

K6

AR03.30-P-8312A

Replacing ring gear of flywheel

10.2.94

ENGINE 602.982 /983, 604, 605, 606

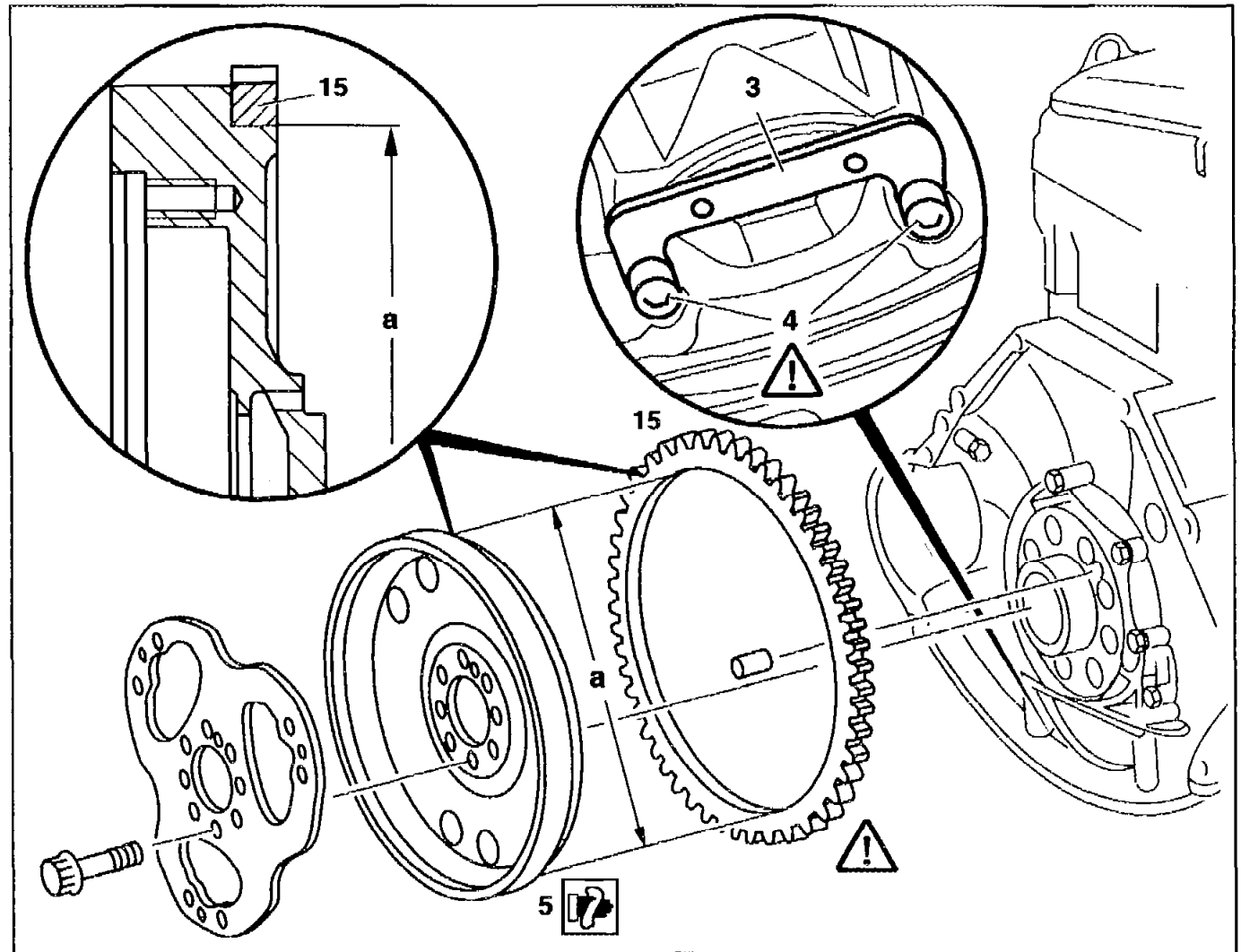


Fig item, etc.	Work instructions		
3, 4	Install blocking plate for crankshaft/ring gear	ⓘ Use M6 × 90 bolts otherwise the threads in the rear end cover will be damaged.	AR03.30-P-5000HA H5
5	Remove flywheel, two-mass flywheel or driven plate		AR03.30-P-8001HA P5
15	Ring gear	<p>Drill open ring gear and snap with a chisel or heat rapidly and remove immediately.</p> <p>Check diameter of centering collar (a) for the ring gear.</p> <p> ⓘ Installation: Clean contact face of the ring gear at the flywheel before fitting on. Heat ring gear with a heating plate or heating oven to about 220 °C and fit onto the flywheel.</p> <p> ⓘ The ring gear is hardened. Do not exceed a temperature of about 220 °C when heating. Use temperature measuring chalk!</p> <p>Heat the ring gear with a torch only in exceptional cases. Heat only the inside of the ring gear</p>	<p>BE03.30-P-1002-04A</p> <p>WH58.30-Z-1001-08A</p>



		After replacing the ring gear, the flywheel need not be re-balanced.	
	Checking		
	After fitting on the ring gear, check the radial runout at the ring gear		BE03.30-P-1001-04A

Ring gear

Number	Designation	Engine
		602.982/983, 604, 605, 606
BE03.30-P-1001-04A	Permissible radial runout of ring gear	mm 0.4
BE03.30-P-1002-04A	Diameter of centering collar for ring gear	mm 275.00 ± 0,05

Commercially available tool

Number	Designation	Make (e.g.)	Order number
WH58.30-Z-1001-08A	Temperature measuring chalk	AW Faber-Castell, D-90547 Stein bei Nürnberg	2815/220 (weiss) Thermochrom