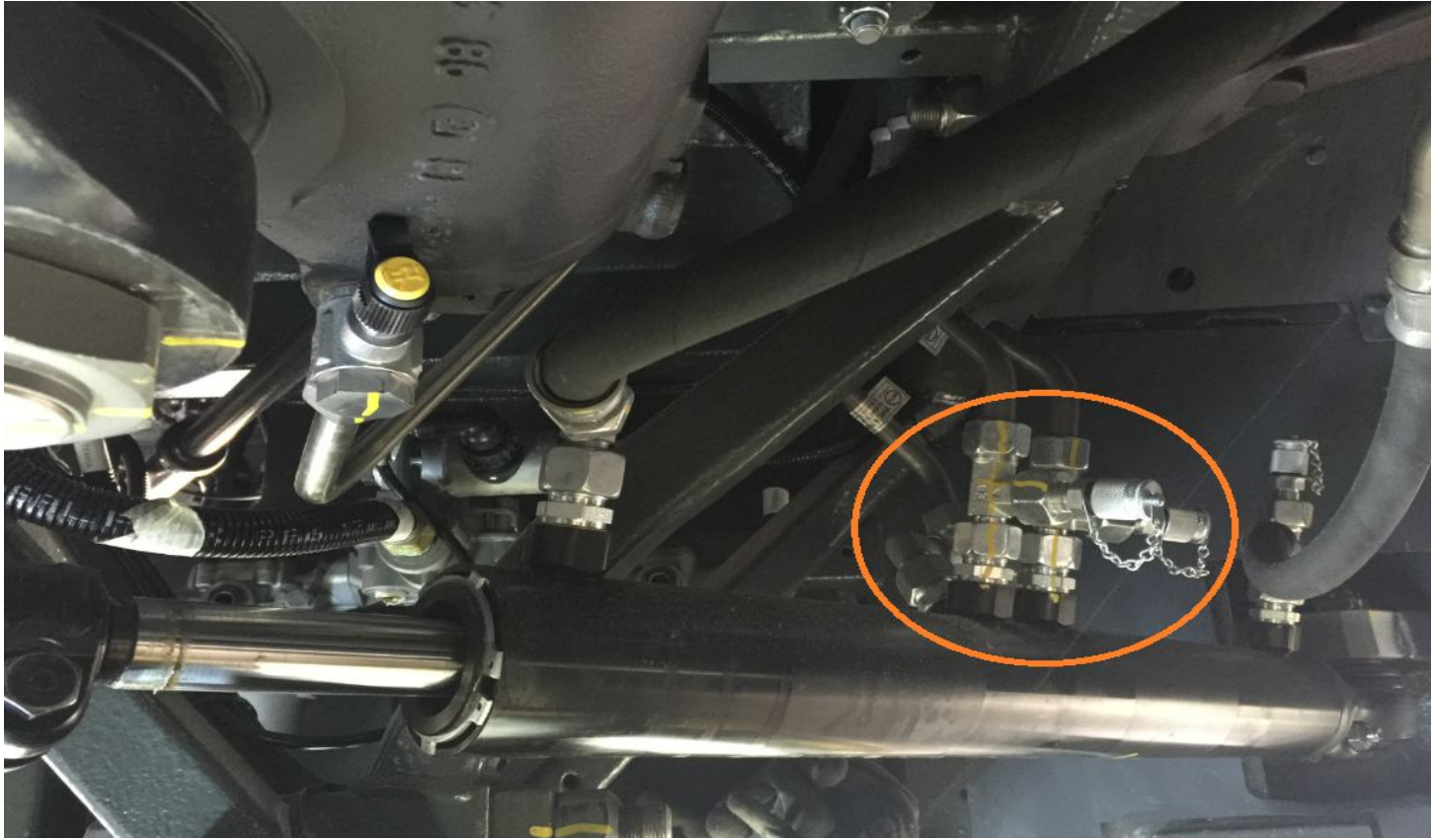




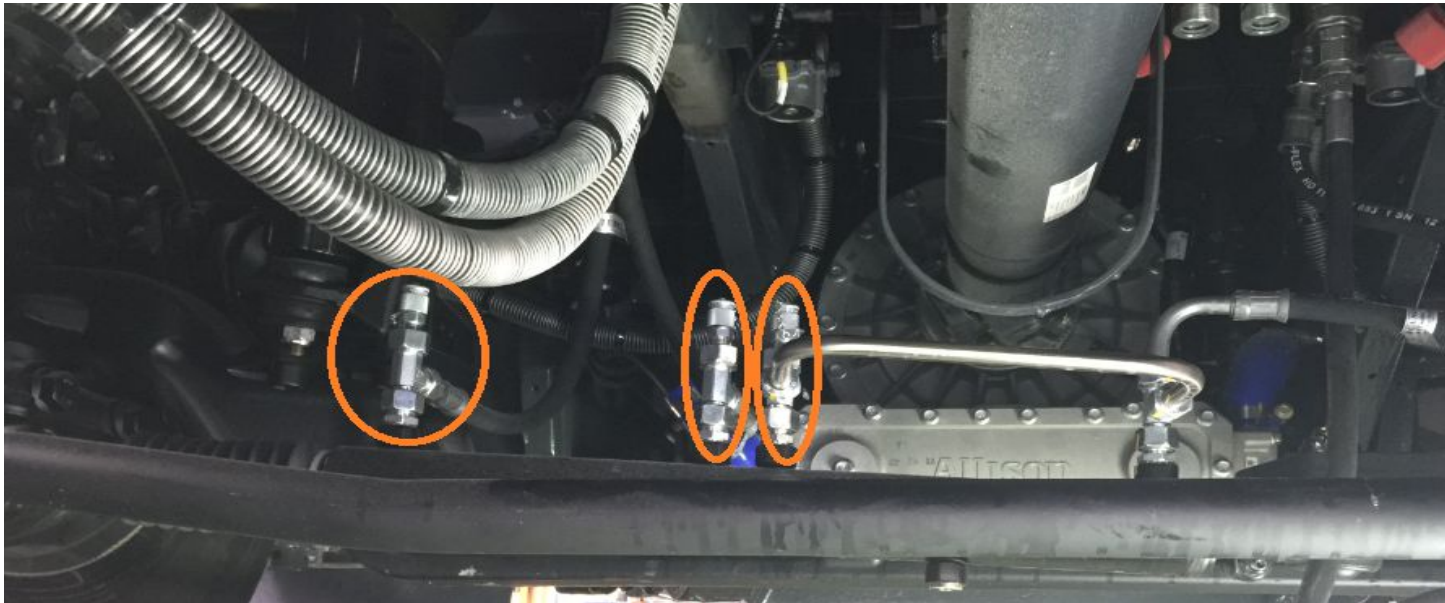
b) Steer Axle Area



b) Steer Axle Area



c) Tag Axle Area

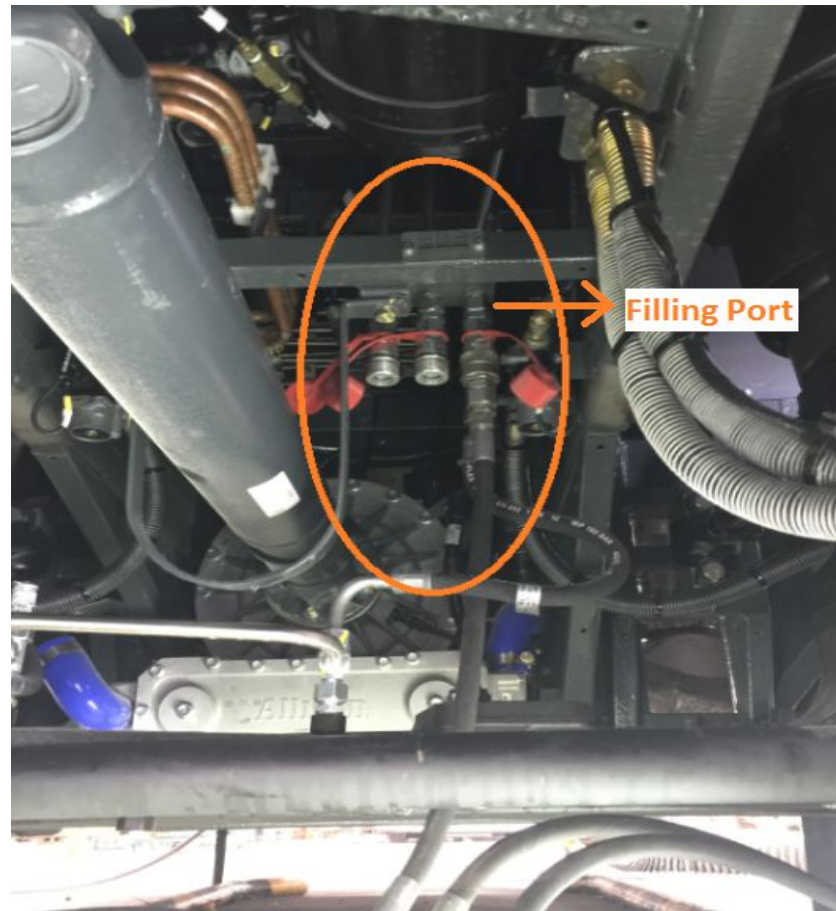


6) Filling with oil;

a) Only oil grades approved by TEMSA must be used, the system will be filled up approximately 6 liters of oil.

b) Be sure that the tires are in straight forward position, and the measurements are given above are in the correct values. (Gauge Template checks are ok and knuckle end installation are in correct dimension)

c) Connect the pump to the centering line. (Filling port shown below). Increase the system pressure to 18 (- 1) bar.



d) Start bleeding, from luggage bay area bleeding ports. Each of the lines must be bled from driver side to curb side. Keep bleeding until no bubble comes. Actuate the hand pump to build up pressure and ensure that the system is pressurized during the entire bleeding process

e) Repeat step "c" and "d" two or three times

f) Keep bleeding, from master cylinder bleeding ports (steer axle area) and then centering cylinder (tag axle area) bleeding ports. Actuate the hand pump to build up pressure and ensure that the system is pressurized during the entire bleeding process

g) Start the engine, turn the steering from one limit position to the other several times

h) While performing the step g, repeat step d, e and f.

i) Check the system pressure. Required: 18 (-1) bar