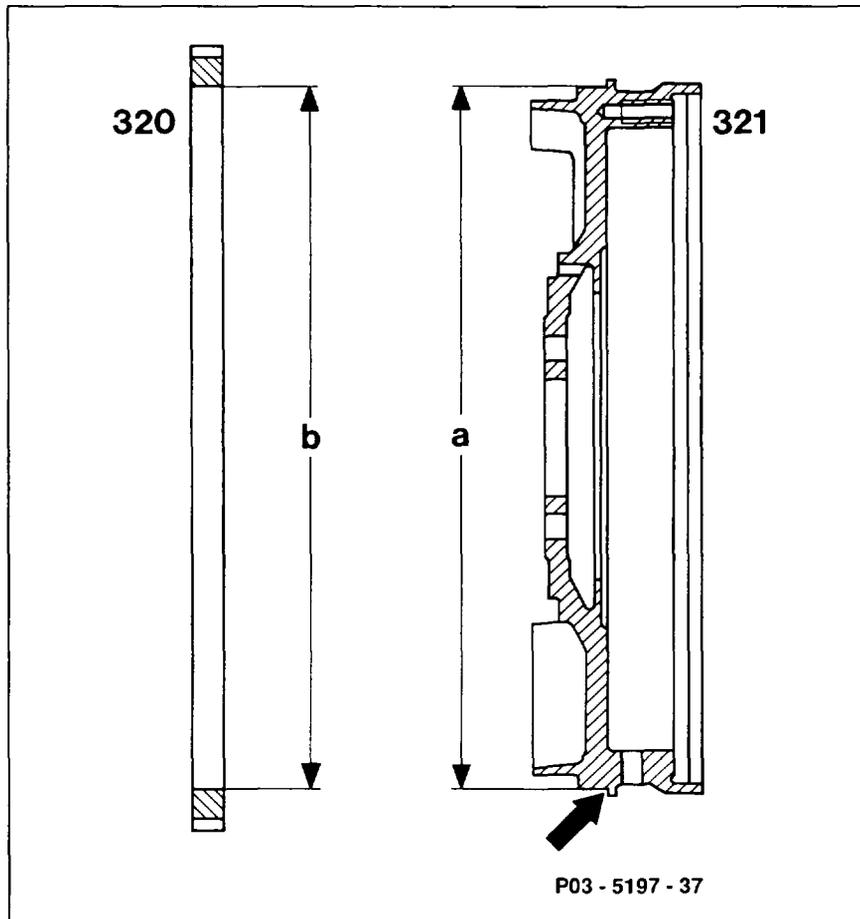


## 03-4300 Replacing ring gear

Preceding work:  
Flywheel removed (03-4100).



### Flywheel and two-mass flywheel

Ring gear (old) .....	drill and snap with a chisel or heat rapidly and remove immediately.
Contact surface of ring gear on flywheel (321) ...	clean.
Centering collar dia. (a) on flywheel (321) and ring gear ID (b) .....	measure.
New ring gear (320) .....	heat to 200 °C.
Temperature measuring chalk .....	use. Pay attention to note.
Ring gear (320) .....	fit immediately onto flywheel (321) flush.
The ring gear must be touching the contact surface (arrow) on the flywheel (321) .....	all round.

**Data**

Permissible deviation at ring gear	axial runout	0.4 mm
	radial runout	0.3 mm
Centering collar dia. for ring gear (a)		275.32 – 275.40 mm
Ring gear ID (b) (when new)		275.00 – 275.05 mm
Shrink-fit temperature		max. 200 °C

**Commercially available accessories**

Temperature measuring chalk Color no. 2815/220 (white) Thermochrom	eg. AW Faber-Castell D-90547 Stein bei Nürnberg
---	--

**Note**

The ring gear is hardened. In order not to impair the hardening, a maximum temperature of 200 °C must not be exceeded at any point of the ring gear when it is heated. This can only be reliably achieved with the heating plate or with an oven. A flame may only be used in exceptional cases. The flame should only touch the inside of the ring gear.

The ring gear of the two-mass flywheel is shrink-fitted onto the primary flywheel mass.

After replacing a ring gear, the flywheel does not need to be balanced.

### Automatic transmission:

The driven plate (11) is riveted to the ring for the ring gear (12). The ring gear (15) is welded to the ring for the ring gear (12). This unit is balanced individually and can be replaced without balancing (03-4100).

#### Layout on automatic transmission

- 1 Oil sump
- 2 Cover
- 3 End cover with radial seal
- 4 M10 × 1 × 22 stretch bolt
- 5 Crankshaft
- 6 Dowel pin
- 7 2.6 mm disk (glued on)
- 8 3.5 mm disk
- 9 Disk
- 10 Bolt
- 11 Driven plate
- 12 Ring for ring gear
- 13 Rivet
- 14 Segment
- 15 Ring gear

