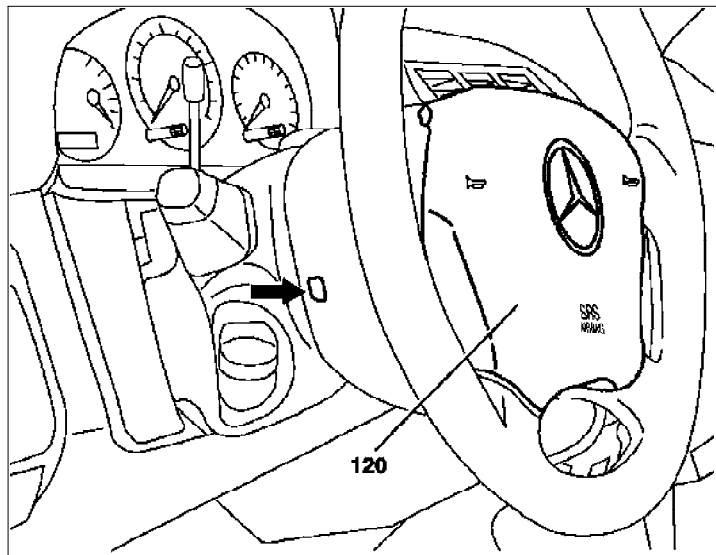
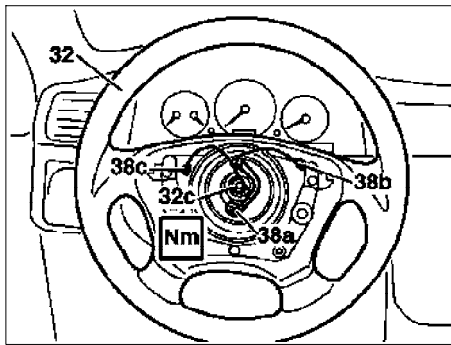


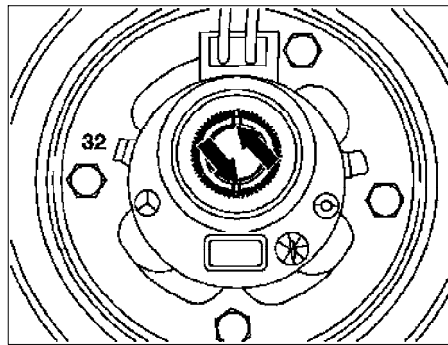
MODEL 163.113 /128 /136 /154 /157 /172 /174 /175



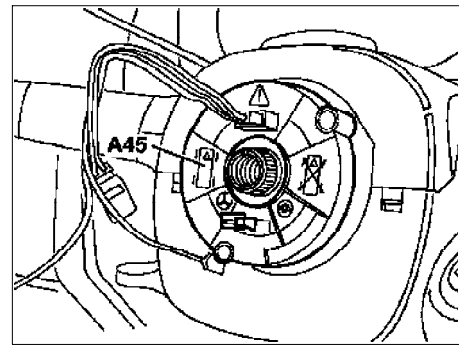
P46.10-0449-11



P46.10-0450-01



P46.10-0458-01



P46.10-0459-01

	Remove/install		
Danger!	Injury hazard when performing test and repair work on airbags and emergency tensioning retractors	Store airbag unit with expulsion area on top, do not subject to temperatures above 100 °C. Interrupt power supply when working on such units.	AS91.00-Z-0001-01A
	Important instructions for performing repair, body work and welding on vehicles with airbag and emergency belt tensioner units	Models 129 as of 1.7.93, 163, 168, 170, 202 as of 1.7.93, 208, 210, 414, 638, 690.6, 901, 902, 903, 904, 905 Model 461 with engine 602.983 Model 463 up to 30.11.00 Type WD141, WD241, WD341, WD641, WD741, XD141, XD241, XD341, XD441, XD541, XD641, XD741, YD141, YD241, YD341, YD441, YD541, YD641, YD741	AH91.00-P-0002-01B
	Legal provisions concerning handling and storage of airbag and emergency tensioning retractor units	Models 124, 129, 140, 163, 168, 170, 202, 203, 208, 209, 210, 211.004/ 006/ 016/ 061/ 065/ 070, 215, 220, 230, 314, 316, 318, 414, 461, 463, 638, 668, 670, 690.6, 901, 902, 903, 904, 905, 950, 952, 953, 954, 970, 972, 974, 975, 976 Type WD141, WD241, WD341, WD641, WD741, XD141, XD241, XD341, XD441, XD541, XD641, XD741, YD141, YD241, YD341, YD441, YD541, YD641, YD741	AH91.00-P-0004-01A
OS	Notes regarding the disposal of airbag and belt tensioner units	All models	OS91.00-P-0001-01A
1	Disconnect ground cable of battery	Ensure that ground cable will not come into renewed contact with the battery terminal as you are working.	AR54.10-P-0003A
2	Remove airbag unit (120) from steering wheel (32)		AR91.60-P-0660GH

