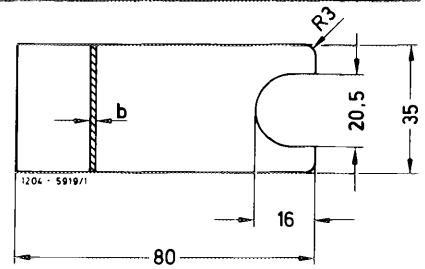
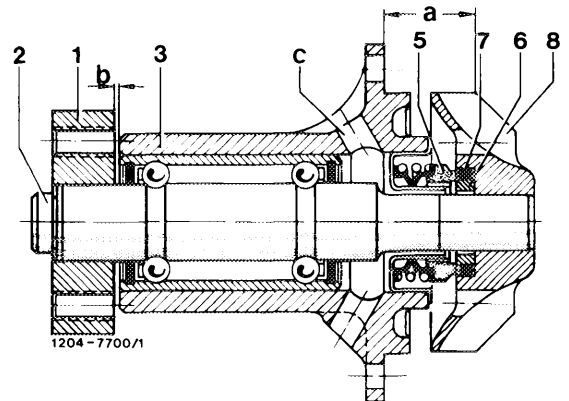
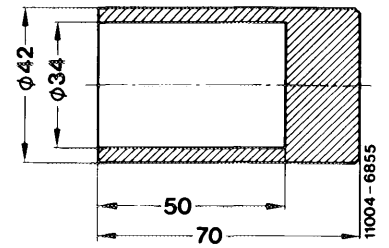


Self-made tools

Spacing plate  
b = 2 mm



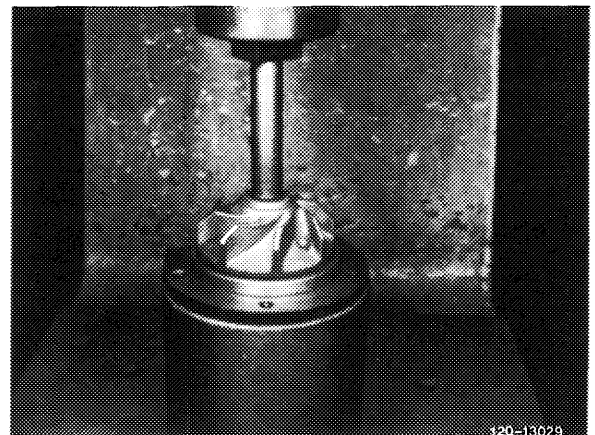
Pressing-in sleeve



- |   |                |
|---|----------------|
| 1 Fan hub                                 | 7 O-ring       |
| 2 Coolant pump shaft with compact bearing | 8 Impeller     |
| 3 Bearing housing                         | a 22.8–23.2 mm |
| 4 Counterterring                          | b 2 mm         |
| 5 Slide ring seal                         | c Vent holes   |

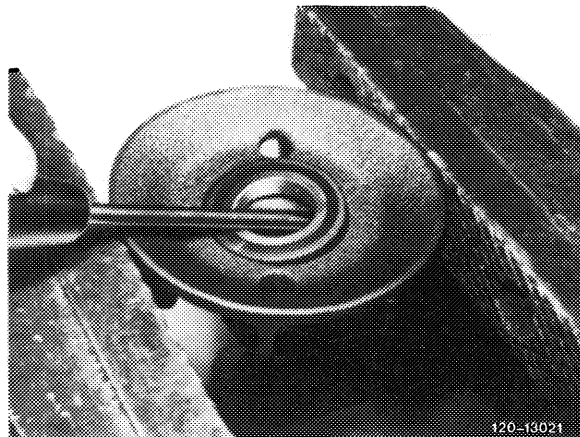
Disassembly

- 1 Support bearing housing with pertinent tubing and press out coolant pump shaft by means of a mandrel.
- 2 Knock sliding ring seal out of bearing housing.



