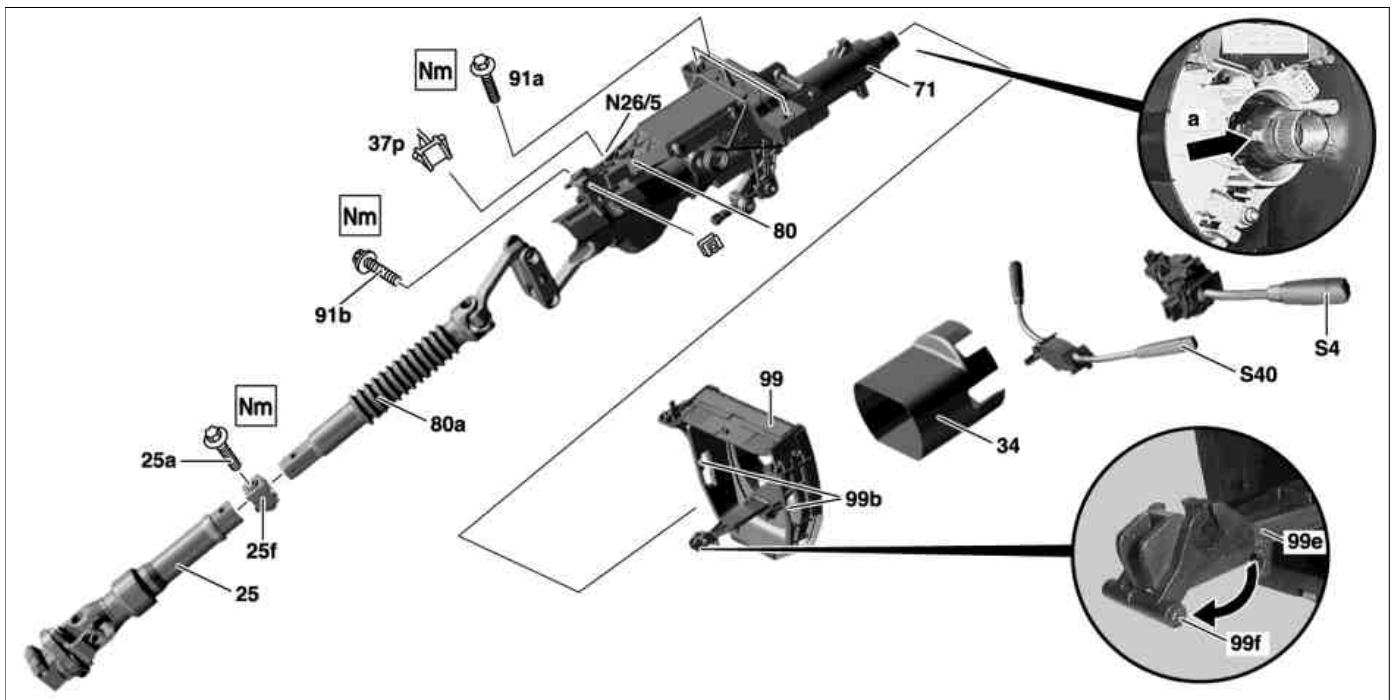


MODEL 203 (except 203.081 /084 /087 /092 /281 /284 /287 /292)  
mechanically adjustable steering column tube



P46.10-2353-09

25	Steering coupling	80a	Lower steering shaft	a	Turn signal indicator lug
25a	Screw	91a	Bolts	N26/5	Electric steering lock control unit
	Locking plate	91b	Screw	S4	Combination switch
34	Steering column switch module housing	99	Steering column tube cover	S40	CC [TPM] switch
37p	Plug connection	99b	Recesses		
71	Jacket tube	99e	Grip arm		
80	Steering column adjustment	99f	Toggle		

	Remove/install		
	Notes on self-locking nuts and bolts	All models	AH00.00-N-0001-01A
1	Extend the adjustable steering column fully	Needed for separating the steering coupling (25).	
2	Move steering to straight-ahead position	When the steering coupling (25) is dismantled the steering wheel must not be twisted, otherwise the clock spring contact may be destroyed.	
3.1	Detach lower engine compartment paneling	Model 203 with engine 111, 112, 113, 271, 272, 612.990	AR61.20-P-1105P
3.2	Remove bottom section of soundproofing	Model 203 with engine 611, 612 except 612.990, 642, 646	AR94.30-P-5300P
4	Detach exhaust shielding plate from firewall under the steering coupling (25)		
5	Remove bolt (25a)		*BA46.10-P-1001-01E
6	Pull the lower steering shaft (80a) upward to extract it from the steering coupling (25.)	Do not apply excessive force (hammer blows, excessive lever action) because the lower steering shaft (80a) is sensitive to lateral loads. <b>Installation:</b> Push the lower steering shaft (80a) all the way into the steering coupling (25), observing the pin on the steering coupling (25) and slot in the lower steering shaft (80a). <b>Installation:</b> Adjust steering gear center position: <div style="text-align: center;">↓</div> Center rack-and-pinion steering and mount steering coupling (25).	AR46.20-P-0600-01P

