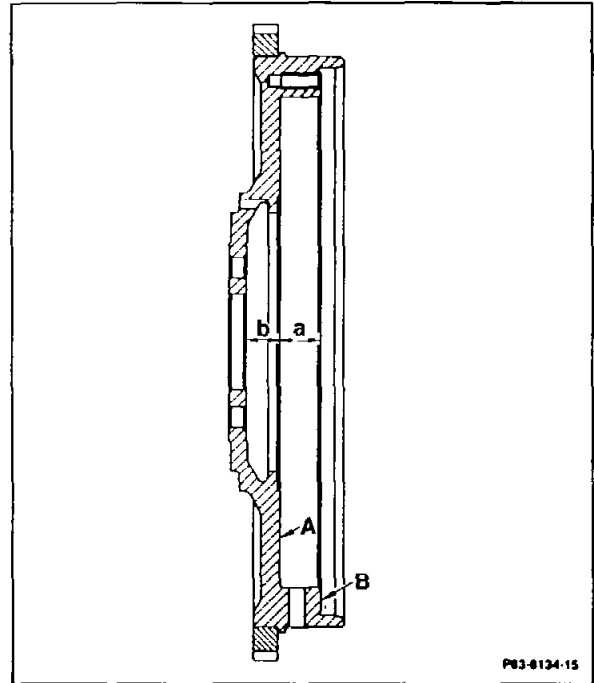
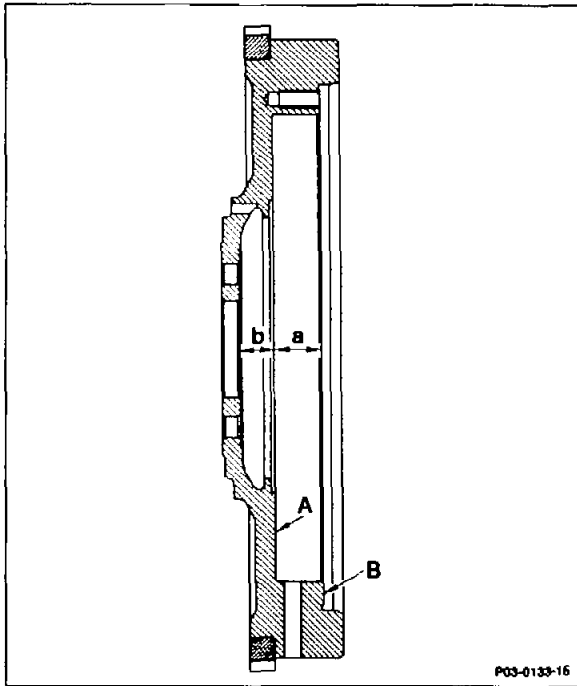


03-420 Refinishing flywheel

Preliminary jobs:
Flywheel and driven plate removed (03-410).

Operation No. of operation texts and operation values or
standard texts and flat rates 03-8022



Engines 601, 602

Engine 603 (except for 603.97)

Dimension (b)

measure, max. 17 mm, min. 15.6 mm.

If dimension (a) has become so great due to material removal that dimension (b) is less than 15.6 mm, renew flywheel.

Dimension (a)

measure, engines 601, 602: 22.5 mm, engine 603: 19.4 mm. Maximum material removal 1 mm, if material removal is greater than 1 mm, renew flywheel.



If the clutch surface (A) is refinished, the mounting surface (B) must be refinished by the same dimension so that distance (a) is maintained.

Flywheel refinish



The two-mass flywheel cannot be refinished.
Clamp flywheel in lathe so that permissible deviation from flat = 0.05 mm is not exceeded.

Data

Engine		601, 602	603
Distance a		22.5 ± 0.1	19.4 ± 0.1
Distance b	in new state	16.6 ± 0.4	
	for repair	up to 15.6 ± 0.4	
Permissible deviation from flat on clutch surface or clutch attachment surface		0.05 mm	

Note

Flywheels for manual transmissions with burned spots, scoring or cracks on the clutch surface should be refinished by precision turning.

If the scoremarks or cracks are greater than the maximum permissible material removal dimension, renew flywheel.

After machining the clutch surface should not have any porous spots or chatter marks.