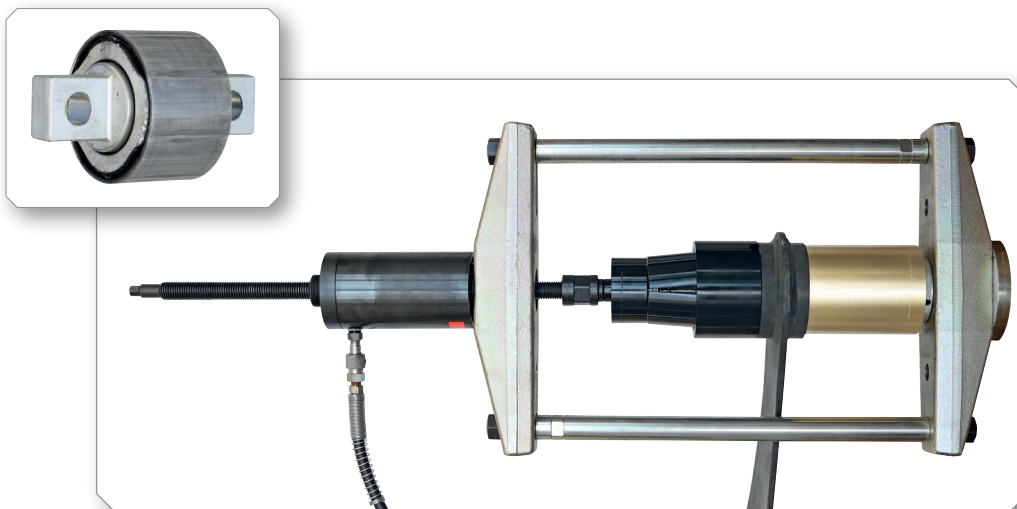
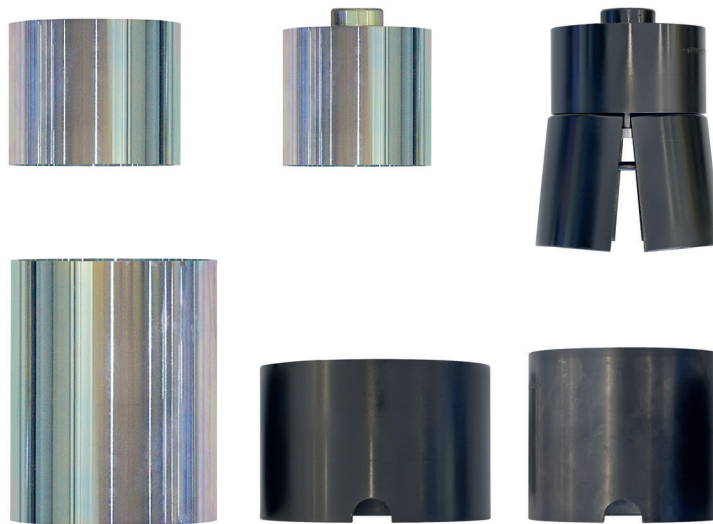


KL-1009-20

Silent Bloc Tool Ø 85/Ø 99, Mercedes-Benz



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1. READ AND UNDERSTAND FOR SAFETY



These operating instructions are part of the **SILENT BLOC TOOL** and are intended to familiarise you with this special tool. Read and understand these operating instructions before using the special tool and follow all instructions, regulations and notes for safe use. Keep the operating instructions in a safe place so that you or subsequent users can access them at any time. Be aware that misuse of the special tool can, in the worst case, lead to **DEATH** or **SERIOUS INJURY**! Stop work immediately if you are unsure how to use the special tool and contact **GEDORE-Automotive** if necessary.

1.1 Target group

These operating instructions are intended **exclusively** for trained specialists with comprehensive expertise in the repair of motor vehicles = motor vehicles.

- ▶ The special tool **may only** be used in specialist automotive workshops by trained specialists who have the necessary expertise in handling special automotive tools and are familiar with the applicable regulations on occupational safety, accident prevention and environmental protection.
- ▶ The special tool **must never** be used by unauthorised, inexperienced, underage or physically, sensory or mentally impaired persons, **or** by persons who are tired or under the influence of medication, alcohol, drugs or similar intoxicating substances.

1.2 Obligations of the owner

According to the German Ordinance on Industrial Safety and Health (*BetrSichV*), employers are obliged to provide their employees with safe work equipment! The special tool from GEDORE-Automotive complies with the recognised rules of technology and relevant safety regulations at the time it is placed on the market.

- ▶ The **owner** of the special tool **must ensure that only** trained specialists in specialist vehicle workshops use the special tool!
- ▶ The **owner** of the special tool **must ensure** that the associated instructions are available to the user and that he has read and understood them in full **before** using the special tool!
- ▶ The **owner** of the special tool **must ensure** that the user has the necessary expertise in handling special automotive tools, is familiar with the applicable regulations on occupational safety, accident prevention and environmental protection, and is provided with personal protective equipment!

1.3 Intended use

The **SILENT BLOC TOOL**...

- ... **may only** be used **on commercial vehicles, in particular on the vehicles mentioned in chapter 2!**
- ... **may only** be used **for pressing out and pressing in Silent blocs on the rear axle stabiliser!**
- ... **may only** be used **up to a maximum load of 28 tonnes !**
- ... **may only** be used **by hand using muscle power with a manual drive or a manually driven GEDORE Automotive hydraulic cylinder/pump combination with pressure gauge for safe pressure control!**
- ... **may only** be used **with GEDORE Automotive original spare parts and accessories!**
- ... **may only** be used **in the manner described in these Operating instructions!**
- ⚠ Any other use may result in **DEATH** or **SERIOUS INJURIES** !