7	Detach locking plate (25f) from steering coupling (25)	<p><b>⚠ Installation:</b> To prevent components from loosening, install a new locking plate (25f) with self-locking nut and push on the locking plate (25f) until the lug engages in the steering coupling (25).</p> <p><b>i</b> Lift the lug with a suitable tool.</p>	
8	Remove electric steering lock control unit (N26/5)		AR46.10-P-0910P
9	Remove steering wheel		AR46.10-P-0100P
10	Remove clock spring contact	<p>Up to 30.6.02 As of 1.7.02 up to 23.4.04 As of 24.4.04</p>	<p>AR46.10-P-0200P AR46.10-P-0200Q AR46.10-P-0200PQ</p>
11.1	Remove cruise control switch (S40)	<p>Up to 23.4.04 with cruise control code 440 As of 24.4.04 with cruise control code 440</p> <p><b>i</b> Push in adjustable steering column fully so that an adequate line length is available.</p>	<p>AR54.25-P-2803P AR54.25-P-2803PQ</p>
12.1	Remove voice control system (VCS) switch	<p>As of 24.4.04 with Voice Control System (VCS [SBS]) code 813</p> <p><b>i</b> Push in adjustable steering column fully so that an adequate line length is available.</p>	AR82.70-P-0002PQ
13	Remove combination switch (S4)	<p>Up to 23.4.04 As of 24.4.04</p> <p><b>i</b> Push in adjustable steering column fully so that an adequate line length is available.</p>	<p>AR54.25-P-2800P AR54.25-P-2800PQ</p>
14	Remove steering column switch module housing (34)		
15	Remove instrument cluster		AR54.30-P-6015P
16	Remove cover below left of dashboard		AR68.10-P-1500P
17	Remove left absorber under the dashboard		
18	Swivel locking handle (99f) forwards until this latches in the handle arm (99e)		
19	Press the handle arm (99e) downwards to separate from the steering column tube (71)		
20	Remove bolt (91b)	<b>Nm</b>	*BA46.10-P-1001-03F
21	Remove bolts (91a)	<p><b>i</b> <b>Installation:</b> Fit bolts (91a) and bolt (91b). The steering column tube (71) must remain movable. After aligning tighten the bolts (91a) first.</p> <p><b>Nm</b></p>	*BA46.10-P-1002-03F
22	Pull steering column tube (71) upwards with lower steering shaft (80a)	<b>i</b> Pull steering column tube (71) with lower steering shaft (80a) upwards until the lug of the steering column adjustment (80) is moved out of the guide bore.	
23	Push steering column tube (71) with lower steering shaft (80a) downwards	<b>i</b> Put down to the left.	
24	Detach steering column tube cover (99) and unclip at top		
25	Disconnect cable tie of cables on left and right at steering column tube covering (99)	<p><b>i</b> <b>Installation:</b> Before the cable ties are tightened, the following points must be processed:</p> <ul style="list-style-type: none"> <li>● Install combination switch (S4), CC [TPM] switch (S40), voice control system (VCS [SBS]) switch.</li> <li>● Pull out adjustable steering column all the way.</li> <li>● Make sure that lines are routed correctly.</li> <li>● The cable ties must be fixed in the cutouts (99b) on the side of the steering column tube cover (99).</li> </ul>	
26	Remove steering column tube covering (99)		
27	Take out steering column tube (71) with the lower steering shaft (80a) upwards	<p><b>⚠</b> Do not use force, as the lower steering shaft (80a) is sensitive to forces applied from the side.</p> <p><b>i</b> The rubber boot remains in the firewall.</p> <p><b>i</b> <b>Installation:</b> The turn signal lug (a) on the steering column must point to the left (arrow).</p>	
28	Install in the reverse order		
29	Grease the boot on the inside front of the firewall, in the area of the bearing seat	Clueber Polylub GLY 801 grease	*BR00.45-Z-1046-06A
30	Carry out function check		

**Nm** Steering shaft

Number	Designation			Model 203 except 203.081/ 084/087/ 092/281/ 284/287/ 292
BA46.10-P-1001-01E	Bolt, steering coupling to steering shaft	Stage 1	Nm	30
		Stage 2	⊥°	-

**Nm** Jacket tube

Number	Designation		Model 203
BA46.10-P-1001-03F	Lower bolt, jacket tube to cross member below instrument panel	Nm	20
BA46.10-P-1002-03F	Upper bolt, jacket tube to cross member below instrument panel	Nm	20

**Repair materials**

Number	Designation	Order number
BR00.45-Z-1046-06A	Klueber Poly lub GLY 801 grease	A 001 989 84 51