

Repairing of Guide Sprocket, OM 621

1. Check pivot pin and bore in guide sprocket for wear. Measures and tolerances (see Job No. 05-0, page 05-0/4).
2. If worn, press out bushing of guide sprocket and press in a new bushing with pre-turned bore.
3. Before pressing in the bushing of the guide sprocket, fix the sprocket in the bore and slightly machine the circumference of the sprocket (vertical out-of-true 0.02 mm). After machining the sprockets, press in the new bushing, fixing the guide at the sprocket circumference and finish the bore of the bushing (16.018–16.000 mm).

Lateral out-of-true of the sprocket when supported in the bore
max. 0.02 mm

Vertical out-of-true, measured at the circumference
max. 0.02 mm

4. If the pivot pin is worn, replace it.