

Color Code for Associated Piston Pins and Pistons

Pistons pins, connecting rods and pistons	Color code	Piston pin O.D.	Bore of piston pin bushing	Running	Bore in piston	
					Nüral	Mahle
180 a, 180 b, 190, 190 b, 190 SL	black	$\frac{24.997}{24.994}$	$\frac{25.007}{25.010}$	0.010–0.016	$\frac{24.994}{24.997}$	$\frac{24.994}{24.997}$
	white	$\frac{25.000}{24.097}$	$\frac{25.010}{25.013}$		$\frac{24.997}{25.000}$	$\frac{24.997}{25.000}$
180 c, 190 SL ¹⁾	black	$\frac{25.997}{25.994}$	$\frac{26.012}{26.015}$	0.015–0.021	—	$\frac{25.994}{25.997}$
	white	$\frac{26.000}{25.997}$	$\frac{26.015}{26.018}$		—	$\frac{25.997}{26.000}$
220 a, 219, 220 S	black	$\frac{21.997}{21.994}$	$\frac{22.007}{22.010}$	0.010–0.016	$\frac{21.994}{21.997}$	$\frac{21.992}{21.995}$
	white	$\frac{22.000}{21.997}$	$\frac{22.010}{22.013}$		$\frac{21.997}{22.000}$	$\frac{21.995}{21.998}$
220 SE	black	$\frac{23.997}{23.994}$	$\frac{24.007}{24.010}$	0.010–0.016	—	$\frac{23.992}{23.995}$
	white	$\frac{24.000}{23.997}$	$\frac{24.010}{24.013}$		—	$\frac{23.995}{23.998}$

¹⁾ 190 SL as from engine design 121.928.

E. Replacement of Starter Rim Gear

For models 180 a, 180 b, 180 c, 190 SL, 220 a, 219, 220 S and 220 SE with standard clutch and for models 219, 220 S and 220 SE with hydraulic-automatic clutch procedure is the same as for model 190. However, the flywheel for models 219, 220 S and 220 SE with hydraulic-automatic clutch is designed as a disk (Fig. 03–5/5). On this flywheel the ring gear is mounted to project uniformly on both sides. Then, the runout of clamping face B should be checked over a diameter of 200 mm. It should not exceed 0.05 mm.

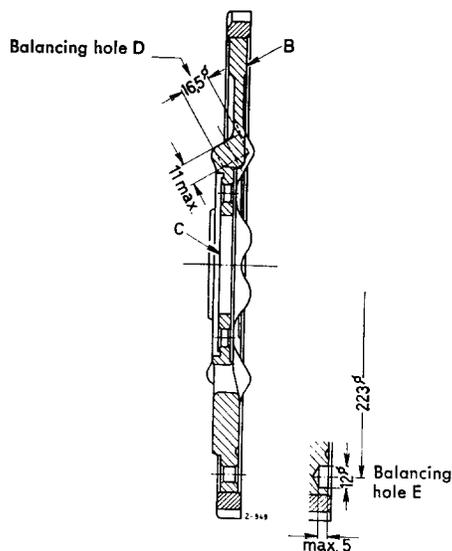


Fig. 03–5/5

Flywheel for hydraulic-automatic clutch

B = Clamping face for hydraulic-automatic clutch
C = Clamping face for crankshaft

Following attachment of a new ring gear on models 220 a, 219, and 220 S having a flywheel acc. to Fig. 03–5/7 the ring gear requires six thread holes for attachment of the clutch. First drill six holes of 6.7 mm dia. accurately centered with holes in flywheel, then chamfer and cut 8 mm threads (M 8).