1.4 Reasonably foreseeable misuse

The **SILENT BLOC TOOL**...

- ... **must never** be used **to press out or press in other parts or in any other way than intended!**
- ... **must never** be used **with an impulse or impact wrench!**
- ... **must never** be used **with a machine drive, a machine-driven hydraulic cylinder/pump combination or a drive other than that intended!**
- ... **must never** be used **for series processing with many constantly repeating work processes!**
- ... **must never** be used **with a bridged, modified or removed safety device!**
- ... **must never** be modified, converted or misused without authorisation!
- ⚠ **Always** use the special tool as intended. Any other use may result in **DEATH** or **SERIOUS INJURIES** !

1.5 Personal protective equipment

For your own safety, wear personal protective equipment when using the special tool! The special tool can cause mechanical hazards such as crushing, cuts and impact injuries.



Wear **EYE PROTECTION EQUIPMENT** (e.g. DIN EN 166, OSHA 29 CFR 1910.133, ANSI Z87) when using the special tool to protect against flying parts or particles!

►When using the special tool, flying parts or particles can cause **SERIOUS INJURY** to your **eyes** !



Wear **PROTECTIVE GLOVES** (e.g. DIN EN 388, OSHA 29 CFR 1910.138, ANSI 105) when using the special tool to protect against sharp edges and crushing between parts!

►When using the special tool, sharp edges and crushing between parts can cause **SERIOUS INJURY** to your **hands** !



Wear **SAFETY SHOES** (e.g. DIN EN ISO 20345, OSHA 29 CFR 1910.136, ANSI Z41) when using the special tool to protect against falling parts!

►When using the special tool, falling parts can cause **SERIOUS INJURY** to your **feet and toes** !

1.6 Labelling of the warnings

Warning notices indicate **potential dangers** which, if ignored, can lead to **DEATH** or **SERIOUS INJURY** in the worst case and must therefore be observed at all times. In these operating instructions, the warnings are classified as follows for better differentiation and recognisability:

Warning signs	Meaning
WARNING	Indicates a potentially hazardous situation which, if not avoided, could result in DEATH or SERIOUS INJURY !
CAUTION	Indicates a hazardous situation which, if not avoided, can lead to MEDIUM or LOW INJURIES !
ATTENTION	Indicates a situation which, if not avoided, can lead to damage to the tool or objects in its vicinity!
i	Reference to important information and useful tips.

1.7 Working environment

Only use the special tool in a safe working environment and **do not** expose it to extreme temperatures, direct sunlight, extreme humidity or moisture!

- The workplace **must** be clean and tidy.
- The workstation **must** be sufficiently large and well lit.
- The workplace **must** have a stable and non-slip surface.
- The workplace **must** be secured against access by unauthorised persons.
- The workplace **must** have a room temperature between -10 °C and +40 °C.

1.8 Emissions

Hydraulic oil and molybdenum disulphide paste can drip or leak when using the special tool and pose a risk to the environment.

- Immediately** remove any leaking hydraulic oil and excess molybdenum disulphide paste, e.g. using an oil binding agent or a cleaning cloth.
- In the event of skin contact, clean the affected area **immediately** with degreasing soap and water.
- Always** dispose of harmful substances such as hydraulic oil and molybdenum disulphide paste **in an environmentally friendly manner**.
- Safety data sheets *in accordance with Regulation (EC) No. 1907/2006* for hydraulic oil (**Alsus Hyd HLP 32 or 46**) and for molybdenum disulphide paste (**MOLYKOTE® G-N PLUS PASTE**) can be found on the manufacturer's website (**World Wide Web**) or contact **GEDORE Automotive** if necessary.

1.9 Basic safety, warning and handling instructions

⚠ WARNING ⚠ CAUTION ATTENTION

Disregarding this can lead to life-threatening situations, injuries and damage!

Always observe the following safety, warning and handling instructions when using the special tool and strictly adhere to all measures to avoid life-threatening situations, injuries and property damage due to hazards, misuse, abuse or improper handling.

