

Replacement of Flywheel Ring Gear

Types 220 and 220a

Procedure:

1. Before pulling the old ring gear, warm it shortly and remove.
2. Heat the new ring to 200° C (390° F) until it is lightly straw yellow, and press quickly on flywheel. The lateral out of true of the mounted ring gear should not be more than 0.4 mm (0.016").
3. After the ring gear has been fitted, drill and tap the holes for the clutch fastening screws.

First drill the holes **strictly concentric** to the bores in the flywheel with a twist drill of 6.7 mm (0.264"), then spot face them and provide with thread M 10 (see Fig. M 14/00).