3	Unplug horn connectors (38b, 38c)		
4	Center the steering wheel (32) at its vertical position (front wheels straight ahead)		
5	Remove key and allow steering lock to lock in position		
6	Unscrew bolt (32c)	<input type="checkbox"/> Hold the steering wheel (32). Installation: Replace bolt. <input type="checkbox"/>	*BA46.10-P-1001-02A
7	Pull off steering wheel (32)	<input type="checkbox"/> Pass cable carefully through the openings. Installation: Align recesses in serrations in steering wheel with the markings on the steering shaft (arrows).	
8	Check fanfare horns and airbag clock spring contact (A45) for damage	<input type="checkbox"/> Visual inspection, replace contact spiral if necessary: ~ Removing, installing contact spiral	AR46.10-P-0200GH
9	Install in the reverse order		
10	Conduct a road test	<input type="checkbox"/> Check during road test: ~ Turn signal canceling: If the steering wheel is more than one spline off center, the turn signals may not cancel correctly Airbag indicator lamp: The SRS indicator lamp must not light up when the steering is turned to full lock in both directions. Steering wheel position: If steering wheel is crooked, adjust it by max. 1 tooth. If the difference is greater: ~ Check and adjust front toe angle	AR40.20-P-0323GH

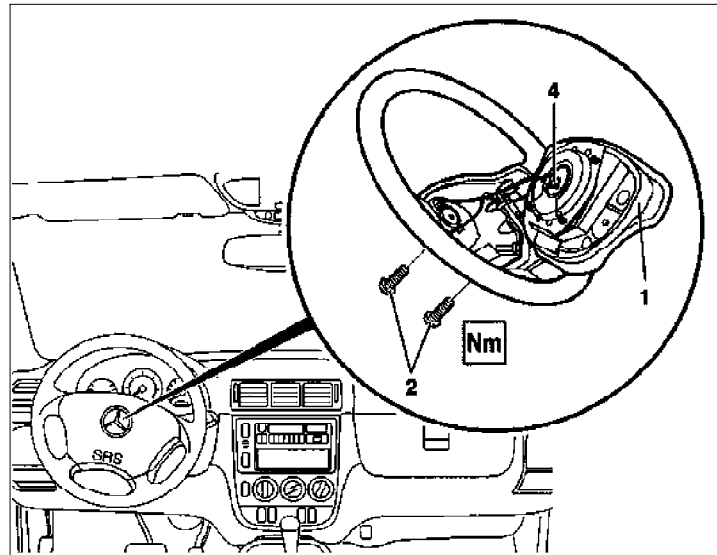
Steering wheel

Number	Designation	Model Series 163
BA46.10-P-1001-02A	Bolt, steering wheel to steering shaft NM	80

