

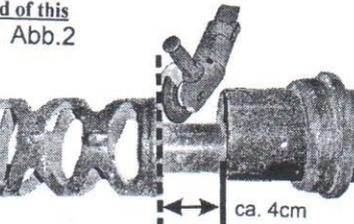
**Mounting instruction**

**Attention!!**

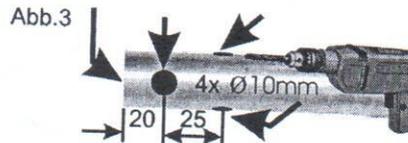
**Mounting of steering parts requires welding work (Abb.7.2) and may only be carried out by qualified personnel!! A corresponding certificate from the company that carried out this work must be presented together with the parts certificate when the vehicle is approved according to § 19 (3) StVZO.**

**Before proceeding with assembly, please note the advice at the end of this mounting instruction!!**

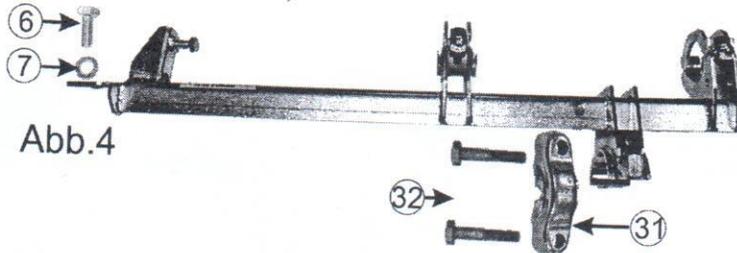
- disassemble tank, original steering gear incl. steering damper and track rods.
- cut steering column right after baffle pipe or, if there is no baffle pipe, cut like you see in Abb.2:



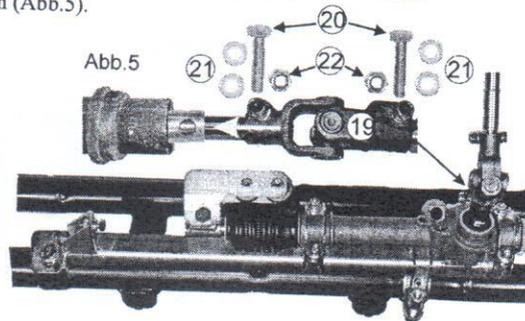
- disassemble steering column.
- drill 2x through the steering column by using a 10mm drill bit (Abb.3) and remove burr inside.



- remount steering column.
- Hold the delivered, pre-assembled holder for steering gear (Abb.4) beside the axle beam and fix it by using OEM holding bracket (optional 31) and OEM screws (optional 32) M10x50mm. Also fix it to the mounting point of the original steering damper with screw M10x25mm (6) and washer 10mm (7) (use threadlocker).

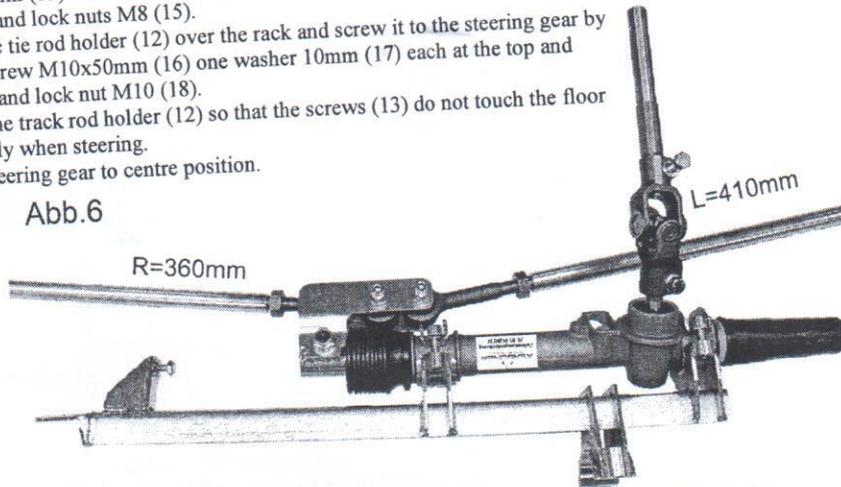


- Slide the pre-assembled cardan joint onto the steering gear until the fastening screw on the cardan joint is aligned with the groove on the steering gear. Screw the screws (20,21,22) and insert steering column adapter into steering column (Abb.5). Use clamps (2) to fix steering gear (1) to holder (5) (use threadlocker).

