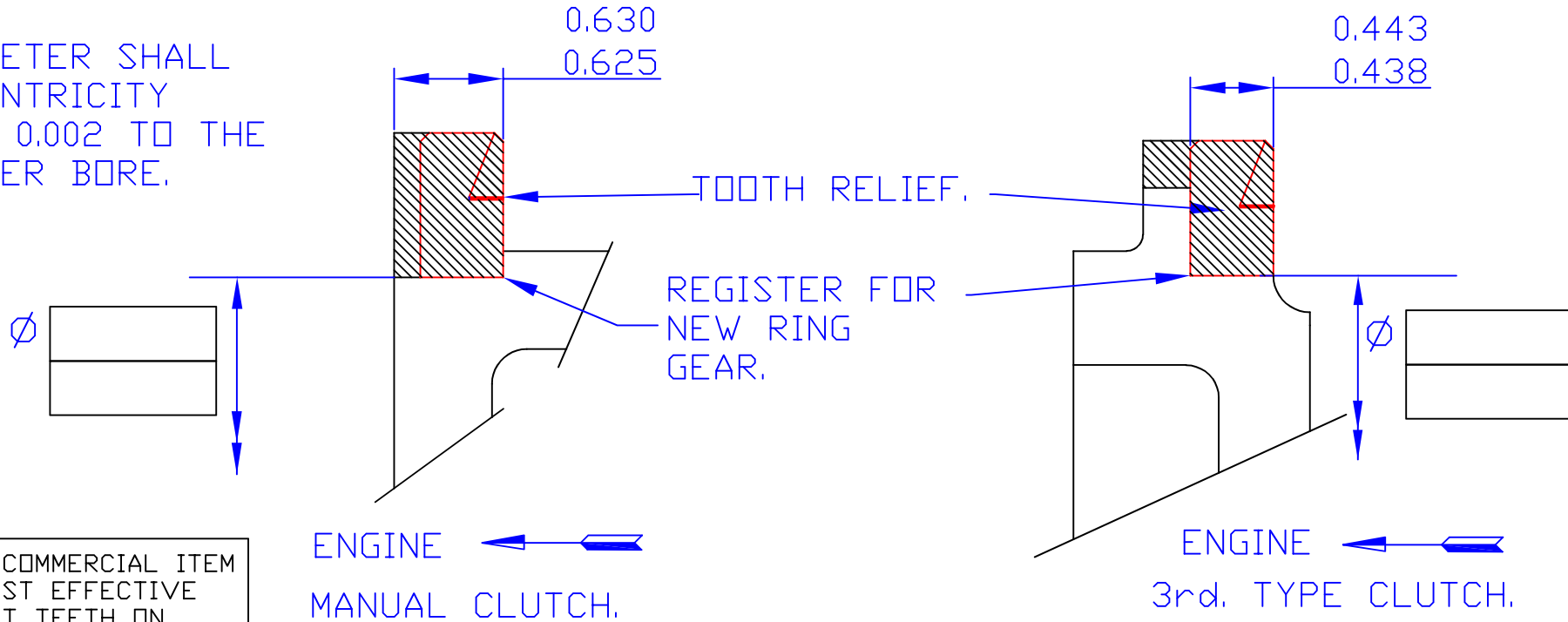


IF IN DOUBT ASK.

THIS DRAWING APPLIES SPECIFICALLY TO THE STARTER RING WITH ID. NO.:

DO NOT SCALE DRAWING.

MACHINED DIAMETER SHALL HAVE A CONCENTRICITY TOLERANCE OF 0.002 TO THE FLYWHEEL TAPER BORE.



THIS RING GEAR IS A COMMERCIAL ITEM WHICH PROVIDES A COST EFFECTIVE SOLUTION TO WORN OUT TEETH ON ORIGINAL RILEY FLYWHEELS. IT IS SLIGHTLY SMALLER IN DIAMETER THAN THE ORIGINAL, BUT THE MINOR REDUCTION IN TOOTH ENGAGEMENT DEPTH IS ACCEPTABLE.

RING GEAR FITTING INSTRUCTIONS FOR ECO37M.  
 TO FIT RING GEAR TO FLYWHEEL, MACHINE FLYWHEEL BY JUST REMOVING EXISTING RING TEETH. MACHINE TO DIAMETER SHOWN FOR THE DEPTH SHOWN FROM EDGE OF EXISTING TEETH. SEE DIAGRAMS-HATCHED AREA IS METAL REMOVED. HEAT STARTER RING GEAR AND PLACE ON FLYWHEEL WITH TOOTH RELIEF TO REAR.(ie. AWAY FROM ENGINE)

PLEASE OBSERVE APPLICABLE HEALTH & SAFETY INSTRUCTIONS. WARNING:-THE HEATED STARTER RING WILL CAUSE SERIOUS BURNS. USE CORRECT PROTECTIVE EQUIPMENT.

A COPY OF THIS SHEET TO BE INCLUDED WITH EACH RING GEAR SOLD. \*

ISS	BY	DATE	CHANGE	APR
		24/03/20	SHEET FORMAT FOR RING SPECIFIC FLYWHEEL MACHINING DIMENSIONS. TO BE COMPLETED FOR ISSUE WITH RING AT TIME OF SALE.	ND

<p>© 2020 RILEY REGISTER SPARES LTD.</p>	DRAWN TO BS 308. LIMITS OF SIZE ARE WITH DEPENDENCY OF SIZE & FORM EXCEPT WHERE GEOMETRIC TOLERANCE IS APPLIED.	UNSPECIFIED TOLERANCES +/- 0.010	DRAWN. W.R.T. 24/03/20 DATE. 24/03/20	MATERIAL:-	TITLE FITTING INSTRUCTIONS FOR REPLACEMENT STARTER RING GEAR 9HP (RING SPECIFIC MACHINING DIMENSIONS)	PART NO. ECO37M
		ALL DIMENSIONS ARE IN INCHES	APPROVED. N. DOWDING			
			PROJECTION 3RD ANGLE SCALE:- N.T.S.			
				SHEET 2 OF 2		
				ISSUE BASED ON 2		