MODEL 163.113 /128 /136 /154 /157 /172 /174 /175

up to 31.08.01

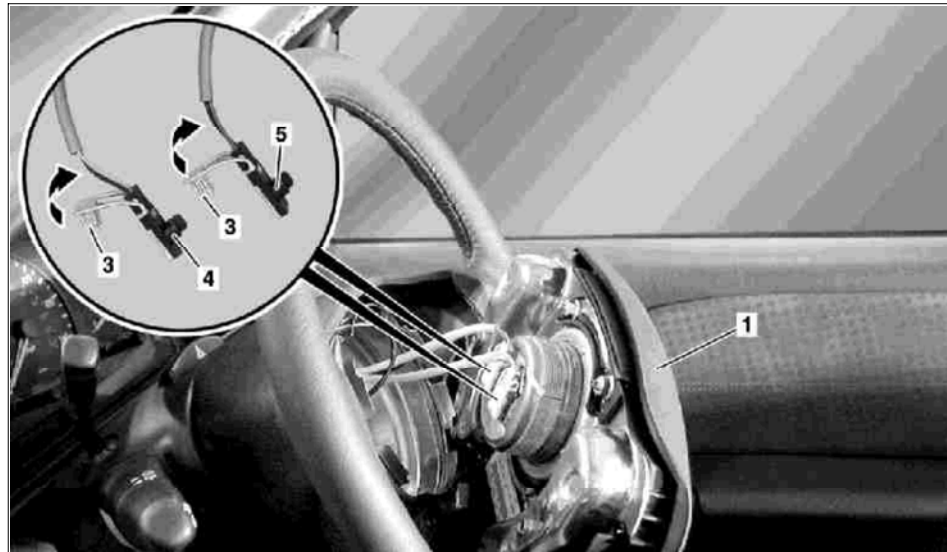
- 1 Airbag unit
- 2 Bolts
- 4 Connector



P91.60-2339-11














as of 01.09.01

- 1 Airbag unit
- 3 Arresting mechanism
- 4 Connector
- 5 Connector



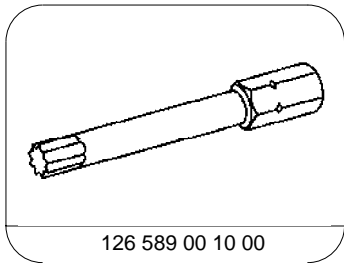
P91.60-2340-05

	Remove/install		
Danger!	Injury hazard when performing test and repair work on airbags and emergency tensioning retractors	Store airbag unit with expulsion area on top, do not subject to temperatures above 100 °C. Interrupt power supply when working on such units.	AS91.00-Z-0001-01A
	Important instructions for performing repair, body work and welding on vehicles with airbag and emergency belt tensioner units	Models 129 as of 1.7.93, 163, 168, 170, 202 as of 1.7.93, 208, 210, 414, 638, 690.6, 901, 902, 903, 904, 905 Model 461 with engine 602.983 Model 463 up to 30.11.00 Model WD141, WD241, WD341, WD641, WD741, XD141, XD241, XD341, XD441, XD541, XD641, XD741, YD141, YD241, YD341, YD441, YD541, YD641, YD741	AH91.00-P-0002-01B
	Legal provisions concerning handling and storage of airbag and emergency tensioning retractor units	Models 124, 129, 140, 163, 168, 170, 202, 203, 208, 209, 210, 211.004/ 006/ 016/ 061/ 065/ 070, 215, 220, 230, 314, 316, 318, 414, 461, 463, 638, 668, 670, 690.6, 901, 902, 903, 904, 905, 950, 952, 953, 954, 970, 972, 974, 975, 976 Model WD141, WD241, WD341, WD641, WD741, XD141, XD241, XD341, XD441, XD541, XD641, XD741, YD141, YD241, YD341, YD441, YD541, YD641, YD741	AH91.00-P-0004-01A

 OS	Notes regarding the disposal of airbag and belt tensioner units	All models	OS91.00-P-0001-01A
1	Separate ground cable of battery		AR54.10-P-0003A
2	Remove screws (2)	 Starting from the straight-ahead position, turn steering wheel by 90° to obtain better access to the bolts.   Screwdriver bit	*BA91.60-P-1001-01A *126589001000
3	Lift airbag unit from steering wheel		
4.1	Open arresting mechanism (3) on plug connector (4)	 Up to 31.08.01.	
4.2	Open arresting mechanism (3) on both plug connectors (4, 5)	 As of 01.09.01.	
5.1	Unplug plug connector (4) from squib	 Up to 31.08.01.  Installation: plug connector should latch audibly.	
5.2	Unplug connector (4, 5) from squib.	 As of 01.09.01.  Installation: plug connector should latch audibly. Close arresting mechanism (3) on the plug connectors after latching.	
6	Remove airbag unit (1) out of steering wheel	 If airbag unit is replaced: Make airbag units unusable	AR91.60-P-0611A
7	Install in the reverse order	 The steering wheel must always be replaced after the driver airbag unit has deployed.	
8	Check automatic return of combination switch		
9	Carry out diagnosis	 According to specifications in diagnosis manual.	

