

## Replacement of Pilot Pins for Front Counterweight on Crankshaft

Types 220 and 220a

If the pilot pins for front counterweight on crankshaft develop looseness, install new pins having a larger diameter.

When a counterweight has to be exchanged, rebalance **the new counterweight together with crankshaft and flywheel** (see Operation No. M 16).

### Procedure:

**Note:** Of the two counterweights shown in Fig. M 17/00, the left one is for Type 220, whereas the right one is for Type 220a.

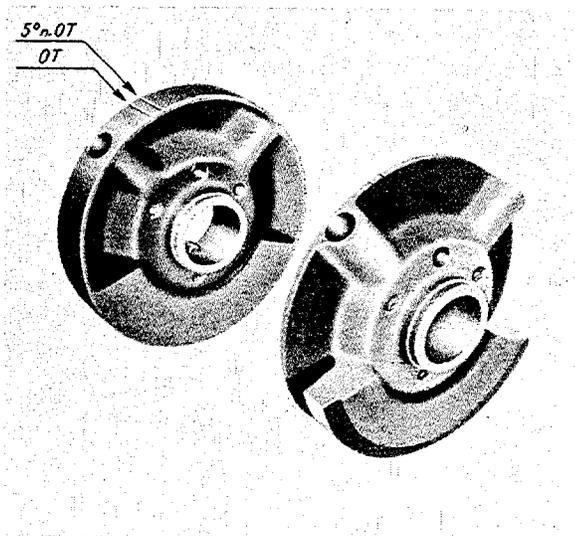


Fig. M 17/00

5° = 6.45 mm (0.245")

1° = 1.3 mm (0.051")

1. Loosen collar screw and pull off counterweight. Remove the two pilot pins.
2. Push counterweight in correct position on crankshaft, bore and scrape both bores 10 mm (0.39") dia.  $\times$  9 (9.930 to 9.966 mm = 0.39094 to 0.39236" dia.) see Fig. M 17/2.

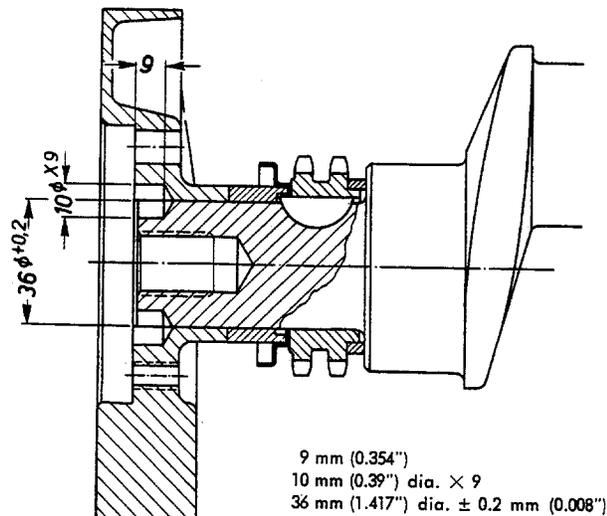


Fig. M 17/2

3. Drive in new pilot pins 10 h 8  $\times$  8 DIN 7 (9.978 to 10.000 mm = 0.39283 to 0.39370" dia.).

**Note:** First bore one hole and drive in the pilot pin, then bore the other hole and provide with a pin.