

**Starter gear - electric starter, magneto side, on engine 582 UL****Instructions for checking of starter gear**

- 1) Remove the complete electric starter with starter gear from the engine.
- 2) Check the starter gear (pos. 2) visually for cracks with a magnifying lens (approx. 5-fold magnifying). Replace if cracks are found.
- 3) Check wall thickness (pos. 7) of starter gear in the area as shown on the illustration (in approx. 10 mm distance from the inner diameter). Exchange gears with less than 3,8 mm thickness.
- 4) Check chamfer $0,5 \times 45^\circ$ (pos. 8). 0,5 mm is important to allow full contact with starter gear adapter. Rework if necessary.
- 5) Check starter gear adapter (pos. 1) to have the 3 supports (pos. 9). If old version without these supports, please exchange adapter.
- 6) Refit the starter gear, applying LOCTITE 648 (pos. 6) between starter gear adapter (pos. 1) and starter gear (pos. 2), and fix it with 3 each shims 250 311 (pos. 3), lock washers (pos. 4) and hex. screws M8 (pos. 5). Tightening torque 22 Nm.
- 7) Fit the remaining electric starter parts.

Note: These works should be done by experienced persons.

