

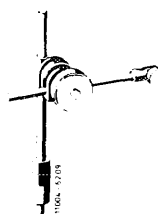
01–220 Installation and centering of intermediate flange

Data

Radial runout of intermediate flange	max. 0.10	
Permissible axial runout of intermediate flange when mounted in crankshaft bearing basic bore during one full turn.	0.10	
Tightening torques	Nm	
Intermediate flange mounting bolts	65	
Drive plate and flywheel expansion bolt	Torque pressure	40
	Torque angle	90–100°

Special tool

Dial gage holder (two required)



121 589 00 21 00

Self-made tool

Threaded pin

see fig, point 3

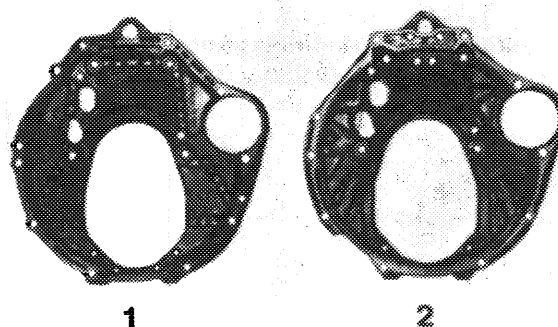
Conventional tool

Dial gauge A 1 DIN 878

e.g. made by Mahr, 7300 Esslingen
order no. 810

Note

A replaced intermediate flange must be centered. The automatic transmission W4A040 requires the intermediate flange (1) with fitted pin and all-around centering system, which can be used as a replacement for the formerly used intermediate flange (2) with all-around centering system.



- 1 Modified intermediate flange 110 011 15 45
2 Former intermediate flange 115 011 11 45

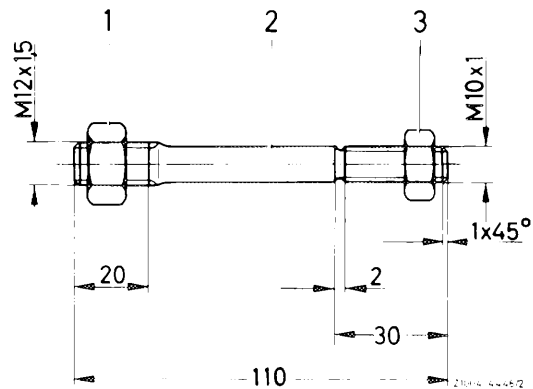
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Series installation of intermediate flange
 110 011 15 45 starting end of november 1979

Starting engine end no.	Starting chassis end no.
110.923 -10-014 453 -12-017 710	123.030-028 448 123.050-003 543
110.984 -10-021 092 -12-070 620	123.033-067 904 123.053-018 127
110.922 -10-040 775 -12-067 894	116.020-121 410
110.932 -10-010 365 -12-002 796	
110.985 -10-014 287 -12-073 060	116.024/025-154 967
110.986 -10-003 392 -12-007 701	107.042-007 301 107.022-007 921

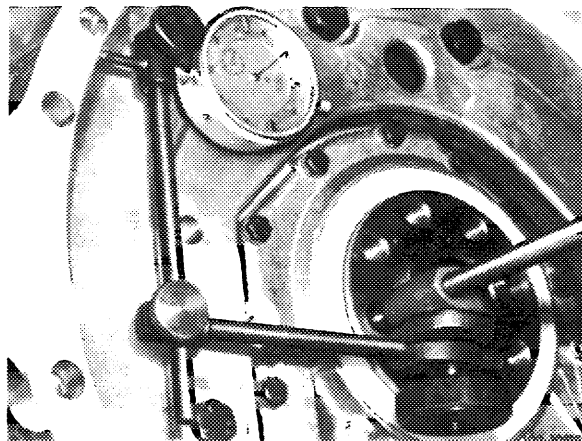
Installing and centering

- 1 Place intermediate flange over dowel pins in crankcase.
- 2 Tighten the four mounting bolts slightly.
- 3 Screw threaded bolt (self-made) into crankshaft and counterlock with hex nut.



- 1 Hex nut M 12 x 1.5
- 2 Threaded bolt 10 mm dia
- 3 Hex nut M 10 x 1

- 4 Attach dial gauge holder with dial gauge to threaded bolt.
- 5 Position feeler pin at fitting point of centering surface. Set dial gauge to 0.



6 Rotate crankshaft for one full turn by means of tool combination. Vertical runout should not exceed max 0.10 mm.

Note: When rotating crankshaft, make sure that the feeler pin of the dial gauge is not getting stuck.

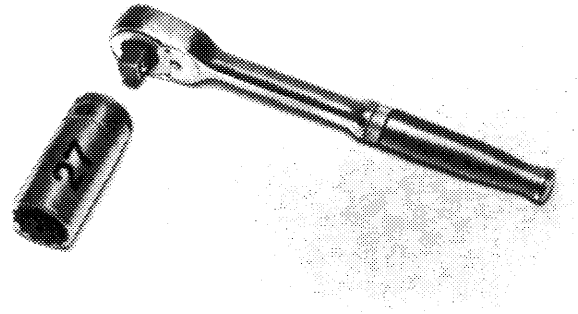


FIG-6498/7

7 Correct vertical runout by light blows against intermediate flange.

8 Tighten fastening screws.

Note: If the vertical runout exceeds 0.10 mm, remove intermediate flange.

9 Increase diameter of both fitted bores in intermediate flange to 12.1 mm.

10 Repeat item 1–8.