 **Airbag**

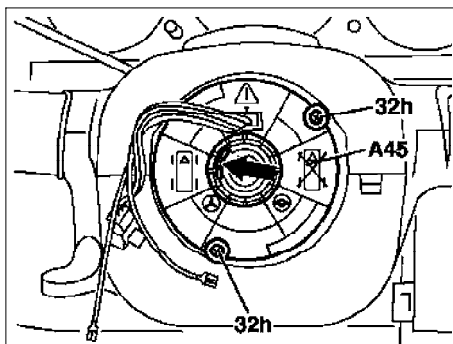
Number	Designation	Model 163
BA91.60-P-1001-01A	Screw for airbag to steering wheel	NM 8



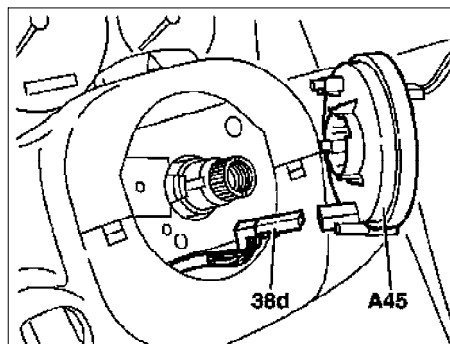
126 589 00 10 00

Screwdriver bit

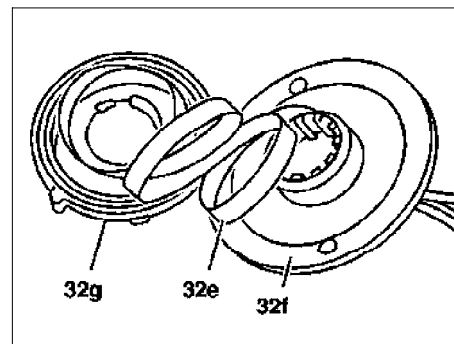
MODEL 163.113 /128 /136 /154 /157 /172 /174 /175



P46.10-0460-01



P46.10-0461-01



P46.10-0399-01

☒ ☒	Remove/install		
1	Remove steering wheel	<p>i Front wheels centered</p>	AR46.10-P-0100GH
2	Only unscrew the mounting screws (32h) until the fanfare horns and airbag clock spring contact (A45) can be removed	<p>i The fastening bolts also act as protection against twisting and as an assembly aid.</p>	
3	Remove the fanfare horns and airbag clock spring contact (A45) carefully from the jacket tube	<p>i Installation: Push on fanfare horns and airbag clock spring contact (A45) as far as the stop. In the process the recess must align with the fixing lug (arrow)</p> <p>⚠ If the clock spring contact twists out of position, i.e., if the steering joint is removed: Set the clock spring contact to center position</p>	AR46.10-P-0200-01GH
4	Unlock plug and disconnect the connector (38d) from the fanfare horns and airbag clock spring contact (A45)		
5	Check fanfare horns and airbag clock spring contact (A45) for damage	<p>👁 Visual inspection</p> <p>⚠ Do not use any oil or grease!</p> <p>i The upper (32f) and lower part (32g) of the clock spring contact are clipped together and can only be separated by the effect of high forces or due to defective assembly. If the spring contact is assembled incorrectly, carefully unwind and clip the upper and lower parts together. Be careful not to trap or bend the spring contact (32e).</p>	
6	Install in the reverse order		

i The center position of the fanfare horns and airbag clock spring contact (A45) is crucial for the trouble-free function of the airbag system and signaling system. In the removed condition, the position is ensured by the mounting screws (32h).

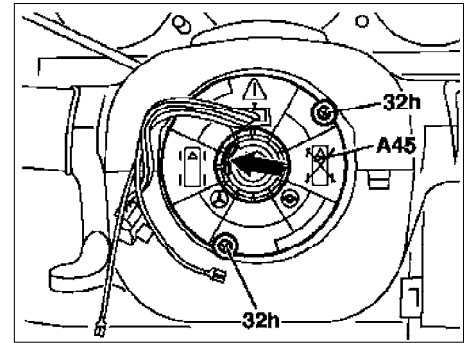
If contact spiral is twisted, however, e.g.

