

Zylinder

Zylinderbohrungen auf Verschleiß prüfen. Zylinderdurchmesser darf max. 0,15 mm größer als der Nennwert sein. Ist der Zylinderdurchmesser größer als bei diesen Maßangaben, ist eine mögliche Ölwanne und Ventileinstellung nötig.

Zylinder-Durchmesser für 1. Schritt			
Typ 444	Typ 445	Typ 446	Typ 447
76,75 - 76,77 76,73 - 76,75	86,25 - 86,27 86,23 - 86,25	96,25 - 96,27 96,23 - 96,25	106,25 - 106,27 106,23 - 106,25
			toleranz: Nennwert -0,050 mm

Die kugelförmige Oberfläche des Zylinders muß plan sein. Abgebürstet kann die Endfläche bis max. 0,3 mm nachgearbeitet werden.

Zerlegen des Zylinderkopfes

Verbrühungsrisikofeld vorsichtig mit stumpfen Werkzeug entfernen. Zylinderkopf an den beiden Boltschrauben M8 im Schraubkopf an den beiden Boltschrauben M8 im Schraubkopf mit Schutzblech anspannen. Beide Ventildeckel ① abschrauben und die 4 Ventileinbauschrauben ② lockern. Beide Verschlußschrauben ③ mit Stiftschlüssel B herausheben.

Cylinder

Check cylinder working surfaces for wear. If cylinder diameter exceeds nominal diameter by more than max. 0,15 mm it must be rebored. Ensure that sealing surfaces are clean.

Roundness and taper max. tolerance 0,03 mm.

Cylinder diameter for 1st oversize

Typ 444				Typ 445				Typ 446				Typ 447			
76,75	76,76	76,77	76,78	86,25	86,26	86,27	86,28	96,25	96,26	96,27	96,28	106,25	106,26	106,27	106,28
76,73	76,74	76,75	76,76	86,23	86,24	86,25	86,26	96,23	96,24	96,25	96,26	106,23	106,24	106,25	106,26

The tolerance of roundness and taper is 0,03 mm.



Cylinder

Check cylinder working surfaces for wear. If cylinder diameter exceeds nominal diameter by more than max. 0,15 mm it must be rebored. Ensure that sealing surfaces are clean.

Roundness and taper max. tolerance 0,03 mm.

Typ 444				Typ 445				Typ 446				Typ 447			
76,75	76,76	76,77	76,78	86,25	86,26	86,27	86,28	96,25	96,26	96,27	96,28	106,25	106,26	106,27	106,28
76,73	76,74	76,75	76,76	86,23	86,24	86,25	86,26	96,23	96,24	96,25	96,26	106,23	106,24	106,25	106,26

La superficie di tenuta, lato testa cilindro, deve essere pulita. Se necessario, abbasare per apertura al massimo 0,3 mm.

Svettaggio della testata

Eliminare con cura i residui di combustione. Fissare la testata nella morsa ad ingranaggi M8. Svitare i 2 supporti della valvola ① e allentare le 4 viti di aggiustaggio delle valvole ②. Svitare i 2 tappi laterali ③ con una chiave da 8.

Beide Kipphebel lockern. Viti-Schraube M8 ① herausheben. Beide Kipphebel mit je 1 Anlaufschraub und 1 Federschraube herausnehmen. Zum Auslösen der Nockenwelle (Sicherungsring) ② abschrauben und Ölwanne ③ herausheben.

Nocken-Einstellschrauben des Nockenverstellers ④ (276-4005, 281-Schraube M8 ⑤ lockern und durch ein schädeliges Nachschrauben der 281-Mutter ⑥ Nockenwelle herausziehen.

Achtung: Beim Herausziehen der Nockenwelle kann es vorkommen, daß die Ausgleichschraube hinter dem WD-Ring in die Seilgengehäuse rutscht und somit das Herausziehen der Nockenwelle verhindert.

Achtung: Abnehmrichtung abnehmen, WD-Ring entfernen und Ausgleichschraube herausziehen. Nach dem die Nockenwelle ohne Schwarmgelenk mit dem Abnehmer herausgezogen werden.

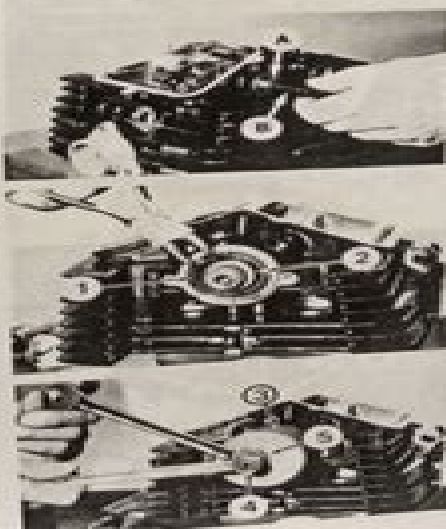
Zylinderkopf aus dem Schraubstock nehmen. Boltschrauben und Padlock entfernen.

