



This starter has the solenoid coupled in the front-end housing, making it a little more difficult to replace the starter drive. We prepared a step-by-step procedure on how to make this replacement.

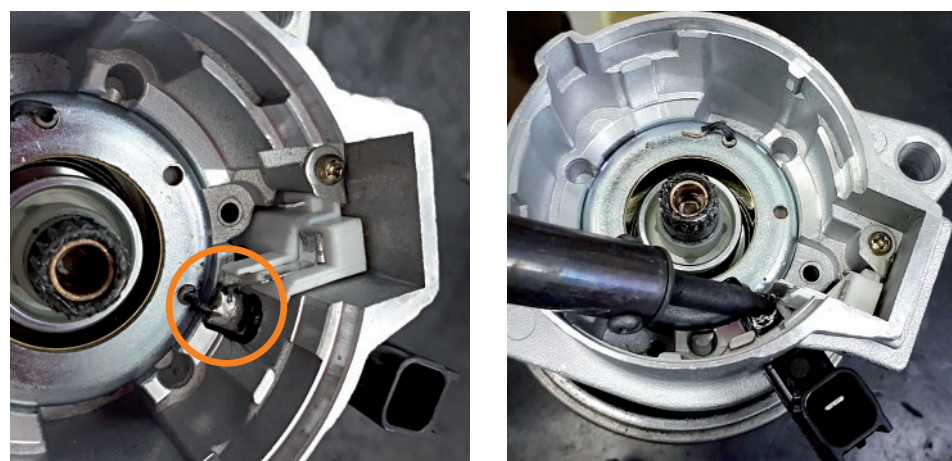
1. Remove the screws on the rear-end housing

Important: there are two types of closure: one with external screws and another with a screw in the center of the housing.



2. Remove the armature

When removing the armature, you will see that there is a connection between the solenoid and the 'S' terminal, which is realized through tinning. Therefore, it is necessary to remove this tinning in order to remove the solenoid.



3. Remove the components of the 'S' terminal

Check if the components of the "S" terminal will not make it harder to remove the solenoid. If so, remove them.



4. Remove the solenoid

Now remove the solenoid to replace the starter drive. To do so, it will be necessary to use the hydraulic press, since there is interference between the solenoid and the drive-end bearing. For this removal a chock is used on the starter drive to apply force and remove the solenoid.



5. Put the solenoid back

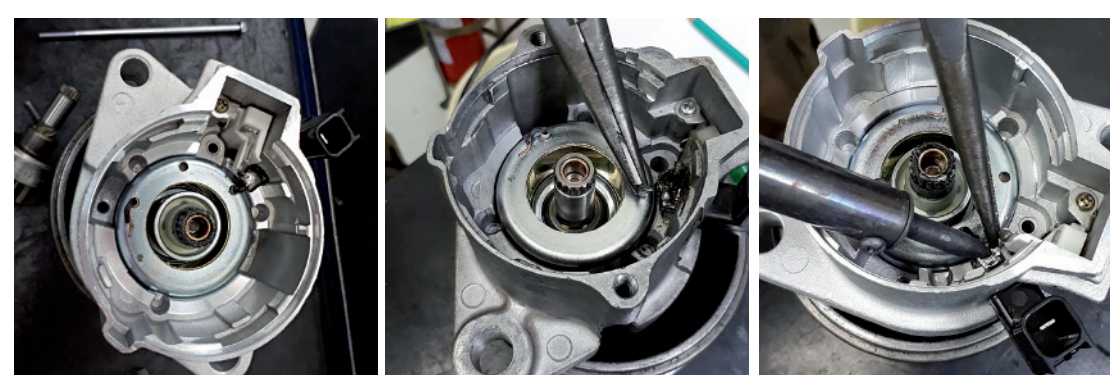
After replacing the broken starter drive, the solenoid should be secured to the drive-end housing again, using a chock to "push" it evenly until there is a clearance of 0.5 mm in the starter drive. It is important



to check that the 'S' terminal connector is close to the attachment point, otherwise the connection will not be possible.

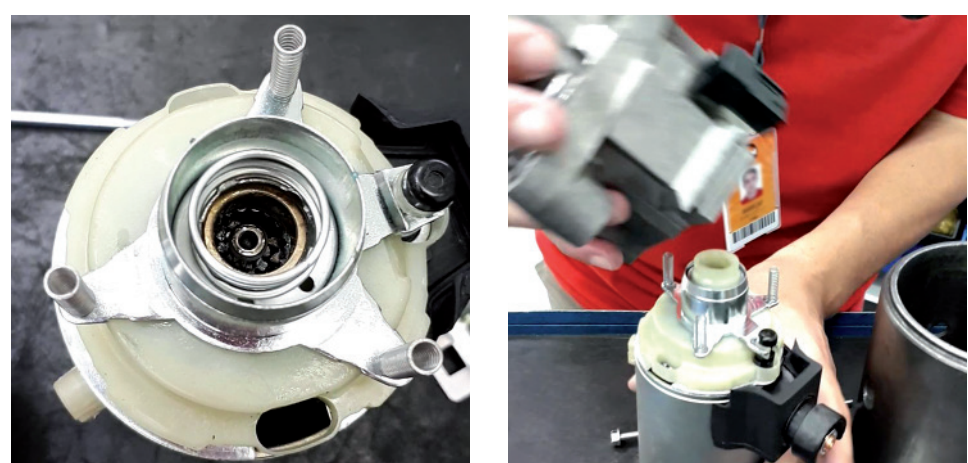
6. Relocate the components in the terminal 'S'

Now put the components in the "S" terminal (in case you removed them) and make the terminal 'S' connection again with the tinning.



7. Close the housing

Close the housing upside down, so that the coils inserted in the fork terminal do not move.



8. Conduct a bench test

Close the starter motor through the stud bolts. Once the starter is assembled, conduct the bench test to verify if the 'S' terminal is OK and if it does not present any abnormal noise.

Done! Now you have replaced the starter drive and have a product of quality and durability inside the vehicle.