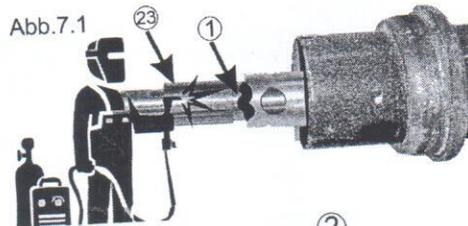


- Screw the pre-assembled track rods (24/25/26/27) to the track rod holder (12) by using hexagon socket screws M8x60mm (13) and one washer 8mm (14) each at the top and bottom and lock nuts M8 (15).
- Push the tie rod holder (12) over the rack and screw it to the steering gear by using screw M10x50mm (16) one washer 10mm (17) each at the top and bottom and lock nut M10 (18).
- Align the track rod holder (12) so that the screws (13) do not touch the floor assembly when steering.
- Turn steering gear to centre position.

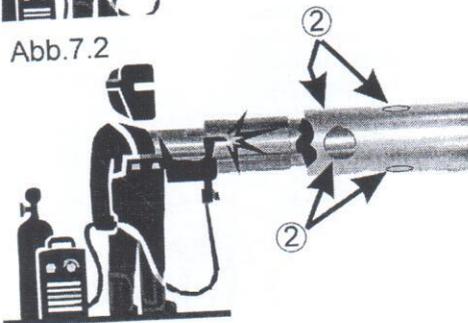
Abb.6



- Align the steering gear and cardan joint so that the steering column adapter is centered in the casing tube and the cardan joint can rotate free. If necessary, loosen or undo the two fastening screws M8x35 (20) and then tighten them again.



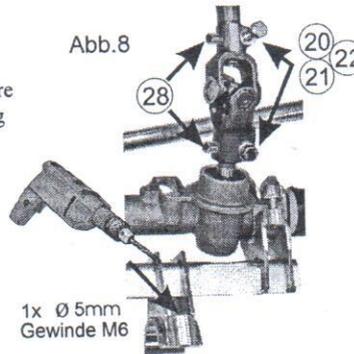
- Move the steering wheel to centre position and fix the steering column adapter (23) to the steering column using a spot weld (Abb.7.1)



- Remove steering column incl. steering column adapter and weld the adapter to the steering column through the 4 holes (Abb.7.2)
- Clean welds and treat with rust protection paint. Remount the steering column and screw the steering column adapter to the cardan joint (19)

- Remove the standard tie rod ends (wheel side) from the original tie rods and screw together with the new tie rods.

- Turn the steering wheel several times from left to right to ensure that there is no contact between the floor assembly and steering parts. Realign the steering if necessary.
- Tighten the screws (20) M8x35 on the universal joint, then slide on washers M8 (21) and tighten nuts M8 (22) with 35 Nm.
- Drill through the bore of the holder into the axle beam, using a 5mm drill bit (Abb.8) and cut a thread in both parts with an M6 tap.  
Insert grub screw M6x20 (10) into the thread and lock with M6 (11) nut.
- Screw tie rods (wheel side) to steering knuckles.



- Tighten all screws to the appropriate tightening torque:

hexagon socket screw M8 (12.9) 40Nm	hexagon socket screw M8 (10.9) 35Nm
nut M6 (12Nm)	screw M8 (10.9) 35Nm
screw M10 (8.8) 50 Nm	screw M10 (10.9) 70 Nm
nut M14x1,5 40 Nm	screw M8 (12.9) 40Nm
nut M8 (10) 35Nm	

- Mount tank:

Vehicles built up to 07/65:

depending on the tank installed, it may be necessary to raise the tank by 12 mm to ensure the required clearance between the tank and cardan joint (kit 7686013).

To do this, clean the tank support surface and stick the sealing tape (29) in this area.

Insert the 4 spacers (30) in the area of the mounting threads of the tank.

Install the tank and screw on with the original brackets and M8x35mm screws (20).

Vehicles built from 08/65:

Install petrol tank

- Carry out wheel alignment on the vehicle.