Remove both rocker spindles ① with a screw M8 ②. Take out both rocker with one thread washer and one spring washer each. To remove the camshaft, take off lock ring ③ and remove spacer ④ (276-4005, hold after screwing in camshaft with screw ⑤ (276-4005, hold after screwing in camshaft by carefully turning hexagon nut ⑥ clockwise).

Caution: When the camshaft is extracted, the screw behind the oil seal sometimes drops into the lock ring groove thus preventing complete removal of camshaft.

Remedy: Take off extractor, remove oil seal and take out screw. Now the camshaft can be taken out with the extractor easily.

Remove cylinder head from vice, take out studs and remove down pins.



Entfernen die beiden Boltschrauben ① mit einer 8 mm Schlüssel. Entfernen die beiden Kipphebel mit je einer Anlaufschraube und einer Federschraube. Zum Auslösen der Nockenwelle (Sicherungsring) ② abschrauben und Ölwanne ③ herausheben.

Nocken-Einstellschrauben des Nockenverstellers ④ (276-4005, 281-Schraube M8 ⑤ lockern und durch ein schädeliges Nachschrauben der 281-Mutter ⑥ Nockenwelle herausziehen.

Achtung: Beim Herausziehen der Nockenwelle kann es vorkommen, daß die Ausgleichschraube hinter dem WD-Ring in die Seilgengehäuse rutscht und somit das Herausziehen der Nockenwelle verhindert.

Achtung: Abnehmrichtung abnehmen, WD-Ring entfernen und Ausgleichschraube herausziehen. Nach dem die Nockenwelle ohne Schwarmgelenk mit dem Abnehmer herausgezogen werden.

Zylinderkopf aus dem Schraubstock nehmen. Boltschrauben und Padlock entfernen.

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Remedy: Take off extractor, remove oil seal and take out screw. Now the camshaft can be taken out with the extractor easily.

Remove cylinder head from vice, take out studs and remove down pins.

Rotax 998 Manual

**British Leyland Motor Corporation of
Australia. Austin-Morris Division**

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THREE-WHEELERS PAST, PRESENT & FUTURE vol.1 Kerry Croxton, *Flyer's Guide to Ultralights* Jim Richard Campbell,1985 *AERO TRADER & CHOPPER SHOPPER, AUGUST 2002* Causey Enterprises, LLC, **Jane's All the World's Aircraft** ,2009 **Sport Aviation and the Experimenter** ,1992 **The Commercial Motor** ,1925 **Flight and Aircraft Engineer** ,1957 Flight ,1957 *Motor Sport* William Boddy,1970 The Electrical Review ,1931 Government Reports Annual Index ,1979 **Telegraphic Journal and Electrical Review** ,1931 **Mini Comprehensive Workshop Manual** ,1976 **Mini Comprehensive Workshop Manual** British Leyland Motor Corporation of Australia. Austin-Morris Division,1971 *Mini Workshop Manual* ,1976 **Mini Comprehensive Workshop Manual** British Leyland Motor Corporation of Australia. Austin-Morris Division,1971 *Mini* Leyland Motor Corporation of Australia,1975

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Table of Contents Rotax 998 Manual

1. Understanding the eBook Rotax 998 Manual
 - The Rise of Digital Reading Rotax 998 Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Rotax 998 Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Rotax 998 Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Rotax 998 Manual
 - Personalized Recommendations

- Rotax 998 Manual User Reviews and Ratings
- Rotax 998 Manual and Bestseller Lists
- 5. Accessing Rotax 998 Manual Free and Paid eBooks
 - Rotax 998 Manual Public Domain eBooks
 - Rotax 998 Manual eBook Subscription Services
 - Rotax 998 Manual Budget-Friendly Options
- 6. Navigating Rotax 998 Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Rotax 998 Manual Compatibility with Devices
 - Rotax 998 Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Rotax 998 Manual
 - Highlighting and Note-Taking Rotax 998 Manual
 - Interactive Elements Rotax 998 Manual
- 8. Staying Engaged with Rotax 998 Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Rotax 998 Manual
- 9. Balancing eBooks and Physical Books Rotax 998 Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Rotax 998 Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Rotax 998 Manual
 - Setting Reading Goals Rotax 998 Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Rotax 998 Manual
 - Fact-Checking eBook Content of Rotax 998 Manual

- Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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