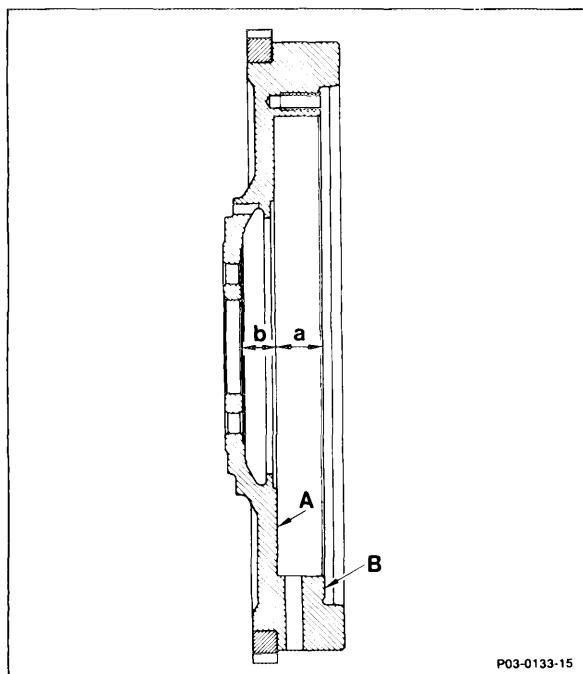


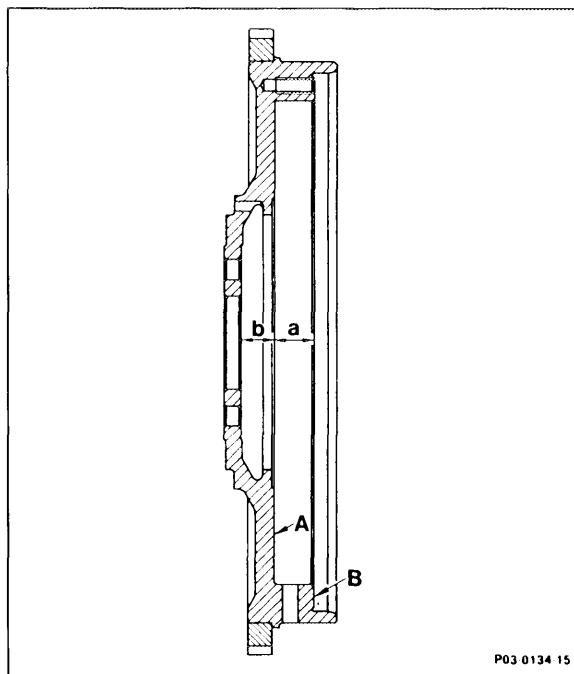
03-420 Refinishing flywheel

Preliminary jobs:

Flywheel and driven plate removed (03-410).



Engine 602



Engine 603 (except for 603.97)

Dimension (b)

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

If material removal causes dimension (a) to exceed max. causing dimension (b) to be less than 15.6 mm, replace flywheel.

Dimension (a)

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

Caution!

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

Flywheel refinish

Caution!

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	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, replace flywheel.

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