

## Fitting Instructions for UR4083KIT, UR15145KIT and UR12748KIT

### Fitting Instructions:

1. Once dismantled ensure that all parts (new and old) are clean before fitting.
2. Follow the instructions in the Rolls-Royce Workshop Manual for general guidance for the removal and assembly until the shimming and adjustment stage.

Instructions can be found in the following chapters:

- Silver Cloud & Bentley S Type - Chapter N4 Steering Levers
- Silver Shadow & Bentley T Type - Chapter N6 Steering Linkage
- Silver Spirit & Bentley Mulsanne - Chapter N5 Ball pin unit

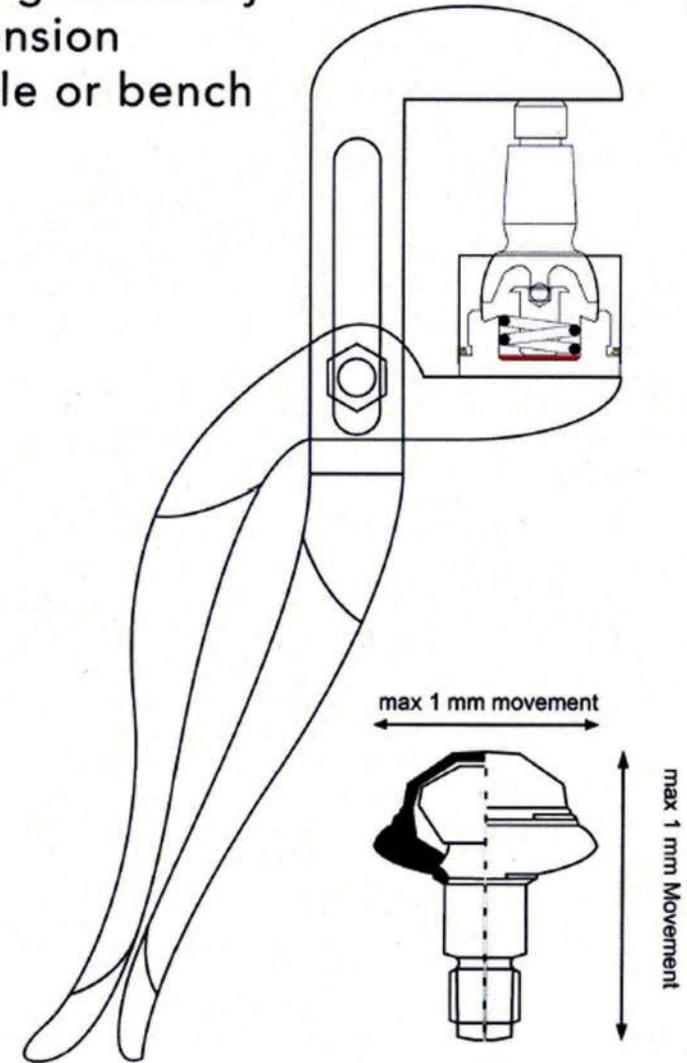
3. When fitting the ball pin and ball bearing supplied, fit both shims to the screwed retaining plug and fit to the assembly (fitting just one shim prior may damage the assembly).
4. Measure the free-play as described in fig.1. If the free-play exceeds 1mm, remove the thinnest shim and try again. If the free-play still exceeds 1mm, replace the thin shim and remove the thick shim. If free-play still exceeds 1mm remove both shims. If free-play still exceeds 1mm we recommend checking the main seat.
5. Check the torque resistance of the ball pin in the assembly, see fig.2 and fig.3. Resistance should not exceed 60 lb ins or 7 Nm when the free-play under compression is between 0.50mm and 1.00mm. Normally figures of 25 lb ins / 2.80 Nm can be expected but the assembly is safe to higher levels.

Torque Tightening figures for all models are as follows:

- Screwed Retaining Plug : 45 lbs ft to 50 lbs ft / 62Nm to 70Nm
- Ball pin nut: 35lbs ft to 40 lbs ft / 48 Nm to 55Nm.

