



Bild 57

Kolbeneinbauspiel: 0,04...0,06 mm.
Kolben in vorgeschriebener Einbaurichtung (der Pfeil auf dem Kolbenboden zeigt in Fahrtrichtung) einsetzen, eingölten Kolbenbolzen auf den Führungsdorn stecken, in die Pleuelbuchse einführen.

Kolben dabei gut festhalten, damit das ausgerichtete Pleuel nicht verdrückt wird.

Werkzeug: Einführdorn,
EV 37001-33



Bild 58

Sicherungsringe sorgfältig in die Ringnuten der Kolbenbolzenaugen einsetzen und sich von deren ordentlichen Sitz überzeugen.

Werkzeug: Seegerringzange



Bild 59

Zylinderfußdichtung mit Wasser anfeuchten und auf die Dichtfläche legen. Haltegabel für den Pleuel einschieben. Kolben und Zylinder mit Öl versehen. Kolbenring-Spannband auflegen.

Achtung! Kolbenringe so drehen, daß der Stoß mit den Sicherungstiften übereinstimmt.

Kurbelwelle zum Vermitteln des Zylinders einige Male durchdrehen. Zylinderdeckel aufsetzen. Befestigungsmuttern M6 mit Federscheiben B6 aufschieben und gleichmäßig über Kreuz anziehen.

Werkzeug: Haltegabel EV37001-30,
Steckschlüssel,
SW 10 mm,
Kolbenband DV 37314-1.

Simpson Schwalbe Manual

**Sidney Lovell Phipson, Derek William
Elliott**



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