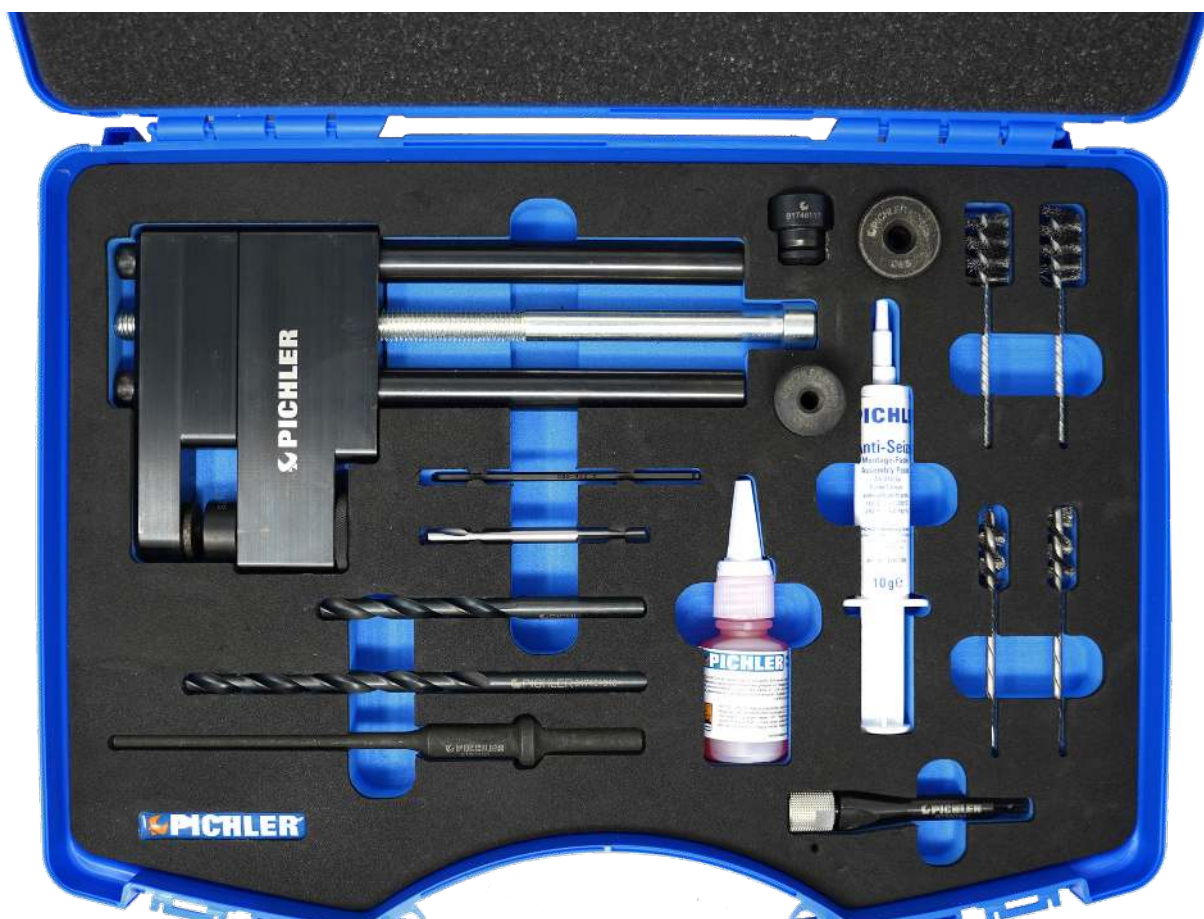




DRILLING-OUT KIT VAG 4-LINK BOLT VAG

Manual

91746150



SAFETY NOTICE

To understand the functioning of the tools, is it necessary to read the manual first!

- > Read these instructions before assembling, during installation and throughout use and in the proper sequence
- > Always refer to the OEM manufacturer's instructions and service manuals for the latest data and to maintain the correct sequence
- > These work instructions and the recommended tools are meant to serve as aides only and are by no means a guarantee for certain results.
- > This tool kit is a special collection and it has been tested and used successfully on several occasions. It is of the utmost importance to maintain the correct procedure as per the instructions
- > The use of the tools should only be carried out by qualified personnel!



ATTENTION

Special caution



CORRECT



LIGHT BULB

Hint or recommendation



WRONG



SAFETY GOGGLES

Wearing safety goggles
necessary



Nr.	Part.-Nr.	Description	91746150
1	91746100-1	Drilling-out kit	1
2	91746110	Centering cone Ø 10 mm	1
3	91746116	Centering cone SW16	1
4	91746106	Drill bush Ø 6 mm	1
5	91746117	Centering cone SW17	1
6	91746108	Drill bush Ø 8,5 mm	1
7	151.2103	Hex key SW3	1
8	91746126	Drill bit Ø 6 mm	1
9	917461306	HSCO Twist drill 6,0 mm short	1
10	917461316	HSCO Twist drill 6,0 mm	1
11	917461308	Twist drill short Ø 8,5mm	1
12	917461318	Twist drill long Ø 8,5 mm	1
13	6180155	Drift punch	1
14	90417911	Cutting oil	1
15	81601000	Grease paste	1
16	9039036	Special brush holder	1
17	9039032	Brush Ø 18 mm	1
18	9139010-1	Brush Ø 10 mm	1

WORK STEPS

Clean the screw head and the nut of the clamping screw with a wire brush.