- ▶ **Use only by specialist personnel:** The special tool may only be used in specialist vehicle workshops by trained specialists who have the necessary expertise and are familiar with the applicable regulations.
- ▶ **Do not use when tired or intoxicated:** The special tool must never be used by unauthorised or impaired persons or by persons who are tired or under the influence of intoxicating substances.
- ▶ **Read the instructions:** The special tool must be used in accordance with these operating instructions and any instructions for accessories, and all instructions, regulations and notes contained therein must be strictly observed.
- ▶ **Comply with the applicable safety regulations:** The special tool must always be used in accordance with the applicable regulations on occupational safety, accident prevention and environmental protection.
- ▶ **Wear personal protective equipment:** The special tool must always be used with the required protective equipment, such as safety goggles, protective gloves and safety shoes.
- ▶ **Only use original parts:** The special tool may only be used with original spare parts and accessories from GEDORE-Automotive.
- ▶ **Check before use:** The special tool must be checked for damage, loose parts, unauthorised modifications and suitability for the intended application before use.
- ▶ **Regular safety checks:** For safety reasons, the special tool should be subjected to a safety check every 24 months by authorised specialist personnel from GEDORE-Automotive.
- ▶ **Do not use if damaged or defective:** The special tool must not be used in the event of damage or other defects and must be checked and repaired before the next use.
- ▶ **Repairs or servicing by specialised personnel only:** For safety reasons, the special tool may only be repaired or serviced by specially trained GEDORE-Automotive personnel.
- ▶ **Stop work immediately if handling is unsafe:** The special tool must not be used if it is unsafe to handle; if necessary, consult the instructions or obtain support from GEDORE-Automotive.
- ▶ **Clean and lubricate regularly:** The special tool, especially the spindle, must be checked regularly for contamination, cleaned if necessary and treated with approved lubricants.
- ▶ **Do not use mechanical drives:** The special tool must never be used with mechanical drives, but only after its intended use with a manual drive using muscle power.
- ▶ **Comply with vehicle-specific application procedures:** The special tool must always be used in accordance with the vehicle manufacturer's instructions and specifications for vehicle-specific application sequences.
- ▶ **Secure the immediate working area:** The special tool may only be used if there are no unauthorised persons in the immediate working area.
- ▶ **Ensure stability:** The special tool must generally be checked for stability and a secure hold, in particular the hydraulic cylinder must be secured against falling and being thrown about, e.g. by holding it firmly or using a safety holding strap or a holding device from GEDORE-Automotive.
- ▶ **Never exceed the maximum load:** The special tool must never be overloaded or operated with a higher load than the maximum permissible.
- ▶ **Never use for series production:** The special tool must never be used for series production, especially not for processes that are repeated quickly and carried out at short intervals.
- ▶ **Never leave unattended when under load:** The special tool must never be left unattended on the vehicle or component, especially when under load.
- ▶ **Avoid damaging effects of force:** The special tool must never be impaired by impacts, clamping or other damaging effects of force, especially not when under load.
- ▶ **Cleaning after use:** The special tool may only be cleaned after use with a clean, dry cleaning cloth. Immersion in water, solvents or other cleaning fluids is strictly prohibited.
- ▶ **Environmentally friendly disposal:** The special tool and packaging material must always be disposed of in an environmentally friendly manner in compliance with legal requirements. If in doubt, contact the local authorities.
- ▶ **Exclusion of liability, warranty and guarantee:** The special tool must always be used in compliance with the safety regulations. In the event of disregard or misuse, the user assumes sole responsibility and GEDORE-Automotive excludes any liability, warranty or guarantee claims.
- ▶ **Disclaimer regarding documentation:** The special tool and its use are carefully described in these instructions, but technical changes, errors, incompleteness, inaccuracies, mistakes and damage or consequences due to incorrect use or misuse can never be ruled out.

1.10 Maintenance

Carry out maintenance on the special tool regularly and only when it is depressurised! Insufficient or improper maintenance can cause damage to the special tool and result in life-threatening situations, serious injuries and property damage during use.

Before each use:

- **before each use**, carefully check the special tool for damage, loose parts or unauthorised modifications and, in particular, bolt connections for a tight fit.
- **before each use**, check moving parts and the spindle of the special tool for free movement and contamination. If necessary, clean and then lubricate them exclusively with molybdenum disulphide paste, e.g. **KL-0014-0030** from GEDORE-Automotive.

Recommended every 24 months:

- Have the special tool professionally checked for safety **every 24 months** by authorised GEDORE-Automotive specialists.

1.11 Troubleshooting

Only carry out troubleshooting on the special tool when it is depressurised!

Problem: Hydraulic oil is leaking from the hydraulic coupling between the hydraulic cylinder and hand pump.

Cause: Hydraulic coupling contaminated or loose.

Remedy: Clean and retighten the hydraulic clutch. Top up missing hydraulic oil (**HLP 32 or 46**) at the hand pump.

Problem: Hydraulic hand pump does not build up pressure or only very slowly.

Cause: Pressure release valve on the hand pump is open or hydraulic oil is missing.

Remedy: Close the pressure release valve on the hand pump completely and top up the hand pump with any missing hydraulic oil (**HLP 32 or 46**).

Problem: Thrust spindle of the mechanical drive runs stiffly in the thread.

Cause: Spindle contaminated or insufficiently lubricated or incorrect lubricant used.

Remedy: Clean the spindle, check for damage and lubricate **exclusively** with molybdenum disulphide paste. (e.g. **GEDORE Automotive - KL-0014-0030**)

1.12 Care / storage

ATTENTION

Improper care and storage can lead to damage to the special tool.

- **Never** immerse the special tool in water, solvents or other cleaning fluids.
- **Only** clean the special tool with a dry and clean cleaning cloth.
- **Only** protect the special tool with special acid-free oils or greases for tool care.
- **Always** store the special tool in a dry and clean place together with the corresponding operating instructions.

1.13 Maintenance

WARNING

Improper repair of the special tool can lead to **DEATH** or **SERIOUS INJURY**.

- If damage, loose parts or unauthorised modifications are found on the special tool, it must no longer be used for safety reasons!
 - Repairs may only be carried out by specially trained personnel at **GEDORE Automotive**!
 - **Only** use original spare parts and accessories from **GEDORE Automotive** for the special tool!
- If necessary, please contact us at **GEDORE Automotive** for a professional inspection and repair of the special tool.

1.14 Environmentally friendly disposal

Dispose of the special tool and packaging material in an environmentally friendly manner in accordance with the legal requirements. If necessary, ask your local authority about environmentally friendly disposal options.

2. PRODUCT DESCRIPTION

2.1 KL-1009-20 - Silent bloc tool Ø 85/Ø 99, Mercedes-Benz

Suitable for silent blocs on the rear axle stabiliser, e.g. for Mercedes-Benz Actros (MP4, MP5), Antos, Arocs, Atego (MP2), Econic (MP2) and other...


