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The present section contains the following assembly sequences:

A. clutch and flywheel assembly

B. clutch thrust bearing assembly



A. CLUTCH AND FLYWHEEL ASSEMBLY

Clutch (Fig.1)

- | | |
|----|--|
| A. | crankshaft |
| B. | flywheel |
| C. | screws securing the flywheel to the crankshaft |
| D. | clutch unit |
| E. | screws securing the clutch to the flywheel |
| F. | phonic wheel |
| G. | clutch thrust bearing assembly |
| H. | gearbox |

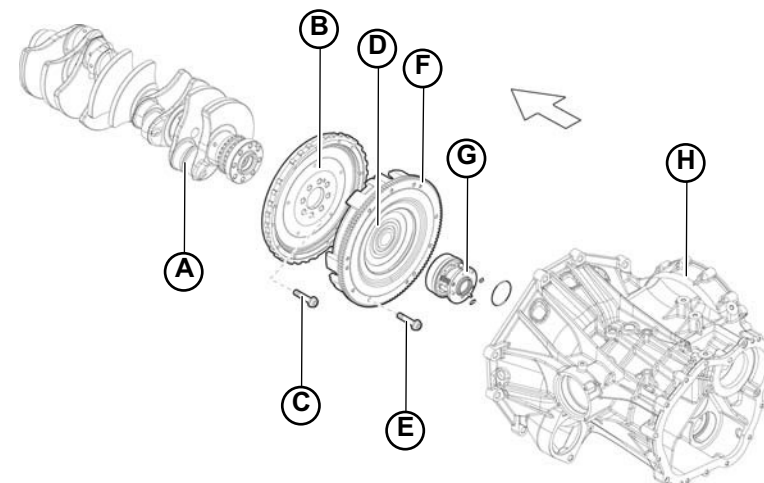


Fig.1



Note

The new flywheel/clutch unit is supplied balanced. The correct assembly position is indicated by reference codes.



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Preassembling the phonic wheel on the flywheel

1. Assemble the phonic wheel (**F-Fig.1/2**) on the flywheel (**B-Fig.1/2**) using the 3 mounting screws (**I-Fig.2**).
Apply System 52A43 medium thread sealant onto the thread of the 3 screws.
Screw attachment: tightening torque (000800-6a).

STOP Tighten the screws, following the ascending order from I1 to I3 shown in Fig.2 (carry out tightening in a clockwise direction).

STOP When tightening, check that all of the external holes of the flywheel coincide with those on the phonic wheel and that there are always 3 holes between each mounting screw.





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Assembling the flywheel onto the crankshaft

1. Position the flywheel on the crankshaft so that the centering dowel on the flywheel coincides with the centering dowel on the crankshaft (**L-Fig.3**).
2. Check that the 10 flywheel mounting screws on the crankshaft are clean.
3. Clean the threaded holes on the crankshaft with LOCTITE 7063 and then compressed air.
4. Secure the flywheel onto the crankshaft using the 10 mounting screws (**C-Fig.1/4**).
Apply System 52A43 medium thread sealant onto the thread of the 10 screws.
Screw attachment: tightening torque (000800-2b).



Tighten the screws, following the ascending order from C1 to C10 shown in Fig.4.
Always use new screws and never use screws previously employed for flywheel attachment.

