



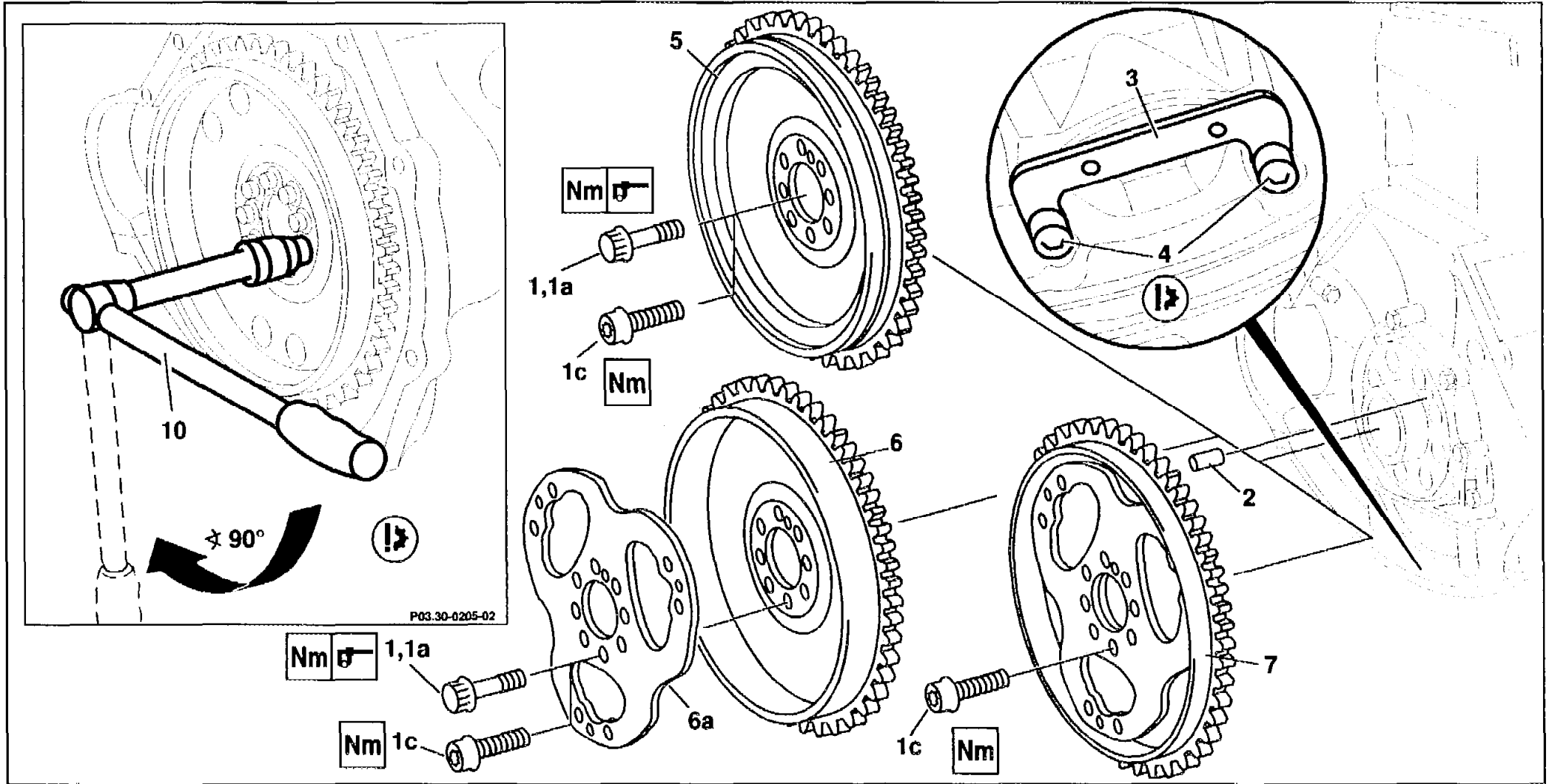
P5

AR03.30-P-8001HA

Removing and installing flywheel/driven plate

10.2.94









ENGINE 602.982 /983, 604, 605, 606 /









Modification notes

1.3.94	Technical modification: Stretch shank bolt replaced by straight stretch shank bolt.	Operation 4	AR03.30-8001HA
1.5.95	Bolt for driven plate, flywheel, sheet metal two-mass flywheel standardised	Operation 4	AR03.30-8001HA

 	Removal, installation		
1.1	Remove manual transmission		AR26.10-P-0020A
1.2	Remove automatic transmission	Models 202, 210, 140	AR27.10-P-0500A
		Model 461	AR27.10-P-0500G
		Model 463	AR27.10-P-0500BD
2.1	Remove clutch	Manual transmission	AR25.10-P-0050A
3	Install blocking plate (3, 4) for crankshaft/ring gear	 Use M6×90 bolts otherwise the threads in the rear end cover will be damaged.	AR03.30-P-5000HA H5
4	Unscrew bolts (1, 1a, 1c)	  Stretch bolts (1)  Straight stretch shank bolts (1a)  Torx bolts (1c)  Replace torx bolts and straight stretch shank bolts, see technical modifications ↓	000 589 01 10 00 BA03.30-P-1004-01A BA03.30-P-1005-01A BA03.30-P-1005-01A



