03–430 Renewing ring gear

Data

Permissible axial runout on ring gear	max. 0.40
Centering flange dia. for ring gear	324.39–324.46 mm
Shrinking temperature	max. 200° C
Annealing color	red-brown

Conventional accessories

Temperature measuring chalk for 220 °C	e. g. AW Faber-Castell D-8504 Stein bei Nürnberg color No. 2815/220 (white), Thermochrome

Note

The ring gear is hardened. To protect hardened surface, the max. temperature of 200° C should not be exceeded at any point when heating ring gear. This can be done reliably only by means of a hot plate or a heating furnace. An open flame may be used in exceptional cases only. The flame should only wipe along inside of ring gear.

No balancing of flywheel is required after renewing ring gear.

Renewing

1 Drill into old ring gear and cut up with a chisel, or heat quickly and then remove immediately.

2 Clean mounting surface of ring gear on flywheel.

3 Heat new ring gear uniformly on a hot plate or in a heating furnace. For this purpose, use temperature measuring chalk according to instructions.

4 Mount heated ring gear immediately on flywheel.

Attention!
The teeth (arrow) should face starter.