**Note for Beetle (year -67) and Karmann Ghia (year 61-67)**

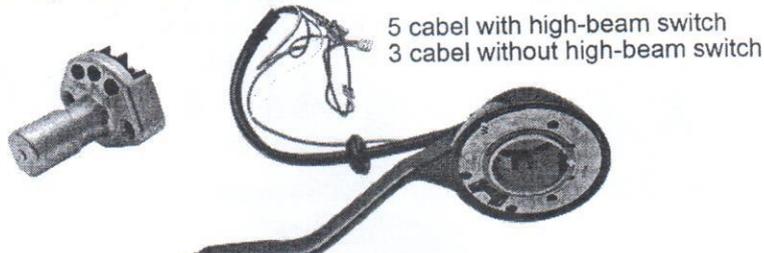
On these vehicles, the horn is controlled as follows as standard:

Earth cable (-) from the horn to the steering tube - steering wheel horn button - cable via the Hardy disc to the steering gear (as earth point).

Due to the conversion to rack and pinion steering, this circuit is no longer possible.

A new horn control is therefore required. For vehicles that have an indicator switch with 5 cables, the high beam switch function can be converted to a new foot switch for high beam and low beam.

The switch for high beam on the indicator switch can then be used as a horn contact.





## Conversion kit VW Käfer 1200/1300/1500 for Rack-and-Pinion Steering LHD

7686012KER (model years -07/65)  
7685012KER (model years 08/65-)



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Br/Ke 12.05.2025

### Contents (Abb.1)

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|---|---|
| <ul style="list-style-type: none"> <li>1 Steering gear (1) 76 85 012-1           <ul style="list-style-type: none"> <li>1 steering stop 15mm (installed)</li> </ul> </li> <li>1 Holder for steering gear (5) 76 85 012KER<br/>or (5) 76 86 012KER           <ul style="list-style-type: none"> <li>2 mounting clamp (2) 7685012-3</li> <li>4 hexagon socket screw M8x20mm 12.9 (3)</li> <li>4 corrugated washer 8mm (4)</li> <li>1 fixing screw M10x25mm 10.9 (6)</li> <li>1 corrugated washer 10mm (7)</li> <li>1 stop screw M8x30mm 8.8 (8)</li> <li>1 counter nut M8 (9)</li> <li>1 grub screw M6x20mm (10)</li> <li>1 nut M6 (11)</li> </ul> </li> <li>2 Track rod joint inner side (27) 7685012-2<br/>(left hand thread)           <ul style="list-style-type: none"> <li>1 track rod left 410mm (24) BZ85016-2</li> <li>1 track rod right 360mm (25) BZ85016-1</li> <li>2 counter nut M14x1,5 (26) (left hand thr.)</li> <li>2 clamp clip (28) with screws M8x35, washers and lock nuts</li> </ul> </li> <li>1 Track rod holder (12) 7685012-4           <ul style="list-style-type: none"> <li>2 hexag. socket screw M8x60mm 10.9 (13)</li> <li>2 lock nut M8 (15)</li> <li>4 washer 8mm (14)</li> <li>1 fixing screw M10x50mm 10.9 (16)</li> <li>2 washer 10mm (17)</li> <li>1 lock nut M10 (18)</li> </ul> </li> </ul> | <ul style="list-style-type: none"> <li>1 Cardan joint (19) with toothing 7685012-7           <ul style="list-style-type: none"> <li>2 fixing screw M8x35mm 10.9 (20)</li> <li>4 washer 8mm (21)</li> <li>2 lock nut M8 (22)</li> <li>1 adapter with toothing (23) for steering column 16,7mm*</li> </ul> </li> </ul> <p><u>Additional required up to model year 07/65:</u></p> <ul style="list-style-type: none"> <li>1 mounting kit for tank elevation 7686013KER           <ul style="list-style-type: none"> <li>4 spacer for tank 25x15x12mm (30)</li> <li>4 screw M8x35 8.8 (20)</li> <li>1 sealing tape 2,5m (29)</li> </ul> </li> </ul> <p><u>Optional order:</u></p> <ul style="list-style-type: none"> <li>2 tie rod ends (35) 7685012-9KER<br/>model year 68-, right hand thread<br/>(conical thread M12x1,5)</li> <li>2 tie rod ends (35) 7686012-9KER<br/>model year -68, right hand thread<br/>(conical thread M10x1,0)</li> <li>1 holding bracket (31) 7685013KER<br/>with 2 screws M10x50 10.9 (32)</li> </ul> <p>* for connection dimension 15,7mm<br/>please contact us!</p> |
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