



CLUTCH FITTING TECHNICAL NOTE

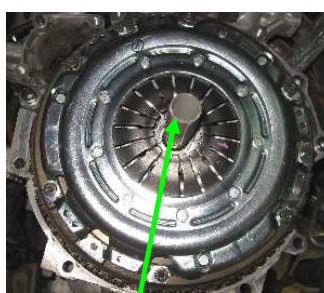

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After disassembling the gearbox from the engine :

- 1- Check engine crank shaft seal : Verify that there is not oil contaminating the flywheel . In case of presence of oil leak , remove the flywheel and change the crankshaft seal and reassemble the flywheel.
- 2- Check gearbox input shaft splines checking that there is not damaged or show excessive wear along the spline length.
- 3- Check Flywheel Fixing Bolts.
- 4- Check Flywheel Friction surface .If there are cracks and/or excessive wear of the friction surface, or blue color due to heating, change the flywheel.
- 5- Check the gear box input shaft seal : Verify that there is not oil coming from the gear box. In case of presence of oil repair the gear box changing the input shaft seal.
- 6- Check the hydraulic bearing (change it if it is damaged):
 - a. Check that the bearing is well rotating under axial hand load: smooth rotation without hard points
 - b. check the wear on the bearing contact ring with the diaphragm . The marks of contact have to be not excessive (less than 0,5mm)
 - c. check that there is not oil coming from the interior of the hydraulic bearing
- 7- Check that the push rod at receiver cylinder can move sliding smooth when is pushed and it don't leak oil



Apply a small quantity of grease



Centering tool

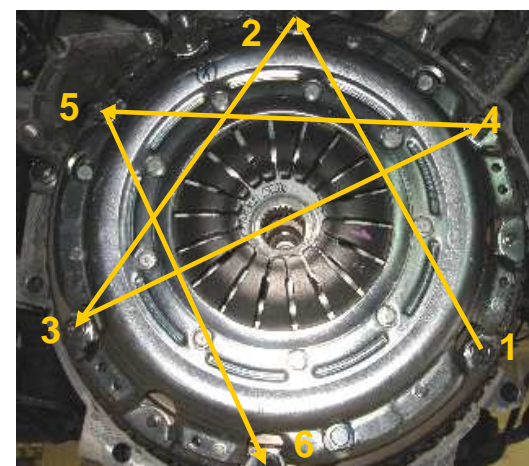
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Prepare the clutch for assembly :

- 1- Apply a small quantity of grease in the hub splines at approximately 5 mm of the hub extremity
- 2- Position the driven plate in the flywheel thanks to the centering tool.
- 3- Fasten the cover assy centering it with the pins and hand tightening 3 screws at 120° and checking that the driven plate remains stable and well centered with the centering tool.
- 4- Use the original bolts from the car **M8x1,25x14**.

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Fasten the clutch :



- 1- Position the driven plate in the flywheel thanks to the centering tool (to see photo)
- 2- Fasten the cover assy centering it with the pins and hand tightening 3 screws at 120° and checking that the driven plate remains stable and well centered with the centering tool.
- 3- Tighten smoothly each screw respecting a star-like sequence as for the tightening of the flywheel. The diaphragm fingers have to move as uniform as possible. Repeat the complete sequence approximately 3 times. Use screws original from the car **M8x1.25x14**.
- 4- Complete the fastening applying a torque of **25Nm** thanks to a torque wrench respecting the previous sequence.

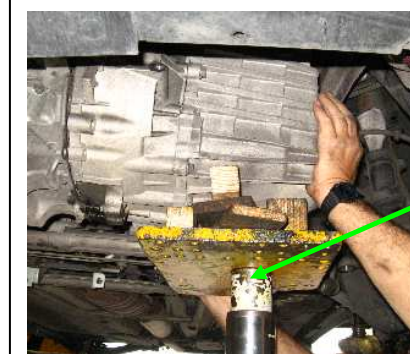

25 Nm
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Re-assemble the gearbox

1. Check that the dowell pins are existing and that they are not damaged.
2. Position the gearbox coaxially with the engine crankshaft, supporting the gearbox weight with the appropriate tools.
3. Introduce the gearbox input shaft into the driven plate hub spline.
4. Take care that the input shaft be introduced without shock. If necessary rotate the crankshaft to make easier the input shaft fitting.

Avoid that the weight of the gearbox be supported by the driven plate of the clutch during the assembly.

5. Check that the gearbox is in full contact with the engine block and that the centering pins are well fitted
6. Fixe the gearbox to the engine block tightening the all the bolts with the appropriate torque



Use the appropriate device to assembly and disassembly the gearbox. The operator never must support the weight of gearbox.

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After the assembly

Check that the clutch is well working:

1. Check that the clutch is well disengaging and reengaging allowing a smooth shifting of each gear box ratio (including reverse)
2. Check that there is not abnormal noise when engaging and disengaging operation
3. Check that that there's not abnormal vibration or noises when increase engine speed in neutral up to **5000 rpm**.
4. Check that there is not abnormal clutch sliding in driving conditions.