

Balancing of Crankshaft with Counterweight and Flywheel

Types 220 and 220a

Operation No.
M 16

The crankshaft is provided with three counterweights: one at the vibration damper flange, another in the middle of the shaft and a third one at the flywheel. These weights permit to balance the crankshaft **dynamically** (Fig. M 16/00). Each of the three counterweights has a definite unbalance. When the crankshaft with front counterweight and flywheel is installed, these three unbalances will compensate each other.

The unbalance must not be more than 15 cmg (0.20 oz. in.).

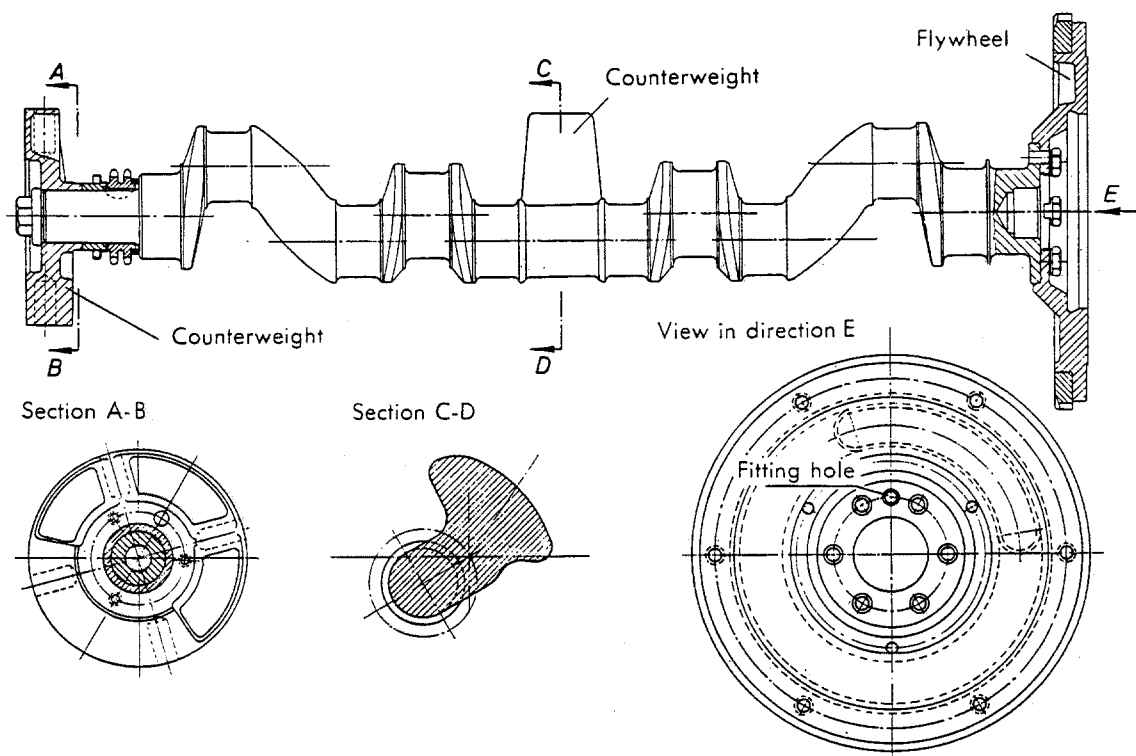


Fig. M 16/00

Drill the radial balancing holes at the circumference of the counterweight with a drill of 14 mm (0.55") diameter. Note that the maximum depth of the holes is 30 mm (1.18").

In the flywheel the balancing holes are drilled on a diameter of 240 mm (9.45") with a drill of 14 mm (0.55") diameter. Here the maximum depth of the holes is 8 mm (0.315"). See Operation No. M 16a, cf. 4.