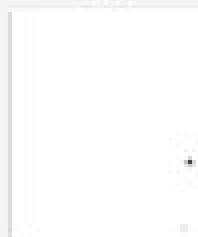


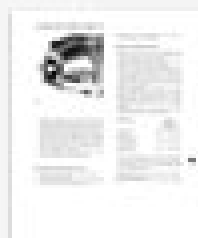
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SECTION P

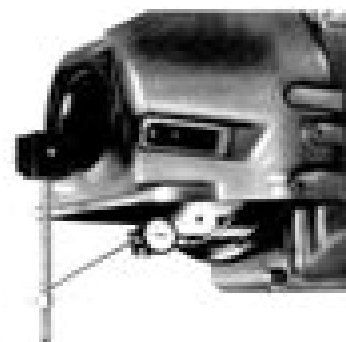
Flywheel and Flywheel Housing

To Remove the Flywheel

1. Remove the gearbox, clutch assembly and any linkage as detailed in the service literature specific to the particular engine or application.
2. Remove the locking tabs from the flywheel securing retainer.
3. Remove the securing retainer and carefully re-move the flywheel from the crankshaft flange.

To Remove the Flywheel Ring Gear

1. The flywheel ring gear is a shaft fit so the flywheel is removed by pulling out by carefully not key through the gear and instead pulling it from the flywheel. An alternative method is to apply flywheel heat to the ring gear to expand it sufficiently to enable it to be forced away from the flywheel.
2. The locking tabs of the flywheel should be thoroughly cleaned to ensure a positive location when the new ring gear is fitted.
3. Clean the heat the new ring gear to a tolerance level not exceeding 0.0175 (0.0007).
4. Fit the ring gear into the flywheel with the heat on the teeth facing upwards, i.e., facing away from the engine when the flywheel is fitted. Remove the gear quickly as the tolerance mechanism it is fitted to around it is being lost, then allow to cool.



P1

5. Set up a dial test indicator (model) gauge with the base removed against the rear face of the flywheel housing and the gauge stem at right angles to the periphery of the flywheel. Turn the crankshaft and check the run out, the flywheel should run flat within 0.015 in (0.38 mm) total indicator reading.

To Refit the Flywheel

It is most essential to ensure that the crankshaft flange face and periphery are perfectly clean and free from burrs, similarly the mating face of the flywheel must be free of anything as the flywheel is positioned. Failure to ensure this may make it impossible to fit the flywheel correctly within the various timing points specified. It will be noted that there is a wide compressed hole in the crankshaft flange which will be at 6.000, when Box 1 and 4 pistons are at T.D.C.

The flywheel can only be fitted in this position due to the integral timing of the reference points.

1. It is advisable to remove a shaft stud into the crankshaft flange just tight, so that when the flywheel is placed on this stud can take the weight of the flywheel whilst the securing retainer are fitted. This stud can then be removed and replaced by the 10th retainer.
2. Engage the securing retainer to the flange given on Page 8.2 but do not lock with the tab washers at this stage.



P2

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