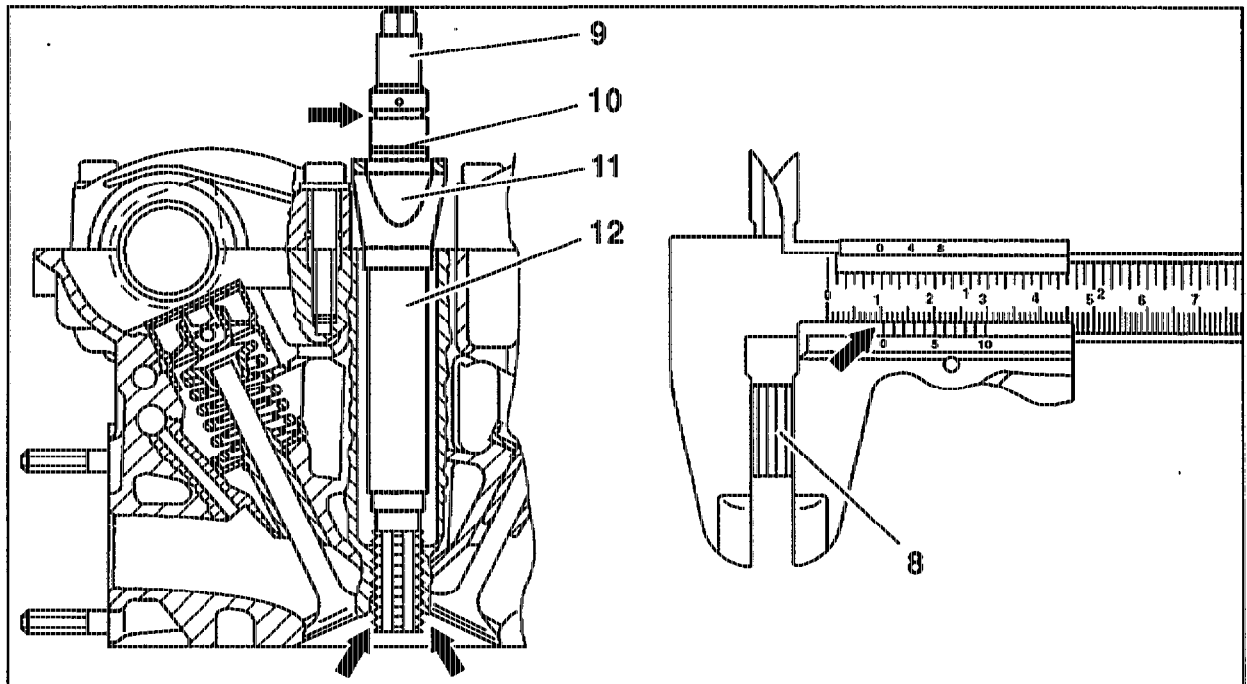


01-4070 Repairing spark plug threads

Preceding work:
Cylinder head cover removed (01-0500).

Operation no. of operation texts and work units or standard texts
and flat rates:



P01-5858-55

Piston of respective cylinder
Grooves (arrows) of combination thread tap (9)
of thread tapping unit
Stop ring (10)
Combination thread tap (9)
Combination thread tap (9)
Combination thread tap (9)

position to 20 – 30° BTDC.

pack with grease.

pull off, fit on.

screw into damaged thread.

guide with guide bush (11) pushed into spark
plug recess.

screw in sufficiently until guide tube (12)
touches and is resting against the groove
(arrow) on the guide bush (11).

