

Grinding Clutch Surface of Flywheel

Types 220 and 220a

Operation
No.

M 14

Procedure:

The clutch surface of the flywheel must be re-conditioned if it shows scores or burnt spots. Surface grind or fine turn clutch surface on a suitable machine and lap with emery cloth.

Clutch surface A can be reworked until dimension $a = 32 \text{ mm}$ (1.26") in Type 220 and $a = 22 \text{ mm}$ (0.87") in Type 220a has been reached. It is not permitted to proceed beyond these values (Fig. M 14/00).

Rework surface B by the amount that has been removed from clutch surface A. Note that surface B must be recessed 0.2–0.3 mm (0.008–0.012") from surface A.

In new condition dimension "a" is as follows:

Type 220 = 32.9–33.1 mm (1.295–1.303)

Type 220a = 22.9–23.1 mm (0.902–0.909)

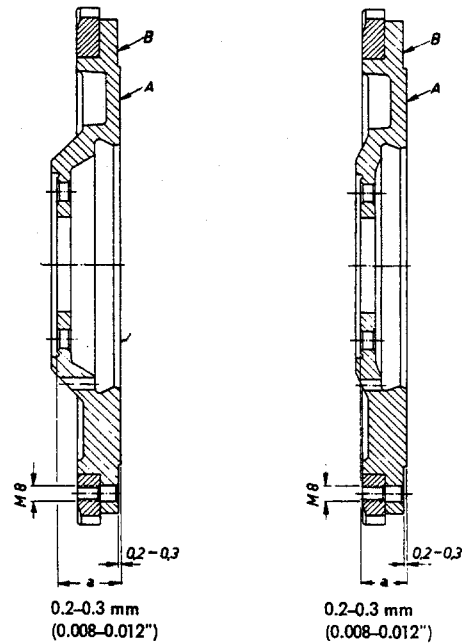


Fig. M 14/00