## Measuring assembly under tension on vehicle or bench

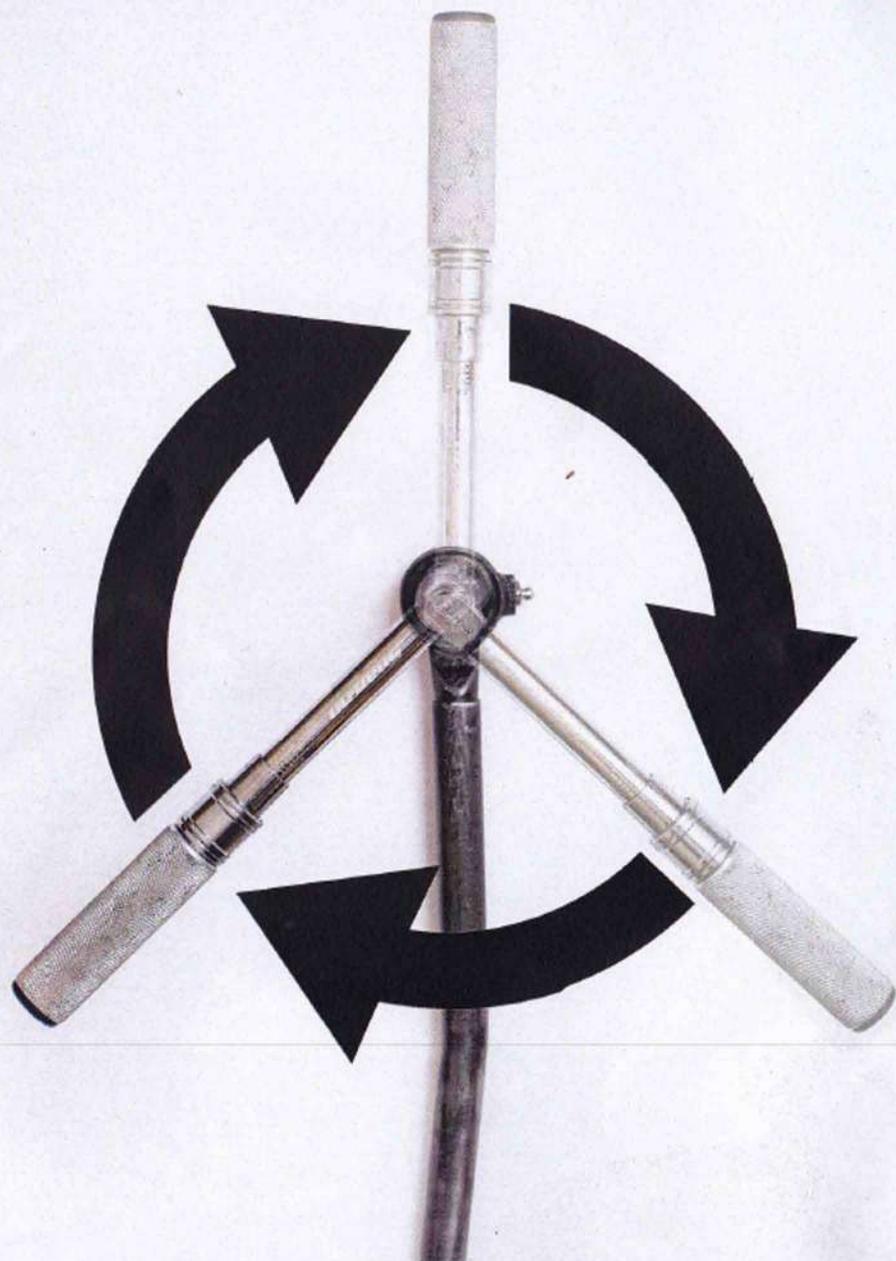
fig.1



**Figures of 1mm 0.040 Inch are established  
from Drawing RF7552 working specs**

Measuring rotational torque resistance

fig.2



Angular torque resistance

fig. 3