Especially suitable for silent blocs with OEM no.:







A 942 326 00 50 (Installed = Ø 85mm / Removed = Ø 88mm)

A 960 326 12 81 (Installed = Ø 99mm / Removed = Oval Ø 102x98mm)

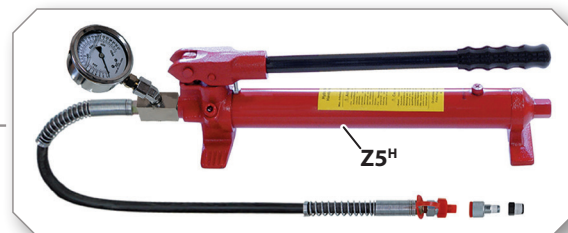
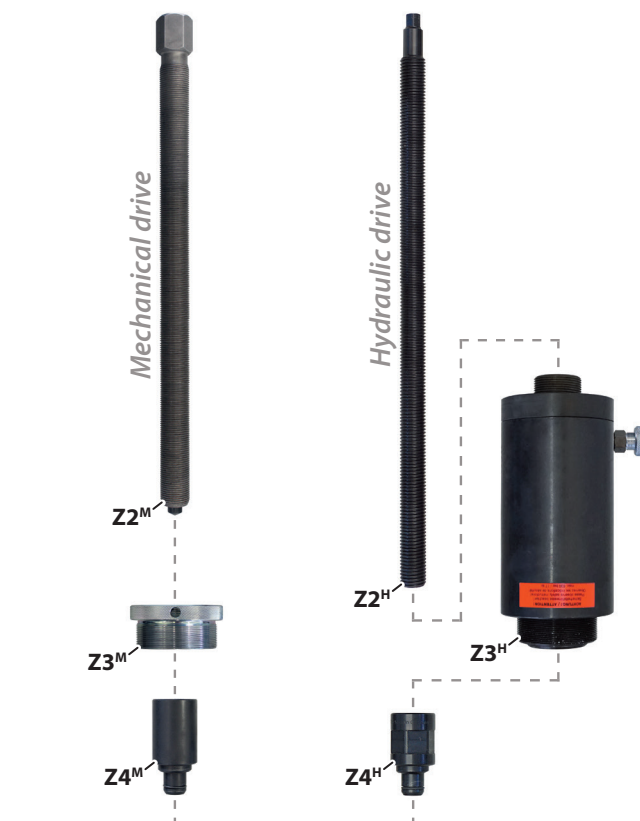
- Pulling device for professional removal and installation of the silent blocs on the rear axle stabiliser.
- Enables quick and easy replacement of the silent bloc directly on the vehicle.
- The silent bloc is preloaded and pressed in using the special thrust piece and the conical sleeve.
- It does not matter whether the silent blocs have a conventional round or special oval shape.
- This eliminates the need for costly replacement of the complete rear axle stabiliser.
- Separate drive parts and the NFZ press frame **KL-1039-111** are required for use.

2.2 Scope of delivery/single part overview/drive parts

 This table shows all components for the silent bloc tool. Before using it, check that all parts included in the scope of delivery are present and assemble the additional parts required accordingly.

