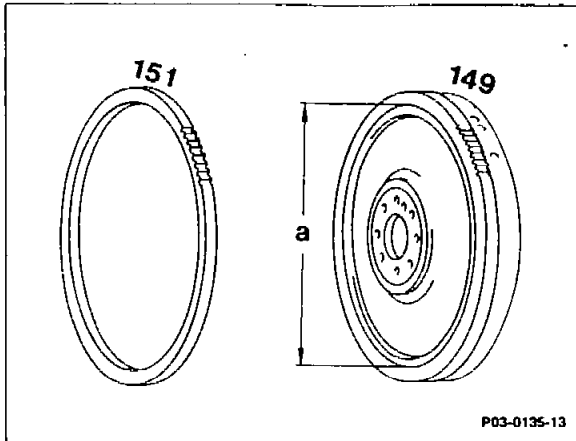


03-430 Replacing ring gear on flywheel

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

Operation No. of operation texts and operation values or
standard texts and flat rates 03-8312



Flywheel (149)	check, centering flange dia. (a) for ring gear 275.00 + 0.05 mm. Clean mounting surface for ring gear on flywheel before installing ring gear.
Ring gear (151)	drill hole into old ring gear and break up with a chisel or heat quickly and then remove immediately. Heat new ring gear and install on flywheel. Temperature for shrink fit 220 °C. Lateral runout on ring gear max. 0.4 mm.

Commercially available tools and testers

Designation	e. g. make	Order no.
Temperature measuring chalk Color No. 2815/220 (white) thermochrome	AW Faber-Castell, 90547 Stein bei Nürnberg	



The ring gear is hardened. For this reason do not exceed 220 °C at any point while heating with hot plate or heating furnace.

Use temperature measuring chalk in accordance with directions.

Use open flame only in exceptional cases. Apply flame to inside of ring gear only.

After replacing ring gear, it is not necessary to balance the flywheel.