Depending on the clamping screws, select the appropriate centering cone **91746116** ③ for SW16 or **91746117** ⑤ for SW17.



Insert the selected centering cone into the clamping device **91746100-1** ①.



Attach the clamping device **91746100-1** ① to the steering knuckle.



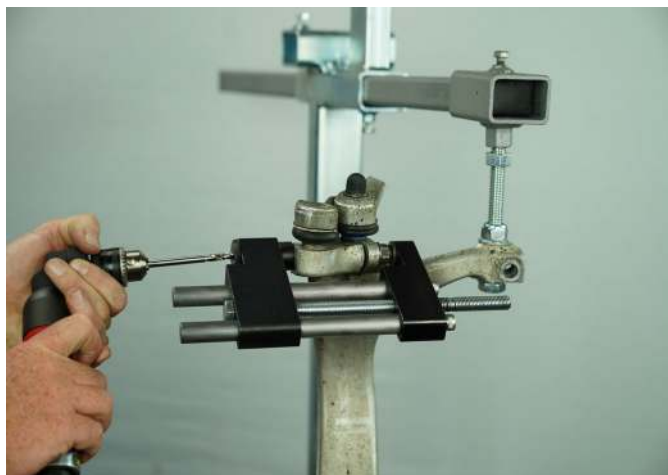
Use the Hex key to tighten the clamping device **91746100-1** ① to the steering knuckle.



Clamp the Ø 6 mm pilot drill **91746126** ⑧ into an angle drilling machine and moisten with the cutting oil **90417911** ⑭.



Guide the drill bit through the drill bush $\varnothing$ 6 mm **91746106** ④ already clamped in the clamping device and center the screw head of the clamping screw.



Clamp the twist drill short $\varnothing$ 6,0 mm **91746123** ⑨ into the angle drilling machine and moisten with cutting oil **90417911** ⑭.



Guide the clamped drill bit through the drill bush $\varnothing$ 6,0 mm **91746106** ④ and drill out the clamping screws.



Replace the drill bit short Ø 6,0 mm **91746123** ⑨ with the drill bit long Ø 6,0 mm **91746124** ⑩ and moisten it with cutting oil **90417911** ⑭.



Guide the clamped drill bit through the drill bush Ø 6,0 mm **91746106** ④ drill out the clamping screws.



Loosen the grub screw in the clamping device and replace the drill bush Ø 6 mm **91746106** ④ with the drill bush Ø 8.5 mm **91746108** ⑥. Then clamp the drill bush over the flat again with the grub screw.



Clamp the twist drill short Ø 8.5 mm **91746127** (11) into the angle drilling machine and moisten with cutting oil **90417911** (14).



Guide the clamped drill bit through the drill bush Ø 8.5 mm **91746108** (6) and drill out the clamping screws.



Replace the drill bit short Ø 8.5 mm **91746127** (11) with the drill bit long Ø 8.5 mm **91746128** (12) and moisten it with cutting oil **90417911** (14).



Guide the clamped drill bit through the drill bush $\varnothing$ 8.5 mm **91746108** ⑥ and drill out the clamping screws.



Loosen the Allen key of the clamping device and remove it from the steering knuckle.



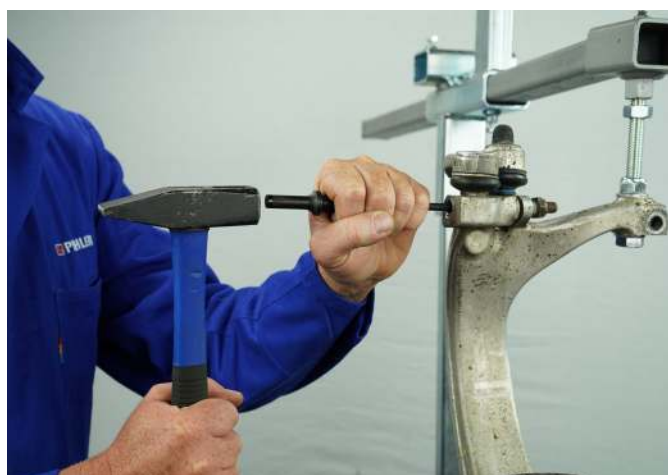
Tear off the drilled screws by turning the screw head.



Loosen the still tight clamping screws by turning the nut.



Remove the remaining clamping screws from the steering knuckle with the aid of the drift punch **6180155** (13)



Clamp the interior brush $\varnothing$ 10 mm **9139010-1** (17) into the special holder **9039036** (16). With an angle drilling machine, turn clockwise to clean the clamping bore on the steering knuckle.



After the ball joints have been removed, these holes can be cleaned with the interior brush Ø 18 mm **9139032** (18).



RECOMMENDED ACCESSORIES

HEAT INDUCTOR „POWER DUCTOR“ 1750W

9535600



PNEUMATIC ANGLED DRILL WITH LEFT AND RIGHT HANDED ROTATION

82004040



PNEUMATIC HAMMER SET VIBRO-IMPACT

80257000



UNIVERSAL KNOCKOUT MANDREL

61758030



SPARE PIVOT PINS PAIR WITH GRUB SCREW FOR KNOCKOUT PIN WISHBONE BALL HEADS

61758032



SPACER SET „4L“ HUB CLAMP

61746860



SUSPENSION ARM LEVER

62016700



CLAMPING ELEMENT WITH RATCHET KEY FOR 62016700

62016710



WISHBONE LEVER TOOL UNI WITH CLAMPING ELEMENT WITH RATCHET RING SPANNER

62016715



NOTES



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