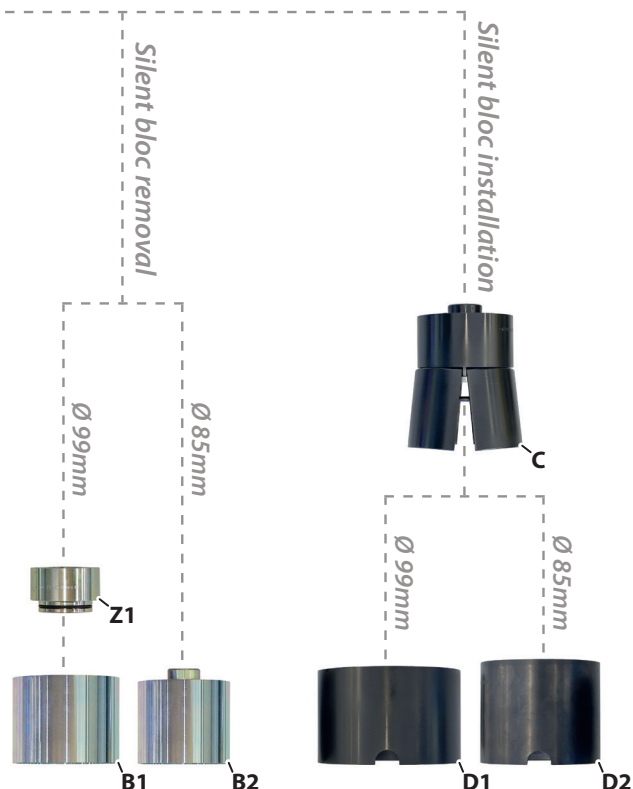
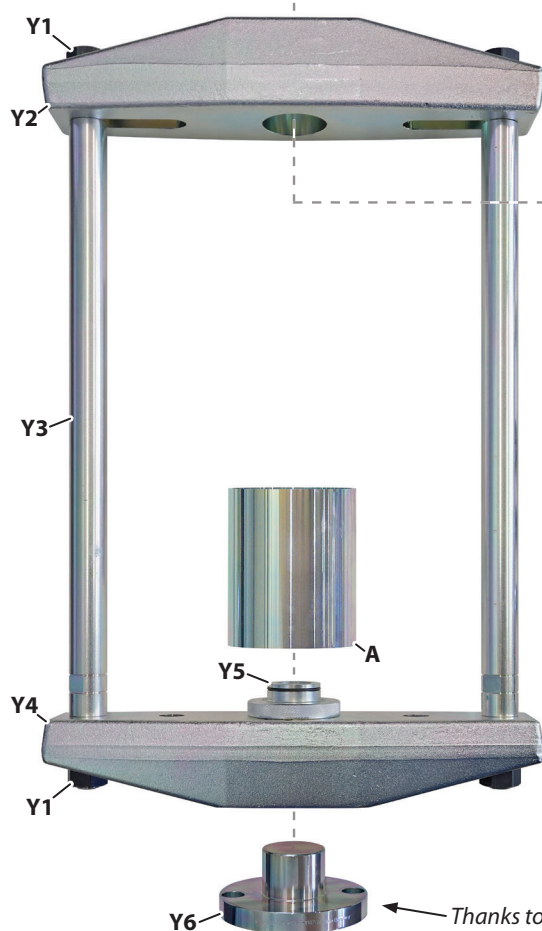
Individual parts...		Pos.	Tool set... KL-1009-20
Supporting sleeve... 			
KL-1009-2001 - Supporting sleeve Ø 120mm		A	●
Pressure sleeves... 			
KL-1009-2002 - Pressure sleeve Ø 99mm		B1	●
KL-1010-5105 - Pressure sleeve Ø 85mm		B2	●
Resilient thrust piece... 			
KL-1010-5302 - Resilient thrust piece		C	●
Conical sleeves... 			
KL-1010-5301 - Conical sleeve Ø 99mm		D1	●
KL-1010-5101 - Conical sleeve Ø 85mm		D2	●
Press frame... 			
KL-1005-1014 - Hexagon collar nut M22		Y1	+ 4x
KL-1005-1011 - Base plate top		Y2	+
KL-1039-1102 - Tie rod M22		Y3	+ 2x
KL-1039-1101 - Base plate bottom		Y4	+
KL-1039-1105 - Adapter		Y5	+
KL-1039-1107 - Mounting foot		Y6	+
Drive parts... 			
KL-0039-1002 - Mounting adapter		Z1	+
...Hydraulic^H	KL-0040-2812-1 - Pull/push spindle M24 x 590mm	Z2H	+H
	KL-0040-2800 - Hydraulic cylinder 28t	Z3H	+H
	KL-0040-2812-5 - Thrust nut	Z4H	+H
	KL-0215-35 M28 - Hydraulic hand pump 28t	Z5H	+H
...Mechanical^M	1.3306500 - Thrust spindle G1 x 500mm	Z2M	+M
	KL-1005-8001 - Adapter 2¾"-16 UNS to G1	Z3M	+M
	KL-1005-8002 - Thrust piece	Z4M	+M

● = Included in Scope of delivery / + = Additionally required / ..^H = Hydraulic drive parts / ..^M = Mechanical drive parts



2.3 Technical data

Suitable for silent blocs: Ø 85 + 99mm
 Max. load on tool set: 28 tonnes
 Max. hydraulic cylinder load: 28 tonnes
 Press frame mounting thread: 2 3/4"-16 UNS

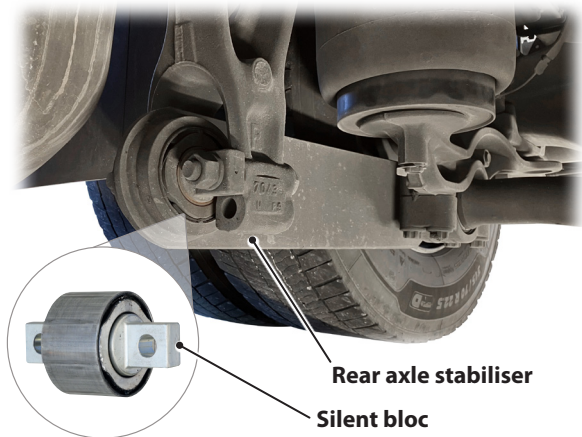


Thanks to the **mounting foot [Y6]**, the silent bloc tool can also be used as a stationary press, e.g. on a workbench.

3. PREPARATION

3.1 Prepare vehicle

📷1: Prepare the rear axle stabiliser accordingly...



ATTENTION

Various lines and cables on the vehicle can be damaged when replacing the silent bloc! It is therefore essential to ensure that these are not subjected to tension during the subsequent work.

1. Lift the vehicle safely and prepare all parts required for the silent bloc replacement according to the manufacturer's instructions.

For example:

Loosen and expose the rear axle stabiliser as far as necessary to replace the silent bloc.

3.2 Prepare the tool

📷2: Prepare the silent bloc tool accordingly...

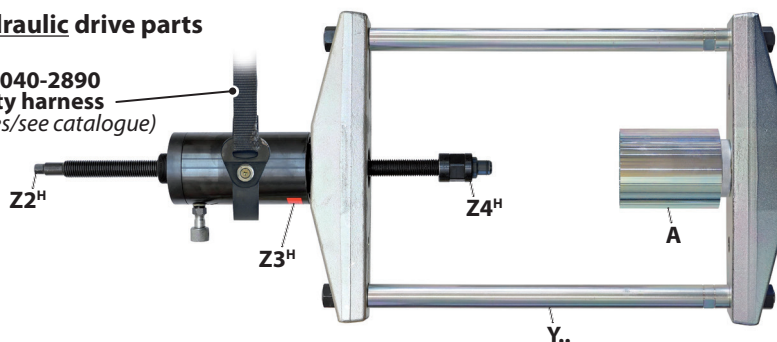
⚠️WARNING

The silent bloc tool can break and spin around if a mechanical drive is used. This can lead to DEATH or SERIOUS INJURY! Therefore, only drive the silent bloc tool by hand using muscle power with a manual drive or a manually driven GEDORE Automotive hydraulic cylinder/pump combination with a suitable pressure gauge for safe pressure control!