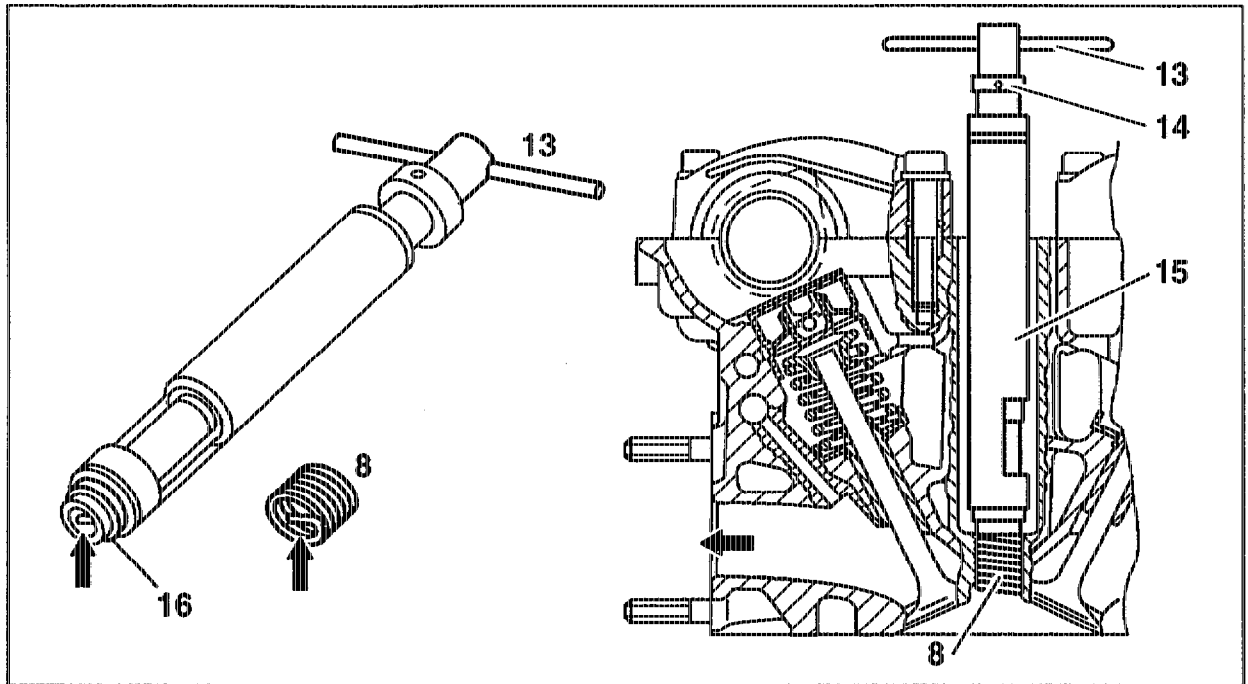


With the cylinder installed, unscrew combination
thread tap (9) after each 5 revolutions
approximately, clean grooves of swarf and
grease and re-pack with grease.

Length of HELI-COIL threaded insert (8)

check.

Use HELI-COIL insert (8) with 10.2 mm block length.

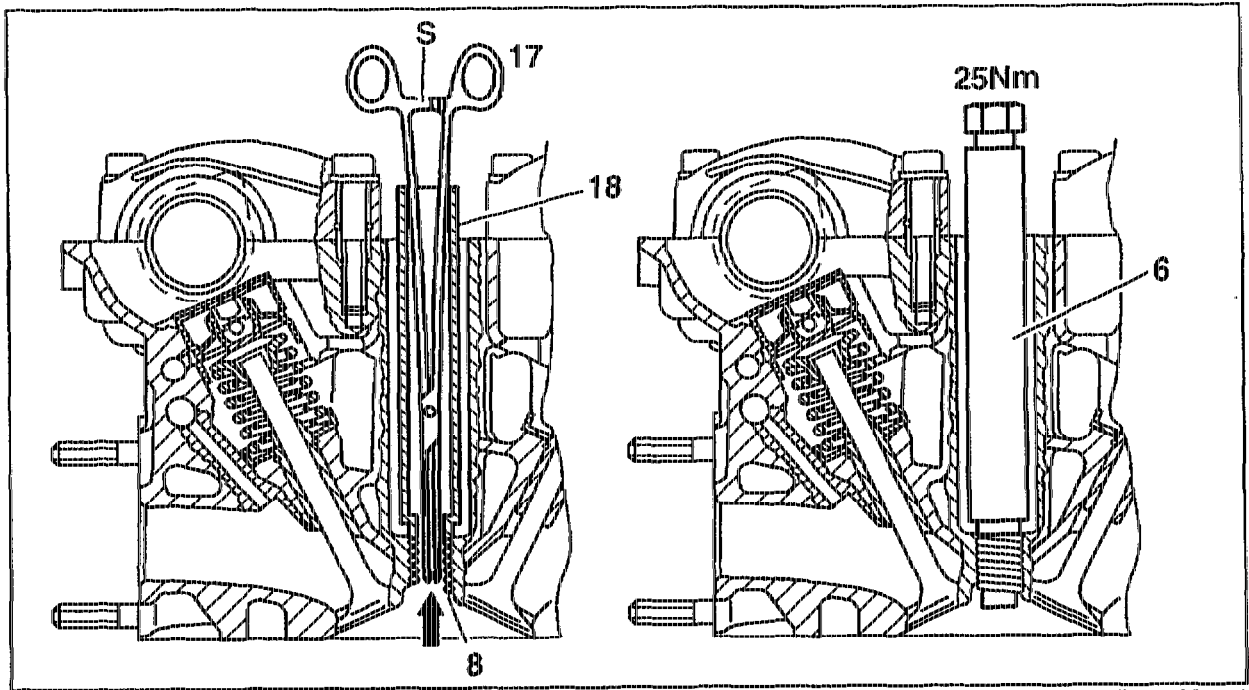


P01-5859-55

- | | |
|-------------------------------------|---|
| HELI-COIL threaded insert (8) | insert into fitting tools so that the stud (arrow) of the insert (8) is facing the pre-tensioning cartridge (16). |
| HELI-COIL insert | screw in flush (arrow) into pre-tensioning cartridge (16) using the spindle (13). |
| Fitting tool | fit onto tapped hole. |
| Jacket sleeve (15) | hold tight. |
| Screw-in spindle (13) | turn sufficiently until the stop ring (14) is resting against the jacket sleeve (15). |

Note

If jacket sleeve (15) jams tight when screwing in, turn back slightly.



P01-5860-55

- | | |
|----------------------------|--|
| Sleeve (18) | fit over driving stud (arrow). |
| Driving stud (arrow) | fix in place with pliers (17) (serrations (s)). |
| Sleeve (18) | turn to left as far a stop. |
| Pliers (17) | move up and down slightly, break off driving stud (arrow). |



If driving stud drops onto the piston crown, it must be removed with a magnet.

- | | |
|-----------------------------------|--|
| Degreased caulking tool (6) | screw in and tighten to 25 Nm. |
| Engine | crank with starter (01-0110) to remove any swarf which may have dropped onto the piston crown. |

Special tools

