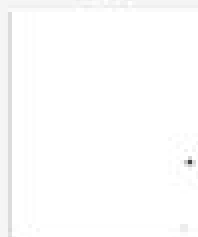


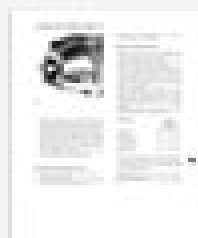
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SECTION P

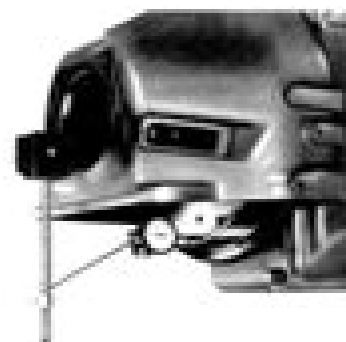
Flywheel and Flywheel Housing

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 pinion fit on the flywheel. Its removal is carried out by carefully cut-ting through the gear and then pulling it from the flywheel. An alternative method is to apply heat-treat tape 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 face of the new ring gear to a tolerance face not exceeding 0.0175 (0.0007).
4. Fit the ring gear onto the flywheel with the lead on the teeth facing outwards, i.e., facing away from the engine when the flywheel is fitted. Press the gear gently on the bearing. Subsequently it is found to around 2 is being felt, then allow to heat.



P1

1. Set up a dial test indicator (model) gauge with the base removed against the rear face of the flywheel housing and the gauge adjust 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 accurately 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 gear as Page 8.2 but do not lock with the bolt washers at this stage.



P2

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Mark Steyvers



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