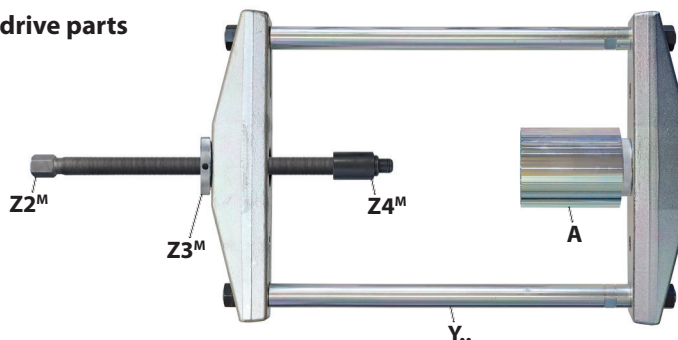
The silent bloc tool may fall during use. This can lead to SERIOUS INJURY! Therefore, secure the silentbloc tool against falling, e.g. by holding it firmly or, especially when using the hydraulic cylinder [Z3^H], using the safety retaining strap available as an accessory!

... with hydraulic drive parts

KL-0040-2890
Safety harness
(Accessories/see catalogue)



... with mechanical drive parts



1. Prepare the required drive parts, either **hydraulically** (..^H) or **mechanically** (..^M), as shown.

❗ For further drive parts and accessories, see also GEDORE-Automotive catalogue.

4. APPLICATION EXAMPLE

- ① This application example describes the pressing out and pressing in of a Silent bloc on the rear axle stabiliser using the silent bloc tool and hydraulic drive parts (..^H). If mechanical drive parts (..^M) are used, the process is also carried out according to the same principle."

4.1 Press out the silent bloc

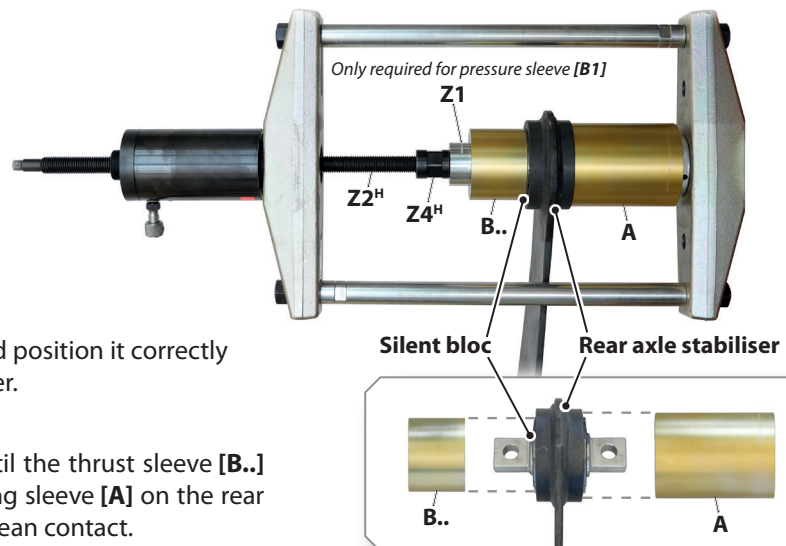
3: Attach the silentbloc tool to the rear axle stabiliser accordingly...

ATTENTION

The rear axle stabiliser can be damaged when the silent bloc is pressed out! It is therefore essential to ensure that the pressure sleeve [B..] and supporting sleeve [A] are centred in relation to the silent bloc!

1. Assemble the silent bloc tool as shown and position it correctly on the silent bloc of the rear axle stabiliser.

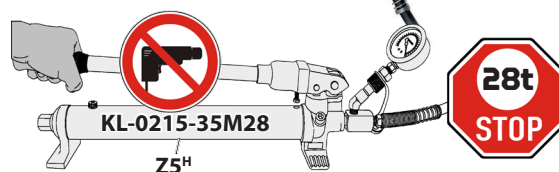
Screw in the thrust spindle [Z2^H] until the thrust sleeve [B..] on the silent bloc and the supporting sleeve [A] on the rear axle stabiliser are in complete and clean contact.



4: Press out the silent bloc in a controlled manner...

WARNING

The silent bloc tool can break and spin around due to overloading or misuse. This can lead to DEATH or SERIOUS INJURY! Therefore, never overload the silentbloc tool, never use it with a mechanical drive or in any other way than intended!



2. Connect the hydraulic hand pump [Z5^H] to the hydraulic cylinder [Z3^H].
3. Align the silent bloc tool in the centre of the silent bloc. Operate the hydraulic hand pump [Z5^H], observing the pressure on the pressure gauge, and press out the silent bloc in a controlled manner.

- ① The maximum stroke of the hydraulic cylinder [Z3^H] is **55mm**! As soon as this is reached: Interrupt the pressing process, release the pressure at the hydraulic hand pump [Z5^H], turn the pull spindle [Z2^H] and continue the pressing process.