 BT  BT	<p>Bolt for two-mass flywheel modified</p> <p>Bolt for driven plate, flywheel, sheet metal two-mass flywheel standardized</p>	<p>Engine 605, 606</p> <p>Engine 602.982/983, 604, 605, 606</p> <p>i Installation: If no torquing angle wrench is available, the bolts can be tightened further in a single step by the specified angle using a socket wrench and tommy bar (10).  Do not use a flexi-rod torquing wrench for tightening according to tightening angles in order to rule out any angle errors.</p>	<p>BT03.30-P-0001-01A C18</p> <p>BT03.30-P-0002-01A D18</p>
5.1	Check bolts (stretch shank bolts) (1) for flywheel/driven plate		AR03.30-P-8001-01HA M16
			BE03.30-P-1001-01A
6	Take off flywheel (5), two-mass flywheel or flywheel (6) with driven plate (6a) or starter ring gear (7)	<p>Straight pin (2) centers flywheel and driven plate.</p> <p>i Flywheels do not need to be balanced and must not be interchanged.</p> <p>i Arrangement of flywheel, two-mass flywheel, driven plate</p>	GF03.30-P-8001-01A F18
7	Install in the reverse order		



Flywheel, driven plate

Number	Designation	Engine 605, 606 with automatic transmission up to 4/95	Engine 605, 606 with manual transmission (TMF) up to 4/95	
BE03.30-P-1001-01A	Flywheel or driven plate Thread \varnothing (D)	M 10×1	10×1	
	bolts (1st version)	Stretch shank \varnothing (d) when new mm	8.5–0.2	
		min mm	8.0	
	Length of shank (L)	when new mm	22.0 ± 0.2	57.0 ± 0.2
		max. mm	22.5	–
fig. see		AR03.30-P-8001-01HA	AR03.30-P-8001-01HA	

Flywheel, driven plate

Number	Designation	Engine 604 up to 10/95	Engine 111 with two-mass flywheel	
BE03.30-P-1001-01A	Flywheel or driven plate Thread \varnothing (D)	M 10×1	10×1	
	bolts (1st version)	Stretch shank \varnothing (d) when new mm	8.5–0.2	
		min mm	8.0	
	Length of shank (L)	when new mm	22.0 ± 0.2	57.0 ± 0.2
		max. mm	22.5	–
fig. see		AR03.30-P-8001-01HA	AR03.30-P-8001-01HA	

Flywheel, driven plate

Number	Designation	Engine 111 with flywheel or driven plate	Engine 111 with sheet metal two-mass flywheel			
BE03.30-P-1001-01A	Flywheel or driven plate bolts (1st version)	Thread \varnothing (D)	M 10×1	10×1		
		Stretch shank \varnothing (d)	when new	mm	8.5–0.2	8.5–0.2
			min	mm	8.0	8.0
		Length of shank (L)	when new	mm	22.0±0.2	22.0±0.2
			max.	mm	22.5	22.5
fig. see		AR03.30-P-8001-01HA	AR03.30-P-8001-01HA			

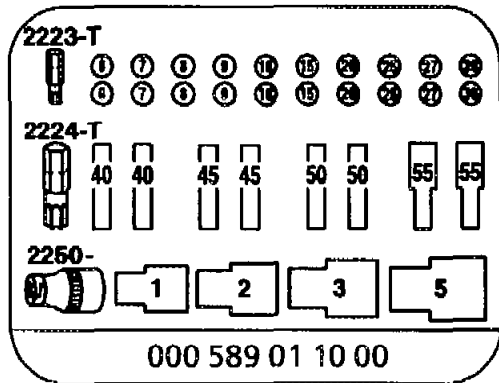
Nm Flywheel, driven plate, vibration damper, starter ring gear

Number	Designation	Engine 601, 602, 603 with / without automatic transmission	Engine 604 with / without automatic transmission	Engine 605, 606 with manual transmission (TMF)		
BA03.30-P-1004-01A	Stretch shank bolt for flywheel to crankshaft	1st stage	Nm	35	35	40
		2nd stage	\sphericalangle °	90	90	90
BA03.30-P-1005-01A	Straight stretch shank bolt for flywheel or two-mass flywheel to crankshaft	1st stage	Nm	45	45	45
		2nd stage	\sphericalangle °	90	90	90



Nm Flywheel, driven plate, vibration damper, starter ring gear

Number	Designation	Engine 605, 606 with automatic transmission		
BA03.30-P-1004-01A	Stretch shank bolt for flywheel to crankshaft	1st stage	Nm	35
		2nd stage	∠ °	90
BA03.30-P-1005-01A	Straight stretch shank bolt for flywheel or two-mass flywheel to crankshaft	1st stage	Nm	45
		2nd stage	∠ °	90



Torx bit set