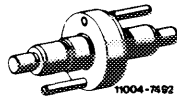


**Special tool**

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Mounting drift for balance plate



617 589 02 63 00

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**Commercially available tool**

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Roller type EO

e.g. Trebel, 4030 Ratingen

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**Note**

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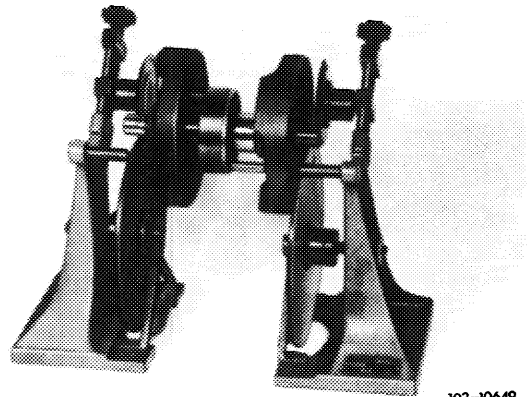
The balance of old balance plates must be transferred to new ones.

A fractured balance plate must be cemented, if possible, together with all parts and balanced statically with the new one.

**Static balancing**

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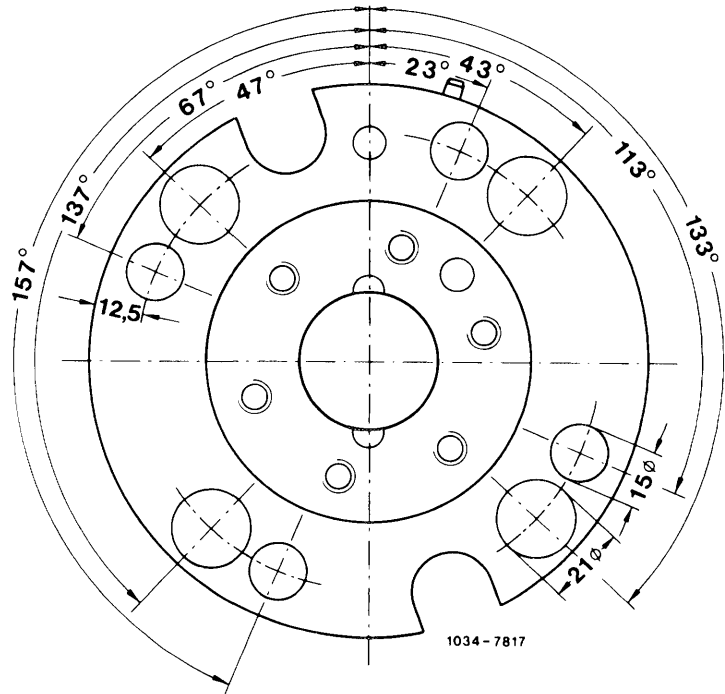
- 1 Position new balance plate on balancing drift, set off from old one by 180°.
- 2 Allow balancing drift with two balance plates to settle down on roller.



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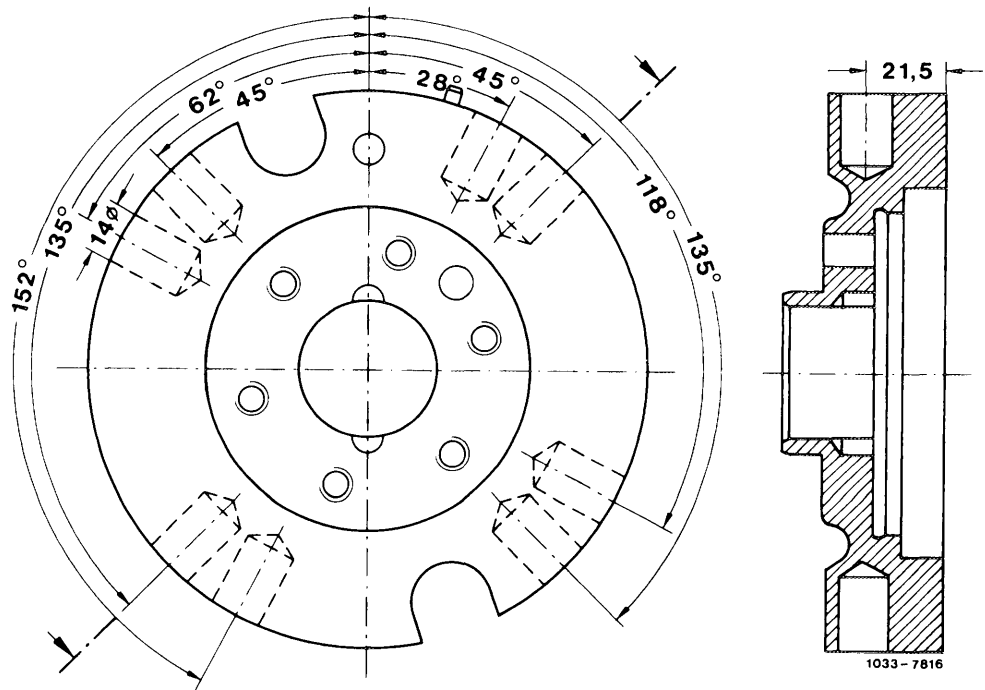
- 3 Spot-drill new balance plate until balance plates stop on roller at any position without swinging backward or forward:

Note positions of balancing holes (patterns).



**Drilling pattern 1**

Holes max. 25 mm deep



**Drilling pattern 2**

Holes max. 20 mm deep

Engine 617

Holes max. 20 mm deep