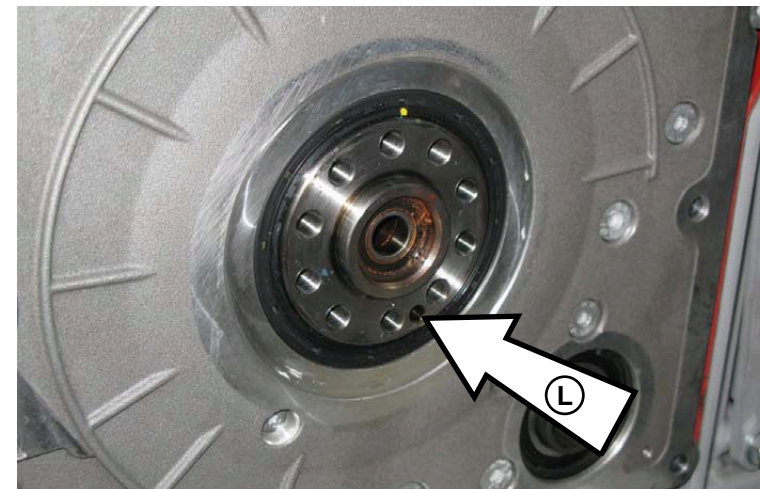


Fig.3

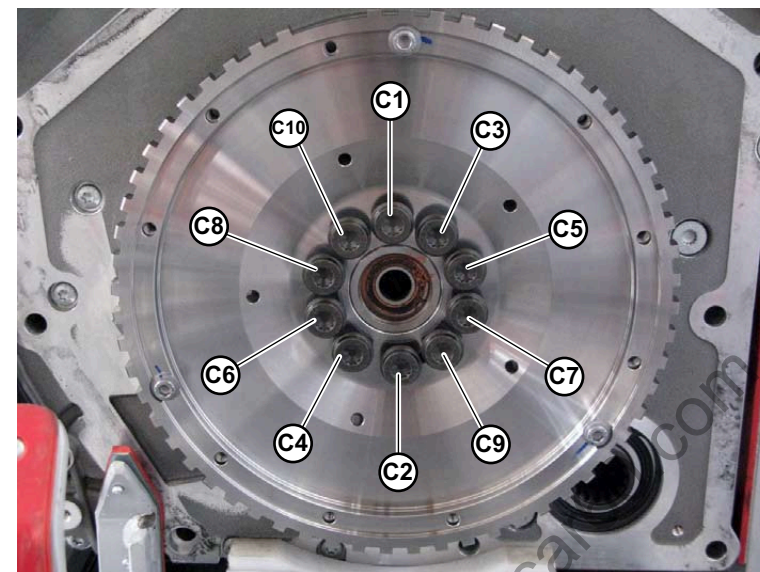


Fig.4



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Assembling the clutch

2. Assemble the clutch unit on the flywheel using the special centering tool (000200-19c) and check that the reference codes coincide (M-Fig.5).
Apply System 52A43 medium thread sealant and tighten the 9 screws (E-Fig.1) in the clockwise order indicated by the numbers in Fig.6.
Tightening torque (000800-4b).
 - Reassemble the gearbox (030105).



Fig.5

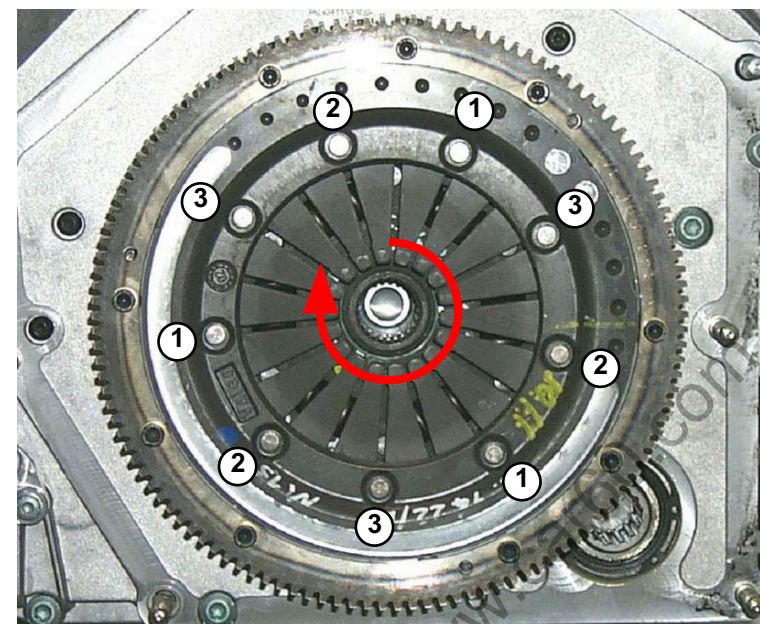


Fig.6



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B. CLUTCH THRUST BEARING ASSEMBLY



Important!

Keep everything as clean as possible during assembly.

1. Clean the inside of the clutch bell and the ribbed shaft.
2. Thoroughly clean the machined area (**A-Fig.7**) of the clutch sleeve housing on the clutch bell and the seats of the O-rings (**B-Fig.7**).
3. Thoroughly clean all of the surfaces of the clutch sleeve unit with a clean cloth and thoroughly check that the oil flow holes are not obstructed.
4. Assemble the O-ring (**C-Fig.8**) on the clutch sleeve with **Kuril K2** and lightly grease the internal edge of the seal (**D-Fig.8**).