3 Remove counterring from impeller.

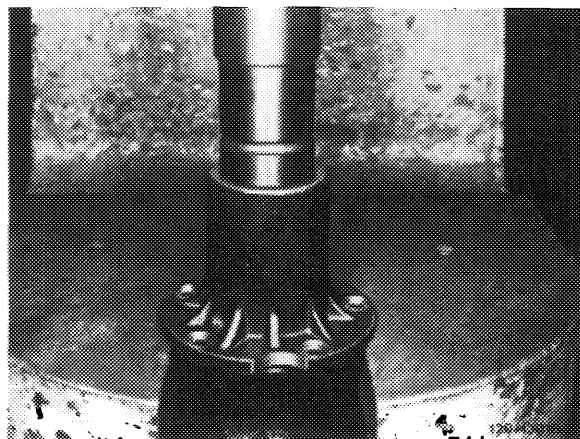
**Note:** Always replace compact bearing and fan hub following disassembly.



### Assembly

4 Press in new compact bearing flush with bearing housing by means of a tube positioned against outer race.

**Do not press against coolant pump shaft.**

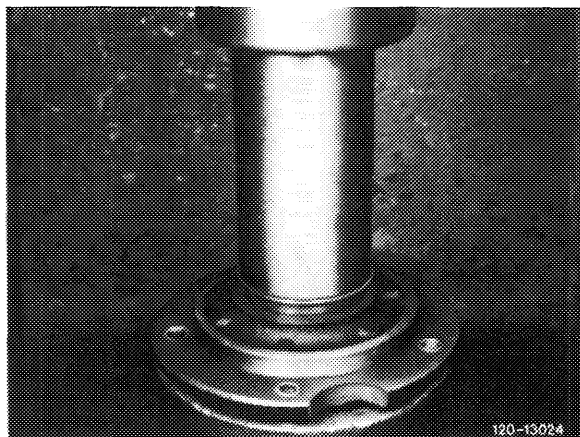


5 Coat mounting bore of sliding ring seal in bearing housing slightly with sealing compound (part No. 001 989 25 20).

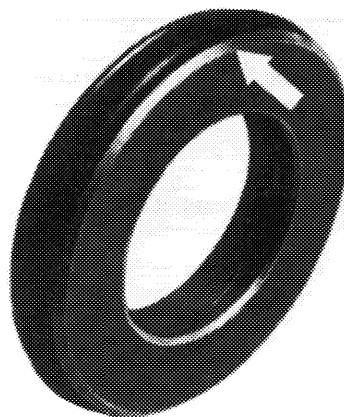
Press-in or knock-in sliding ring seal with pressing-in sleeve.

#### **Attention!**

Support only against bearing housing and not against coolant pump shaft.



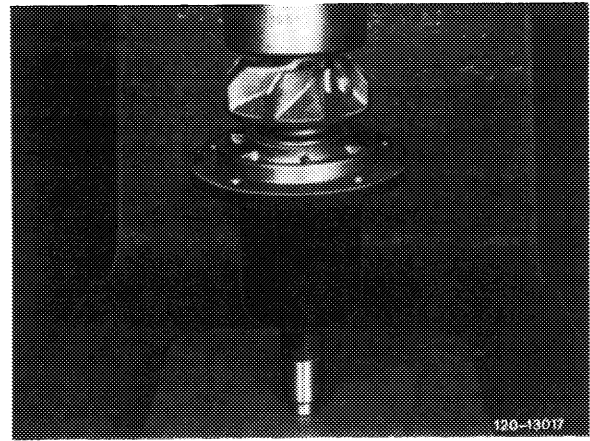
6 Coat O-ring on counterring with brake cylinder paste and push with chamfered side (arrow) into thoroughly cleaned impeller.



7 Clean sealing surfaces of countererring and sliding ring seal free of dust by means of a chamois cloth.

8 Degrease both shaft stubs and impeller in bore.

9 Press-on impeller flush with shaft while supporting coolant pump shaft.



10 Heat fan hub on a hot plate to approx. 300 °C (annealing color dark – up to light blue).

Place heated fan hub on a recessed base. Hold spacing plate on coolant pump shaft, slip coolant pump shaft on fan hub and apply a blast of compressed air against hub. Wait for a few seconds until fan hub is firm and then cool immediately in water bath.