Rear axle stabiliser
Silent bloc

4.2 Preload silent blocs

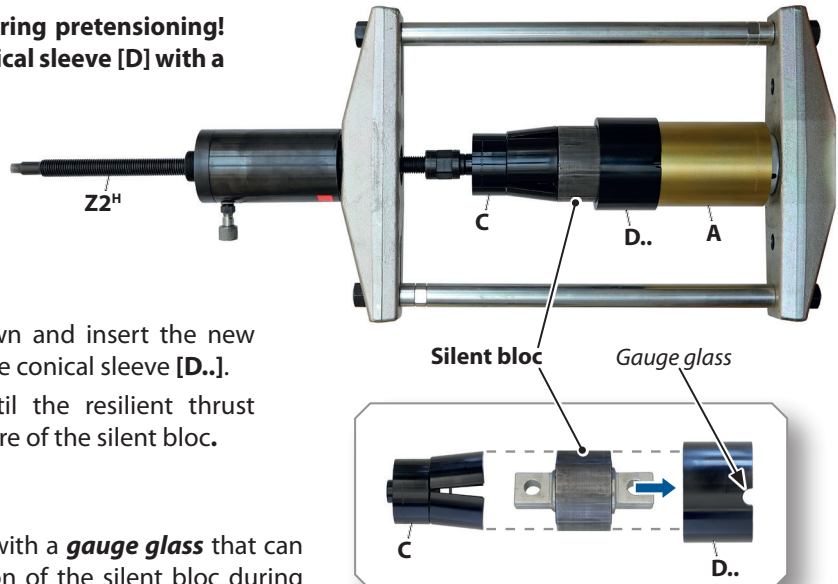
5: Insert the silent bloc accordingly on the silent bloc tool...

ATTENTION

The new silent bloc can be damaged during pretensioning! Therefore, rub the silent bloc and the conical sleeve [D] with a suitable lubricant beforehand!

1. Assemble the silent bloc tool as shown and insert the new silent bloc in the correct position on the conical sleeve [D..]. Screw in the thrust spindle [Z2^H] until the resilient thrust piece [C] is in full contact with the centre of the silent bloc.

① The conical sleeve [D..] is equipped with a **gauge glass** that can be used to check the correct position of the silent bloc during pretensioning.

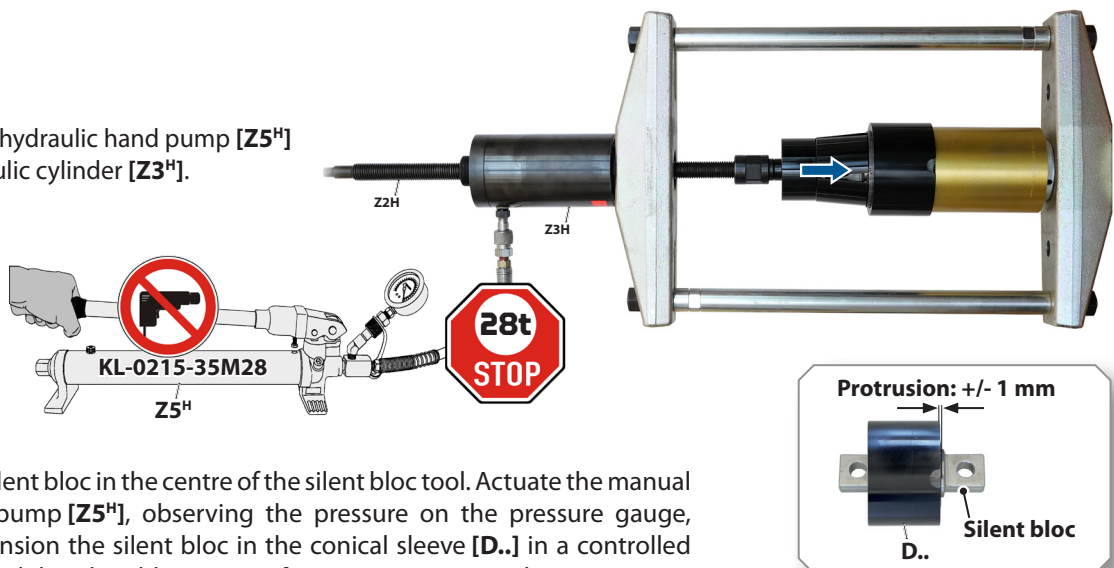


6: Preload Silent bloc in a controlled manner...

WARNING

The silentbloc tool can break and spin around due to overloading or misuse. This can lead to DEATH or SERIOUS INJURY! Therefore, never overload the silentbloc tool, never use it with a mechanical drive or in any other way than intended!

2. Connect the hydraulic hand pump [Z5^H] to the hydraulic cylinder [Z3^H].



3. Align the silent bloc in the centre of the silent bloc tool. Actuate the manual hydraulic pump [Z5^H], observing the pressure on the pressure gauge, and pre-tension the silent bloc in the conical sleeve [D..] in a controlled manner until the silent bloc **protrudes** approx. **1mm** at the rear.

① The maximum stroke of the hydraulic cylinder [Z3^H] is **55mm**! As soon as this is reached: Interrupt the pressing process, release the pressure at the hydraulic hand pump [Z5^H], turn the pull spindle [Z2^H] and continue the pressing process.

4.3 Press in the silent bloc

7: Attach the silent bloc tool with the preloaded silent bloc to the rear axle stabiliser...