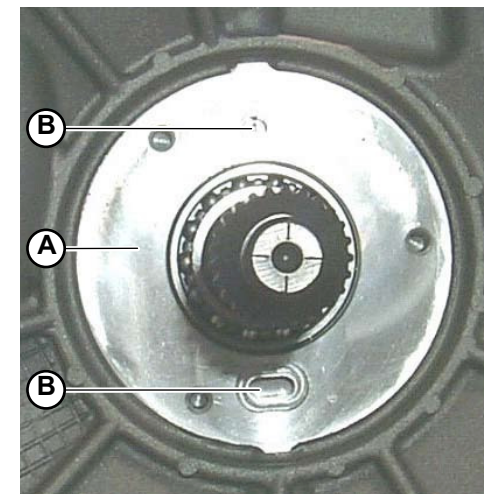


Fig.7

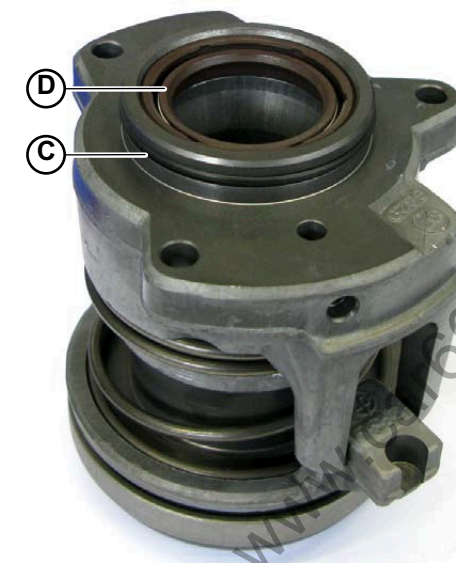


Fig.8



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5. Assemble the two O-rings (**F-Fig.9**) on the clutch bell seat with Kuril K2.
6. Before inserting the clutch sleeve unit on the gearbox, completely protect the grooved profile of the shaft with tape (**G-Fig.9**); start wrapping the tape at the gearbox.

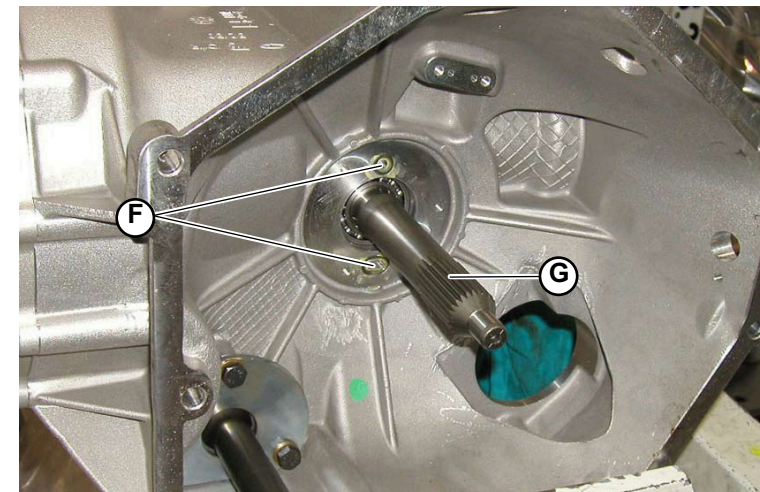


Fig.9

7. Insert the clutch sleeve unit (**H-Fig.10**), sliding it along the ribbed shaft wrapped with tape, pressing on the sleeve.
8. Tighten the three pins (**L-Fig.10**) and secure the clutch sleeve onto the clutch bell.



Note (E-gear)

Tighten the five screws (**L1-Fig.10**) and secure the **e-gear** clutch sleeve onto the clutch bell.

9. Push the bearing toward the gearbox and remove the protective tape.



Important!

Remember to remove the protective tape.

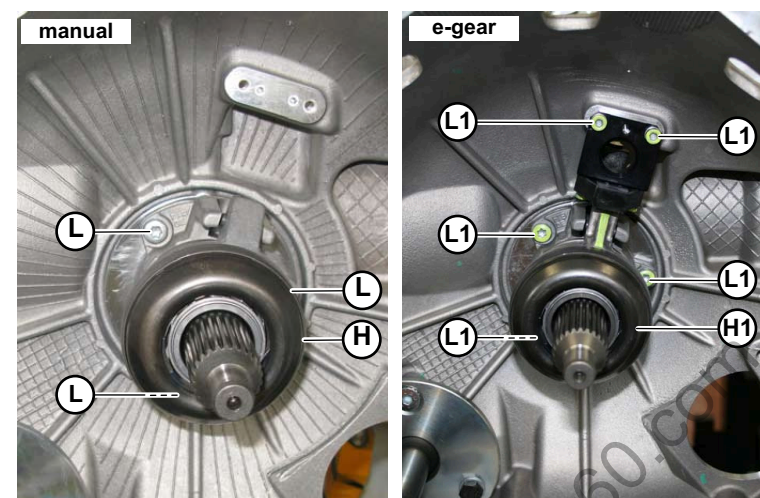


Fig.10

- Reassemble the gearbox (**030105**).
- Bleed the clutch (**014106**).