

03–327 Replacing rear crankshaft radial oil seal

Tightening torques		Nm
Necked down screw for camshaft gear		80
Connecting rod nuts	initial torque	40–50
	angle of rotation torque	90–100°
Necked down screws for flywheel or driven plate	initial torque	30–40
	angle of rotation torque	90–100°
Crankshaft bearing bolts		80

Self-made tool

Gage	see fig., point 4
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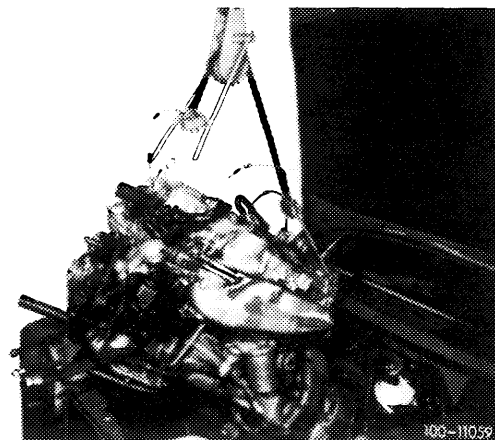
Note

When repairing engines 110, use radial sealing ring 000 997 90 41 (yellow-brown) and cut off with 0.5 mm projection.

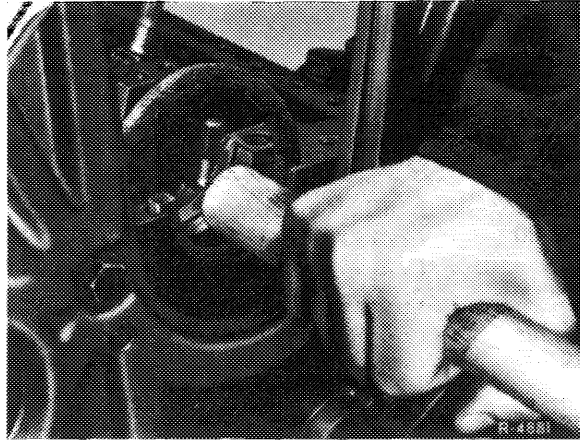
Exception: On engines which are provided with a new or a newly machined (refinished) crankshaft and new crankshaft bearings during repairs, install radial sealing ring 000 997 69 41 (graphite-grey) and cut off with 1 mm projection.

Replacing

- 1 Remove engine (01–030).
- 2 Remove crankshaft.



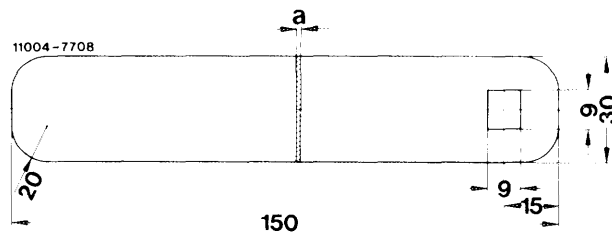
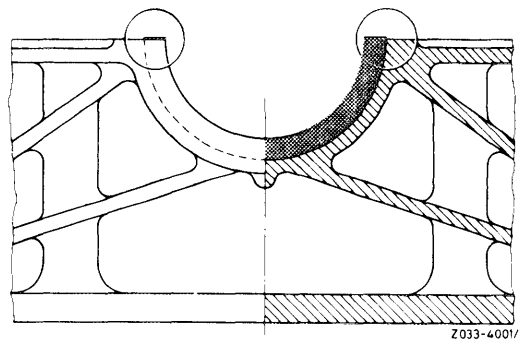
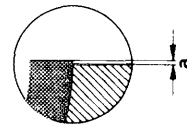
3 Place radial oil seal in crankcase and oil pan, and rub in with an oiled hammer handle.



4 To provide an overlap, cut off radial oil seal in crankcase and oil pan about 0.5 mm or 1.0 mm above mating surface.

Note: For cutting off, a self-made gauge according to drawing can be used.

Radial sealing ring, part no.	Dimension a (mm)
000 997 69 41 (graphite-grey)	1.0
000 997 90 41 (yellow-brown)	0.5



5 Coat radial oil seal with oil before installation of crankshaft.

6 Install crankshaft.

7 Install oil pan, turn crankshaft and check for easy movement.