- When the steering coupling is removed
- When the retaining bolts are fully unscrewed

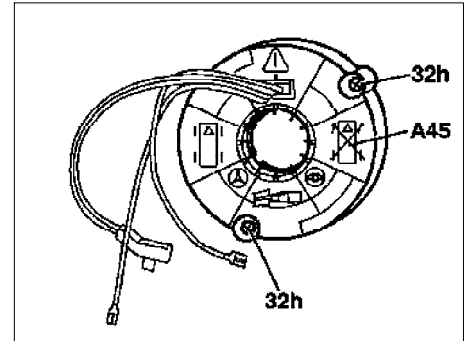
then the center position must be found as follows:

- 1 Remove clock spring contact
- 2 Screw the mounting screws (32h) completely into the fanfare horns and airbag clock spring contact (A45).
- 3 Rotate the fanfare horns and airbag clock spring contact (A45) counterclockwise until a slight resistance is noticeable (clock spring contact is rolled up completely).
- 4 Rotate clock spring contact approx. 3 to 3.5 revolutions clockwise (turn back), until the mounting screws (32h) can be unscrewed again through the openings and fix the fanfare horns and airbag clock spring contact (A45) in position.

i The entire rotation range of the clock spring contact is approx. 6 to 7 revolutions.

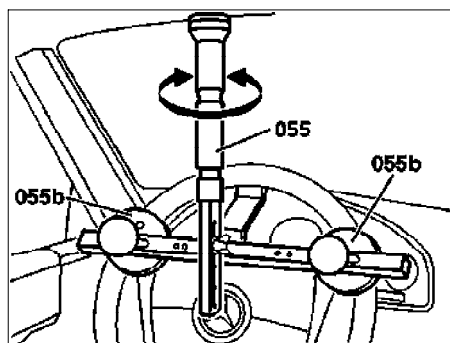


P46.10-0460-01

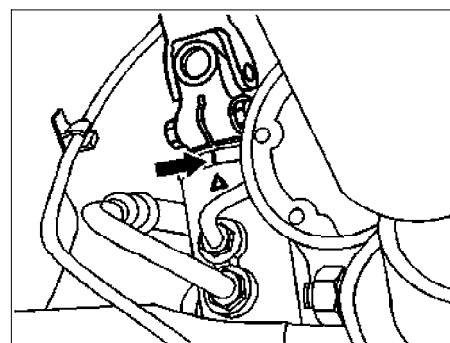


P46.10-0462-01

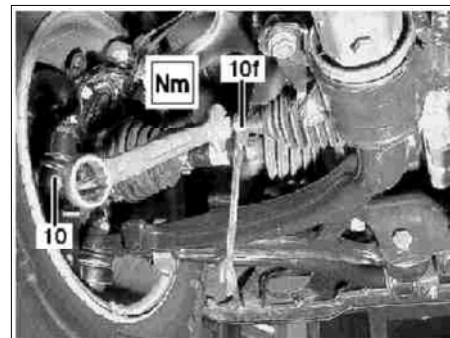
MODEL 163



P40.20-0307-01



P40.20-0354-01



P40.20-0348-01

Modification notes

27.7.01	Value changed from 0° 10'+ 10' to 0° 20'+ 10'	Value changed to BE40.20-P-1001-07A for model 163	*BE40.20-P-1001-07A
---------	---	---	---------------------

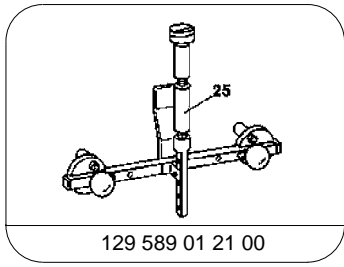
☐	Checking and adjusting		
1	Set steering wheel to center position	☑ by inserting retainer (055).	*129589012100
2	Check center position of steering gear and steering wheel	The steering gear is in the center position when the marking line on the cap is in line with the marking notch on the rotary valve (arrows) If necessary, offset the steering wheel by max. one tooth.	
3	Adjust the toe-in by slackening the locknut (10f) and twisting the tie rods (10).	ⓘ Check that the boot is not twisted after adjusting the toe-in Nm	*BE40.20-P-1001-07A *BA46.40-P-1002-01C

Front axle toe-in test values

Number	Designation	Model 163
BE40.20-P-1001-07A	Front axle toe-in	fi ° 0° 20'+ 10'

Nm Track rod

Number	Designation	Model 163
BA46.40-P-1002-01C	Clamping nut, tie rod to inner tie rod	Nm 50



129 589 01 21 00

Retaining device