

## 03-440 Static balancing of flywheel

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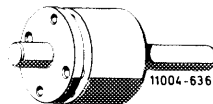
### Data

Flywheel for	Balance bores max. drilling depth	Drill dia.	Hole locating dia.
manual transmission	20 + 1	11	251
automatic transmission	drilled through		

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### Special tool

Balancing mandrel  
(flywheel for automatic and  
manual transmissions)



617 589 00 63 00

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### Conventional tool

Rolling device for static  
balancing

Trebel, D-4030 Ratingen  
type EO, order no. 03600/0904/E 0010

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### Note

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Crankshaft, balance disc and flywheel are balanced together.

A new flywheel must be balanced to the same value of the one removed.

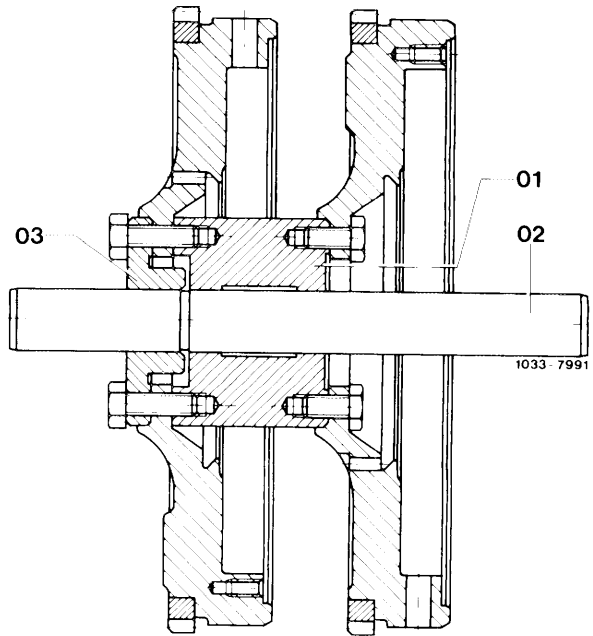
The balancing condition of a flywheel for manual transmission can be transferred to a flywheel for automatic transmission by static balancing (and vice versa).

### Static balancing

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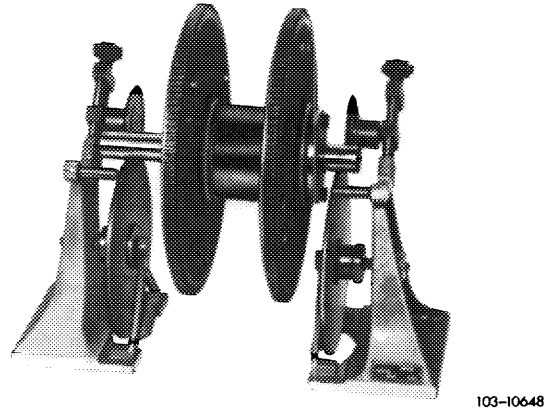
- 1 Place old and new flywheels on top of each other that all bores align and both clutch surfaces face in one direction.
- 2 Transfer mark from old to new flywheel.

3 Apply balancing mandrel and bolt new flywheel with an offset of exactly 180° over old unit.



01 Mounting fixture  
02 Shaft  
03 Centering disc

4 Let balancing mandrel with both flywheels oscillate on rolling device.



5 If an unbalance is found, drill so many holes in mass of new flywheel until the flywheels remain still without oscillating in any position.

**Attention!**

The hole circle dia, the drill dia and the max drilling depth must be maintained (refer to table).

The dust bores (arrows) must not be drilled.

