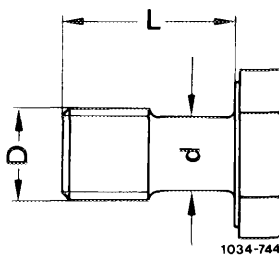


## 03–410 Removing and installing flywheel and driven plate

### Flywheel-crankshaft group

Group Code No.	Color code	Crankshaft dia. on mounting pin	Bore in flywheel or in driven plates
1	red	54.99–55.00	55.00–55.01
2	yellow	55.00–55.01	55.01–55.02
3	green	55.01–55.02	55.02–55.03

### Necked-down screw for flywheel or driven plates on crankshaft

Necked-down screws, part No.	116 032 02 71		
Thread D	M 12 x 1.5		
Shaft dia. d	when new	9.8–0.2	
	minimum dia.	9.3	
Length L	23		

### Tightening torque

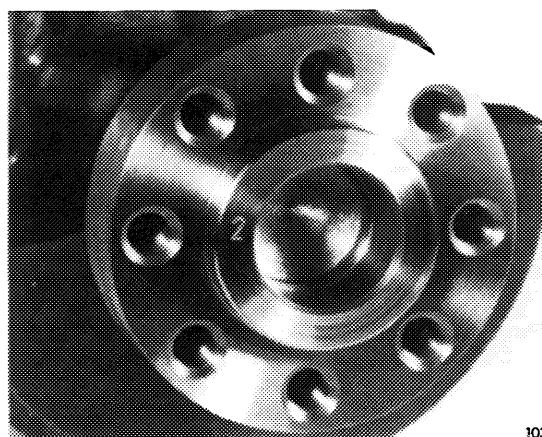
Initial torque	30–40 Nm
Angle of rotation torque	90–100°

### Note

When installing a new flywheel, the latter need not be balanced again, since the flywheel, the crankshaft and the vibration damper are individually balanced.

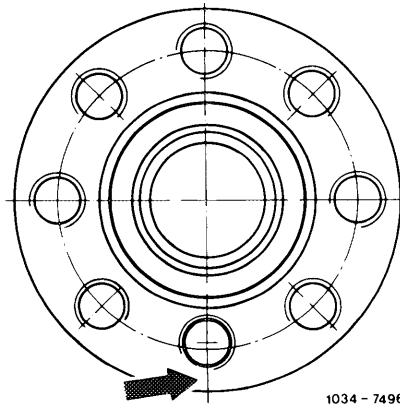
Due to installation tolerances, crankshaft and flywheel are combined in three groups.

During assembly, pay attention to color code or group code number on crankshaft (illustration) and flywheel.



103-9976

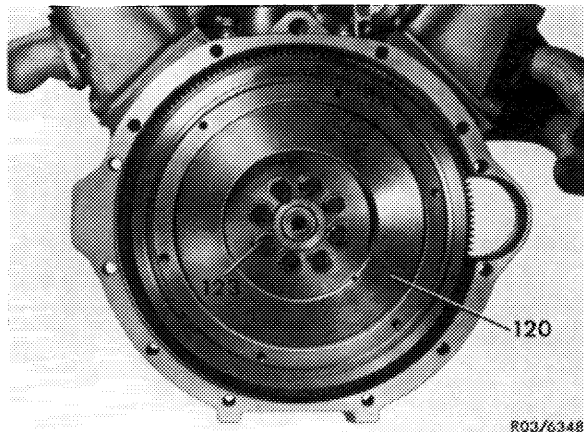
One of the eight fastening bores is located off center in pitch circle dia. (arrow). As a result, the flywheel or driven plates must be mounted in a given position. The whole pattern should be accurately aligned.



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**Removal**

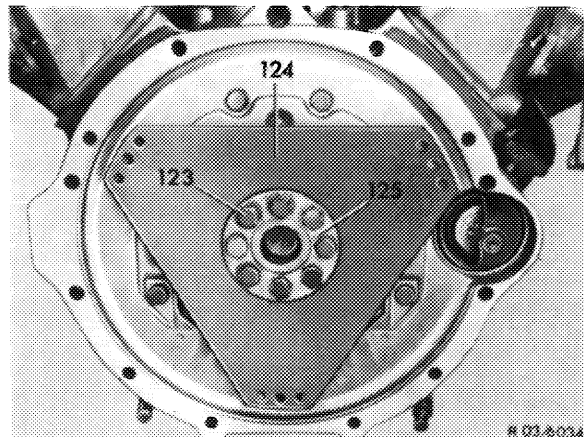
- 1 Remove transmission.
- 2 Unscrew necked-down screws and remove flywheel (manual transmission).



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- 120 Flywheel
- 123 Necked-down screws

Unscrew necked-down screws and remove spacing washers and driven plates (automatic transmission).

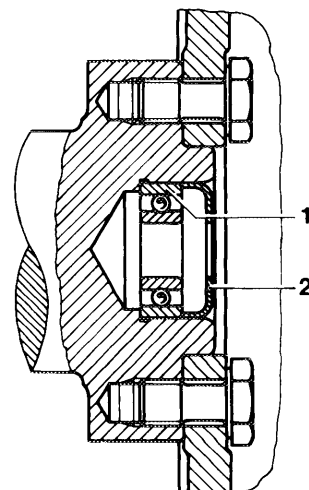


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- 123 Necked-down screws
- 124 Driven plates
- 125 Spacing washers

**Installation**

- 3 Measure necked-down shaft. If the specified minimum dia. "d" on shaft is attained, renew necked-down screws.
- 4 Mount flywheel or driven plates.



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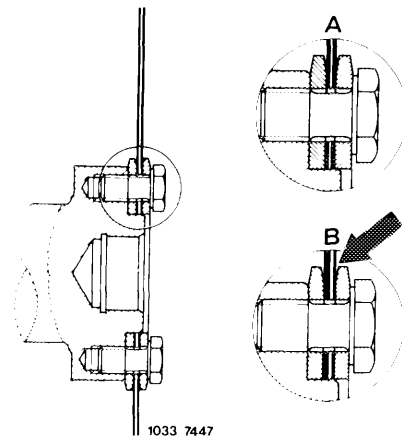
**Note:** In the event of repairs, the driven plates version "B" may be installed instead of version "A".

**Cutout A**

1st version: 2 driven plates 1 mm thick

**Cutout B**

2nd version: 1 driven plate 1.5 mm thick and 1 driven plate 1 mm thick (arrow)



5 Screw-in necked-down screws and tighten to 30–40 Nm initial torque and 90–100° angle of rotation torque.

