

## H. Static Balancing of New Flywheel

For Models 180 a, 180 b, 190 SL, 220 a, 219, 220 S and 220 SE the static balancing procedure for the flywheels is the same as for Model 190.

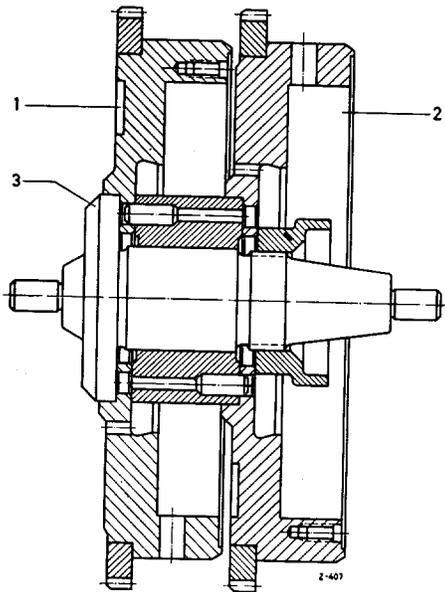


Fig. 03-5/11

- 1 Old flywheel
- 2 New flywheel
- 3 Arbor Fixture 180 589 00 27

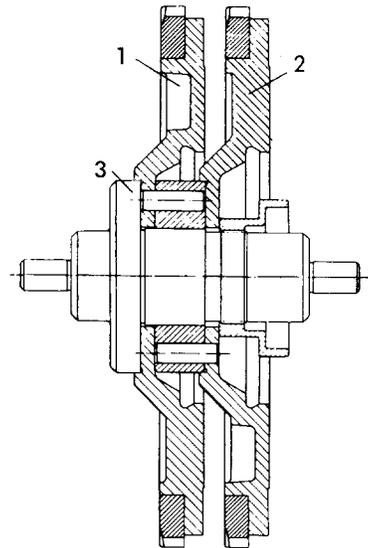


Fig. 03-5/12

- 1 Old flywheel
- 2 New flywheel
- 3 Arbor Fixture 187 589 02 27

Use Arbor Fixture 180 589 00 27 (Fig. 03-5/11) for the static balancing of flywheels in Models 180 a, 180 b, 190 SL as well as Models 219, 220 S 2<sup>nd</sup> version and 220 SE; for the flywheels of Model 220 a as well as Models 219, 220 S 1<sup>st</sup> version and 219 and 220 S with hydraulic automatic clutch use Arbor Fixture 187 589 02 27 (Fig. 03-5/12).

The 2<sup>nd</sup> version flywheel can be installed subsequently on Model 220 a as well as on Models 219 and 220 S with the 1<sup>st</sup> version flywheel, if the clutch is replaced (without drive plate). However, the 2<sup>nd</sup> version flywheel must be statically balanced with the 1<sup>st</sup> version flywheel which has been removed.

The early engines of Model 190 SL have a flywheel with a recess of 75 mm diameter and a bolt hole circle of 56 mm diameter. Because of its smaller recess and bolt hole circle, this flywheel cannot be replaced by a 2<sup>nd</sup> or 3<sup>rd</sup> version flywheel when repairs are carried out; it can only be replaced by another 1<sup>st</sup> version flywheel. Make a suitable arbor fixture for balancing the new flywheel.

**Note:** For Model 190 SL only crankshafts with a recess of 98 mm diameter and a bolt hole circle of 78 mm diameter, together with a counterweight and a 3<sup>rd</sup> version flywheel are supplied as replacement parts.