

Engine 617 is balanced as a whole, i.e. the entire engine is balanced on a balancing machine.

Since this balancing operation cannot be executed in a repair shop, and as engine balance has to be retained as well as possible, it is necessary to note the following rules and measures:

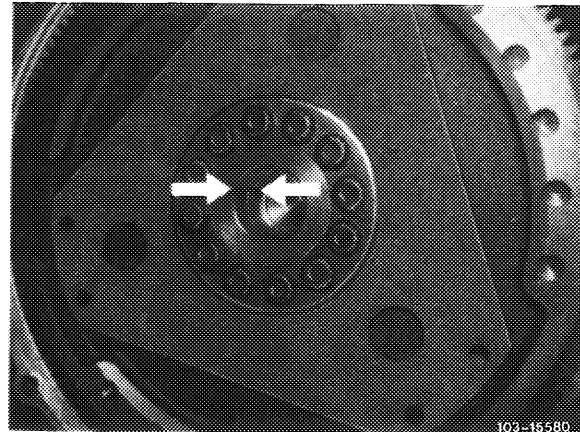
1 Replacement crankshafts are supplied without flywheels, balance plates, pulleys and vibration dampers. These parts are to be taken from the old crankshaft.

Replacement crankshafts are balanced at zero.

2 When replacing crankshaft, make sure that mark (arrow) on flange of old crankshaft is applied at identical position on new crankshaft.

3 Flywheel and balance plate must be adjusted, on replacement, to balance of old parts by means of static balancing (03-344 and 03-440).

The vibration damper must not be balanced.



4 When installing new connecting rods be sure to note weight categories. New connecting rods must always be of the same weight category as the old ones (03.313).

5 Partial engines (short blocks) are balanced as whole assemblies.