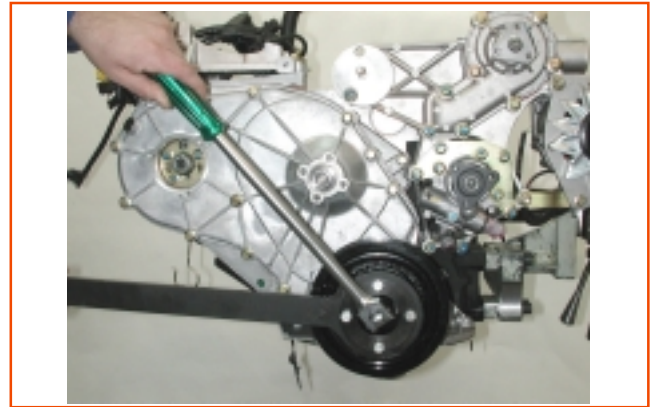


► FLYWHEEL

1. Remove gearbox.
2. Remove starter motor.
3. Remove clutch.
4. Install two long bolts of 8 mm in clutch bolt holes diametrically opposites, to use as handles when removing flywheel from crankshaft.
5. Install tool nr. 8130638 in crankshaft pulley and fix it with four bolts, to immobilize crankshaft during flywheel fixation bolts removal.
6. Loosen flywheel fixation bolts and remove it.



Cleaning and inspection

1. Wash all parts with biodegradable chemical detergent.
2. Check if gear ring teeth are worn. To replace, see GEAR RING REPLACEMENT.
3. Use a male M14 in crankshaft bolts holes, to remove the residues of Loctite.

Reinstallation

Note: To avoid flywheel excessive eccentricity, make sure if flywheel and crankshaft contact surfaces are perfectly clean.

1. Install flywheel on crankshaft and fix it with thrust plate and new bolts, tightening according to specification.
2. Check flywheel eccentricity, assembling a dial indicator gauge so that its point touches at 114 mm from the center of the flywheel.

3. Check eccentricity to do not exceed from 0,05 mm to 0,07 mm. If eccentricity is excessive, remove flywheel and check again for irregularities on flywheel, crankshaft and guide thrust surfaces.
4. Check with dial indicator gauge, concentricity between flywheel diameter and crankshaft.
5. Reinstall in the inverse order of the removal, install the fixation bolts, using Scotch Grip and tighten with 60 Nm + 30°.

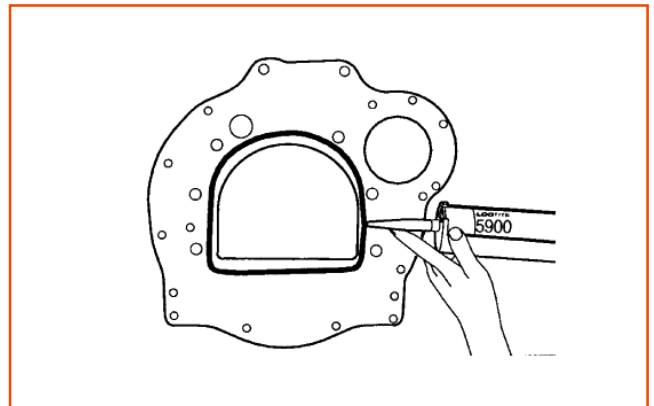
Flywheel housing

Removal

1. Remove flywheel, see FLYWHEEL Removal.
2. Remove the flywheel housing support four bolts.
3. Loosen the six central bolts and remove flywheel housing.

Reinstallation

1. Clean engine block and remove the excess of liquid gasket (Loctite 5900) from the block.
2. Apply a 4 mm fillet of Loctite 5900 on flywheel housing.



3. Install housing on engine block and fix it with bolts according removed and tighten according to specification, see TECHNICAL SPECIFICATIONS.

RING GEAR REPLACEMENT

Warning: Following operations evolve heat, and may cause burinings.

Disassembly

1. Put flywheel in a recipient, with clean water and support ring gear on four metal blocks, so ring gear stays approximately 6,5 mm (1/4") above the level of water.
2. Heat ring gear on all its extension so that flywheel loosen.

Assembly

1. To assembly ring gear on flywheel, heat it up to approximately 246 °C (475 °F) in a stove.