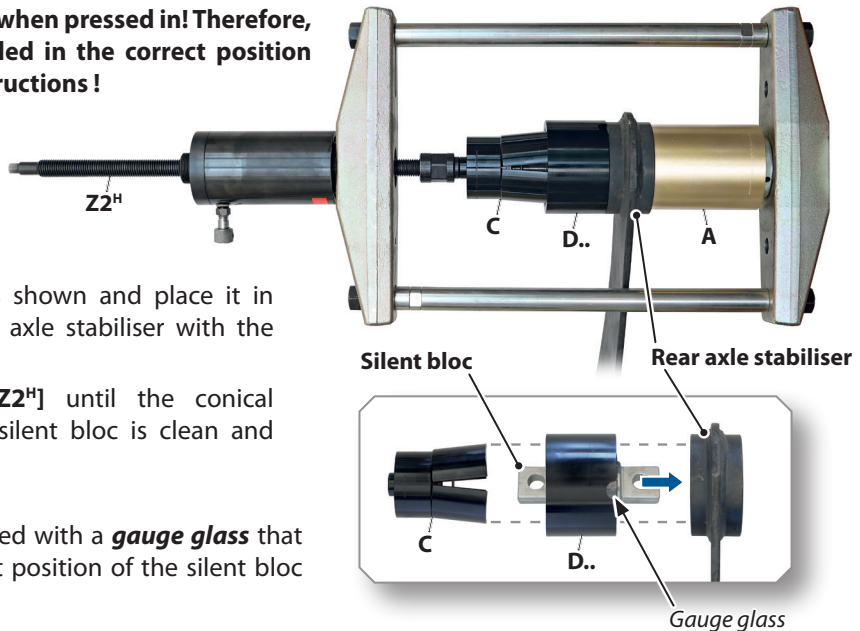
ATTENTION

The new silent bloc can be damaged when pressed in! Therefore, ensure that the silent bloc is installed in the correct position according to the manufacturer's instructions!

1. Assemble the silent bloc tool as shown and place it in the correct position on the rear axle stabiliser with the pretensioned silent bloc.

Screw in the thrust spindle [Z2^H] until the conical sleeve [D..] with the preloaded silent bloc is clean and centred on the rear axle stabiliser.

- i** The conical sleeve [D..] is equipped with a **gauge glass** that can be used to check the correct position of the silent bloc during installation.

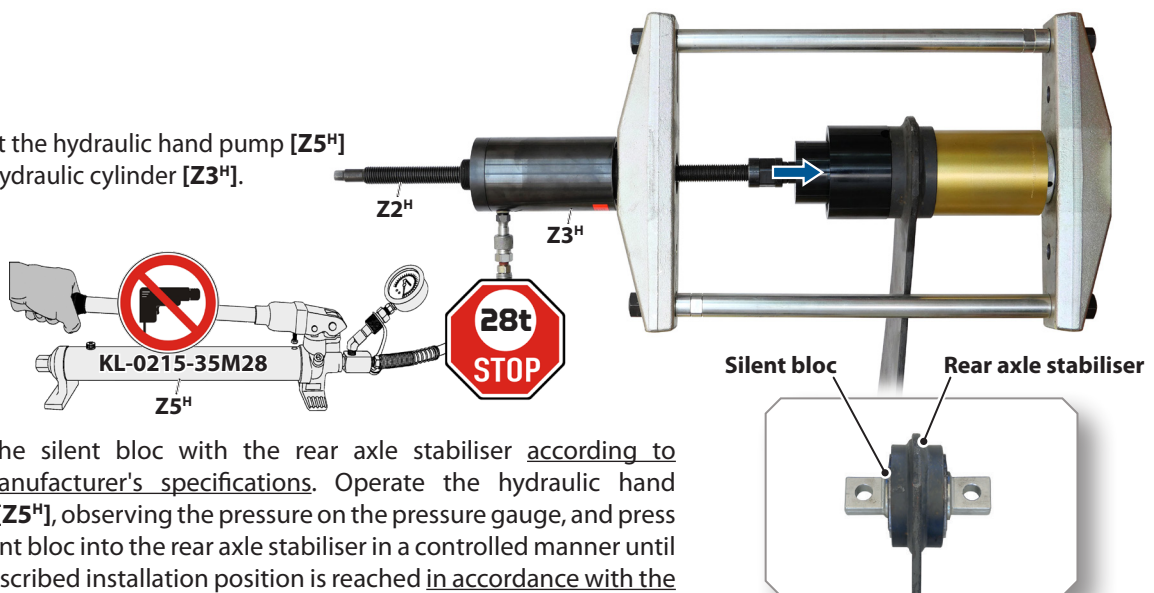


8: Preload silent bloc in a controlled manner...

WARNING

The silent bloc tool can break and spin around due to overloading or misuse. This can lead to DEATH or SERIOUS INJURY! Therefore, never overload the silent bloc tool, never use it with a mechanical drive or in any other way than intended!

2. Connect the hydraulic hand pump [Z5^H] to the hydraulic cylinder [Z3^H].



3. Align the silent bloc with the rear axle stabiliser according to the manufacturer's specifications. Operate the hydraulic hand pump [Z5^H], observing the pressure on the pressure gauge, and press the silent bloc into the rear axle stabiliser in a controlled manner until the prescribed installation position is reached in accordance with the manufacturer's specifications.

- i** The maximum stroke of the hydraulic cylinder [Z3^H] is **55mm!** As soon as this is reached: Interrupt the pressing process, release the pressure at the hydraulic hand pump [Z5^H], turn the pull spindle [Z2^H] and continue the pressing process.





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