

## R. Removal and Installation of Front Grease Seal for Crankshaft with Engine installed in Vehicle

### Removal:

1. Remove the radiator (see Job No. 50 — 1).
2. Remove the counterweight (see Job No. 01 — 4, Section N).
3. Pry out the sealing ring with a suitable tool. Care must be taken to ensure that when doing this the guide, the bore and the oil thrower ring are not damaged.

### Installation:

4. When installing the new grease seal, smear it with sealing compound at its circum-

ference, fill the space between the two sealing lips with high-viscosity grease and press in the sealing ring with a suitable insertion sleeve with pressure block (see Fig. 01—4/48).

The shoulder half of the grease seal must rest firmly against the face of the crankcase.

5. Install the counterweight (see Job No. 01—4, Section N).
6. Install the radiator (see Job No. 50 — 1).

## S. Removal and Installation of Flywheel

Repair procedure (see Job No. 03 — 5, Sections E to H).

### Removal:

**Note:** This operation is performed either with engine removed altogether or, if the engine is in the vehicle, with clutch and transmission removed.

1. After removing the fixing screws, the flywheel is taken off the crankshaft.
2. Check the annular grooved bearing assembly on crankshaft. If on examination the annular grooved bearing assembly is found to be defective, the bearing cover and the bearing itself should be pulled off with Puller 136 589 07 33 (Fig. 01—4/52).

### Installation:

3. When installing the new annular groove bearing, do not omit the spacer sleeve between the crankshaft and the annular grooved bearing!
4. Screw the flywheel onto the crankshaft. The flywheel is fixed in position on the crankshaft by means of a dowel pin.

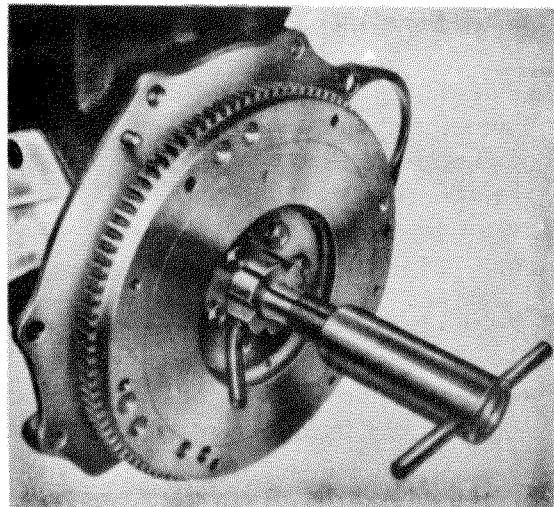


Fig. 01—4/52

The above picture shows the removal of the annular grooved bearing assembly on engine Model 220

Tighten the flywheel fixing screws (stretch screws) to a tightening torque of 4.4—5 mkg.

**Note:** If a new flywheel is installed, it must be balanced beforehand (see Job No. 03—5, Section H).