01-220 Installation and centering of intermediate flange

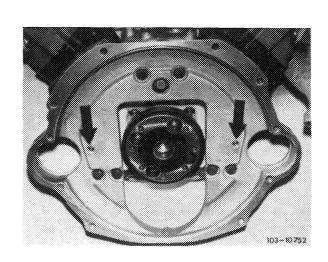
Tightening torques Fastening screws for intermediate flange Fastening screws M 8 for supporting angle on cylinder crankcase Fastening screws M 10 for supporting angle on intermediate flange Support of the flange of rotation torque of flywheel Special tool Dial gauge holder Necked-down screw for driven plate or flywheel Special tool Special tool Self-made tool	Data		
intermediate flange during one full turn Fitted bore in intermediate flange for centering pins 12,016 to 12.0 Tightening torques Nm Fastening screws for intermediate flange 50 Fastening screws M 8 for supporting angle on cylinder crankcase Fastening screws M 10 for supporting angle on intermediate flange Necked-down screw for driven plate or flywheel Dial gauge holder Self-made tool			0.10
Tightening torques Fastening screws for intermediate flange 50 Fastening screws M 8 for supporting angle on cylinder crankcase Fastening screws M 10 for supporting angle on intermediate flange Necked-down screw for driven plate or flywheel Special tool Dial gauge holder Nm 50 initial torque 30–40 angle of rotaton torque 90–100° Special tool Self-made tool			0.10
Fastening screws M 8 for supporting angle on cylinder crankcase 30 Fastening screws M 10 for supporting angle on intermediate flange 50 Necked-down screw for driven plate or flywheel angle of rotation torque 90–100° Special tool Dial gauge holder 363 589 02 21 Self-made tool	Fitted bore in intermediate flange for centering pins		12.016 to 12.043
Fastening screws M 8 for supporting angle on cylinder crankcase Fastening screws M 10 for supporting angle on intermediate flange Necked-down screw for driven plate or flywheel Special tool Dial gauge holder Self-made tool	Tightening torques		Nm
on cylinder crankcase Fastening screws M 10 for supporting angle on intermediate flange Necked-down screw for driven plate or flywheel angle of rotaton torque 90–100° Special tool Dial gauge holder Self-made tool	Fastening screws for intermediate flange		50
Necked-down screw for driven plate or flywheel Special tool Dial gauge holder Self-made tool			30
Necked-down screw for driven plate or flywheel angle of rotation torque 90–100° Special tool Dial gauge holder Self-made tool			50
Special tool Dial gauge holder Self-made tool		initial torque	30–40
Dial gauge holder 363 589 02 21 Self-made tool		angle of rotaton torque	90–100°
Self-made tool	Special tool		
	Dial gauge holder	- Y	363 589 02 21 00
Threaded bolt refer to Fig. ite	Self-made tool		
19.7	Threaded bolt		refer to Fig., item 3

Note

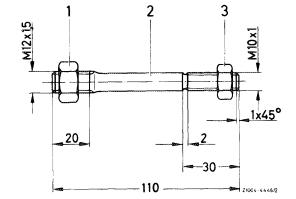
A new intermediate flange must be centered.

Installing and centering

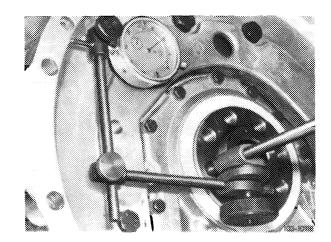
- 1 Insert intermediate flange into fitted pins (arrows) into crankcase.
- 2 Slightly tighten the four fastening screws.



3 Screw threaded bolts into crankshaft and counterlock.

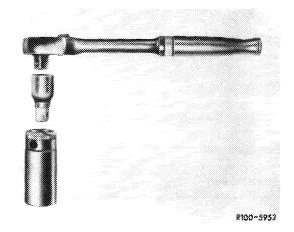


- Hex. nut M 12 x 1.5
- 2 Threaded bolt 10 mm dia.
- 3 Hex. nut M 10 x 1
- 4 Attach dial gauge holder with dial gauge to threaded bolt.
- 5 Position feeler pin against fitted OD of intermediate flange for measuring axial or radial runout. Set dial gauge to 0.



6 Turn crankshaft with tool combination in direction of rotation for one complete revolution. Radial or axial runout should not exceed max. 0.10 mm. This means that the total deflection may amount to max. 0.10 mm. If the axial runout exceeds 0.10 mm, renew intermediate flange.

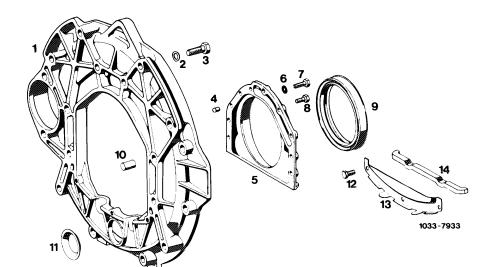
Note: When rotating crankshaft, make sure that feeler pin of dial gauge is not getting stuck.



- 7 Correct radial runout by means of light blows against intermediate flange.
- 8 Tighten fastening screws.

Note: If the radial runout is higher than 0.10 mm, remove intermediate flange.

- 9 Drill both fitted bores in intermediate flange to 12.1 mm.
- 10 Repeat item 1-8.
- 11 Mount supporting angle only after the intermediate flange has been attached to cylinder crankcase.



- 1 Intermediate flange
 2 Spring washer B 10
 3 Screw M 10 x 28
 4 Cyl. pin 6h 8 x 10
 5 End cover
 6 Washer A 6.4
 7 Screws M 6 x 25 (5 each)
 8 Screws M 6 x 20 (3 each)
 9 Radial sealing ring
 10 Cyl. pin 6h 8 x 10
 11 Cover
 12 Screw M 6 x 15
 13 Cover plate
 14 Sealing strip