03–430 Renewing ring gear of flywheel

Data

Lateral runout of ring gear	max. 0.4
Centering flange dia. for ring gear	268.31–268.39
Shrinking-on temperature	220° C
Annealing color	yellow

Conventional accessories

Temperature measuring chalk	e.g. made by AW Faber-Castell D--8504 Stein bei Nürnberg color no. 2815/220 (white) thermochrome

Note

The ring gear is hardened. To prevent impairing hardness, do not exceed temperature beyond 220° C at any point of ring gear. This can be done reliably only by means of a hot plate or a heating furnace. Use an open flame only as an exception. Flame should touch inside of ring gear only.

No balancing of flywheel is required following renewal of ring gear.

Renewal

1 Drill into old ring gear and break apart with a chisel or heat quickly and then remove immediately.

2 Clean contact surface of ring gear on flywheel.

3 Heat new ring gear on a hot plate or in a heating furnace uniformly. Use temperature measuring chalk according to pertinent instructions.

4 Fit heated ring gear immediately on flywheel.

Attention!
Tooth chamfer (arrow) should face starting motor.

As a spare part, ring gears are available with chamfered teeth only. Install these ring gears also on vehicles with manual transmission in place of ring gears without chamfer.