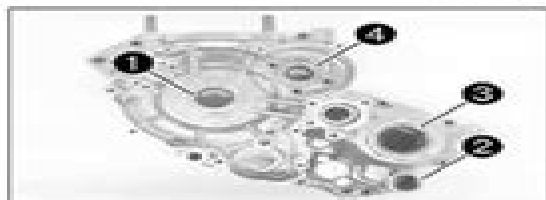




- Blow out lubrication bore 6 with compressed air and check that it is clear.

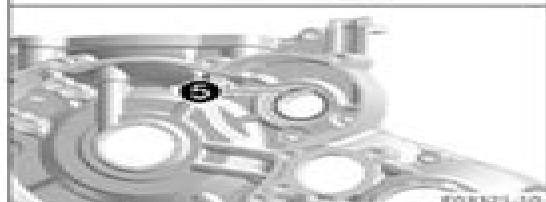


- Insert the new cold bearings in the bearing seats of the heated section of the engine case; if necessary, use a suitable mandrel to push them all the way in and make them flush.

**Info**

When pressing in, ensure that the section of the engine case lies flat in order to prevent damage.

Only press the bearings in using the outer bearing race; otherwise, the bearings will be damaged when they are pressed in.



- After the section of the engine case has cooled, check that the bearings are firmly seated.

**Info**

If the bearings are not firmly seated after cooling, it is likely that they will rotate in the engine case when warm. In this case, the engine case must be replaced.

- Press in radial shaft seal ring 1 of the crankshaft with the open side facing inward so that it is flush.
- Press in radial shaft seal ring 2 of the shift shaft so it is flush with the open side facing inward.
- Press in radial shaft seal ring 3 of the countershaft so it is flush with the open side facing in.
- Mount lock ring 5.
- Press in radial shaft seal ring 4 of the balancer shaft so it is flush with the open side facing in.

### 18.4.3 Removing the crankshaft bearing inner race



- Fixate the crankshaft in the vice with special tool 1.

**Guideline**

Use soft jaws.

Separator plate (54829009000) (CP p. 320)

- Warm up special tool 2.

**Guideline**

180 °C (356 °F)

Puller (58429037043) (CP p. 321)

- Push the warmed up special tool 2 onto the crankshaft bearing inner race, press firmly together, and pull jointly from the crankshaft.

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