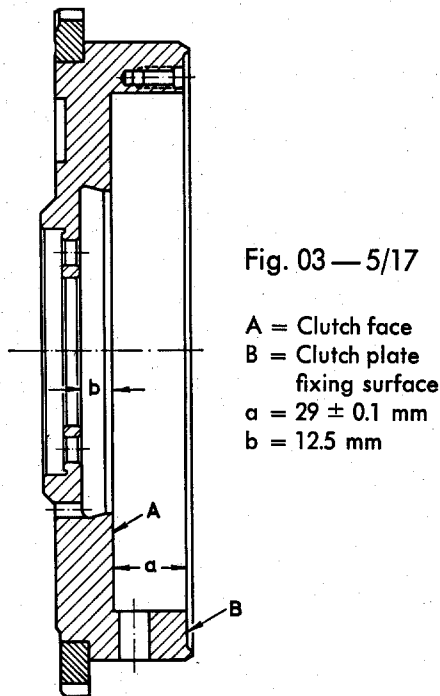


E. Replacement of Starter Ring Gear

1. Heat the old starter ring gear and pull it off immediately.
2. Heat the new gear to 200°C so that a light yellow sheen appears on it and then press

it quickly onto the flywheel, with the bevelled side, seen from the direction of travel, pointing forward (see Fig. 03—5/17). The lateral deflection of the shrunk-on ring gear must not be more than 0.4 mm.

F. Grinding Clutch Face of Flywheel



This job must always be done if there are scorings or burnt patches on the clutch face of the flywheel. The clutch face must then be surface-ground or precision-turned on a suitable machine.

The clutch face A may be machined off until the dimension $b = 11.5 \text{ mm}$ is reached. When the clutch face is new the dimension is $b = 12.2 \text{ mm}$. The dimension must not be reduced below $b = 11.5 \text{ mm}$ (Fig. 03—5/17).

The surface B must in any case be re-machined or turned so that the distance $a = 29 \text{ mm} \pm 0.1$ is maintained in all cases.

When machining the clutch face, care must be taken to ensure that the surfaces A and B are exactly parallel to each other and also to the flywheel flange fixing surface. The permissible deviation from parallel is 0.05 mm at a diameter of 230 mm.