

03-4200 Machining flywheel (except two-mass flywheel)

Preceding work:
Flywheel removed (03-4100).

Operation no. of operation texts and work units or standard texts
and flat rates
03-8022

| | | | |
|---|-------------------|------------|------------|
| Engine | | 103.98 | 103.94 |
| Distance a | | 25.4 + 0.2 | 19.4 ± 0.1 |
| Distance b | when new | 15.2 ± 0.4 | 16.6 ± 0.4 |
| | for repairs up to | 14.2 ± 0.4 | 15.6 ± 0.4 |
| Permissible variation in concentricity of clutch face or clutch flange face | | 0.05 | 0.05 |

Flywheels for manual transmission which have scorch points, scoring or cracking in the clutch face should be machined by precision-turning.

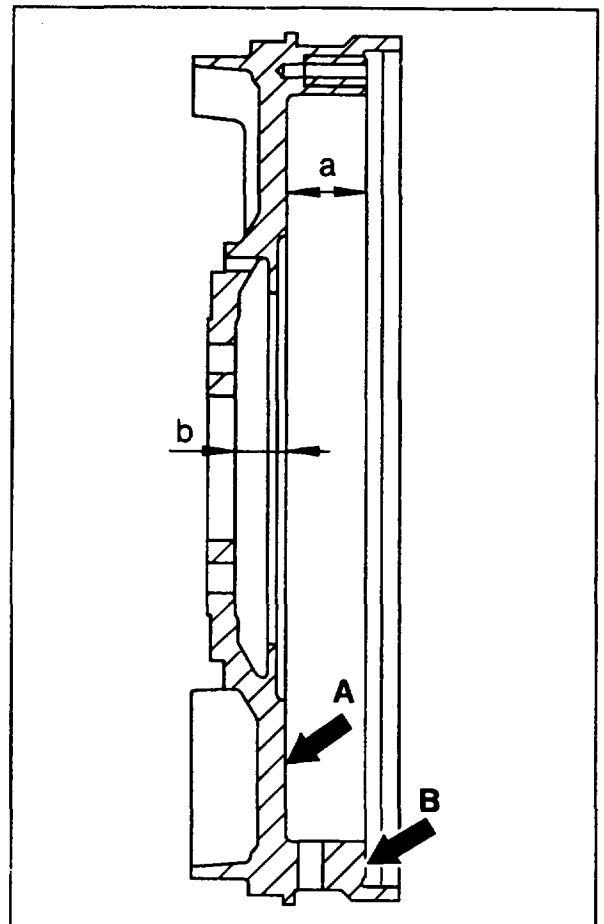
If the grooves or cracks are deeper than the maximum permissible stock removal, the flywheel must be renewed.

If the clutch face "A" is machined, the mounting face "B" must also be machined by the same amount in order to maintain the distance "a".

Size "b" must be maintained as a minimum size when performing repairs.

The flywheel must be properly clamped for machining to ensure that the permissible variation in concentricity of 0.05 mm is not exceeded.

Following machining, the clutch face must not have any shrinkholes or chatter marks.



P03-5356-17

