01 Crankcase and cylinder head

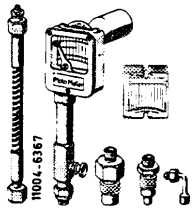
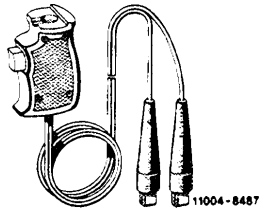
	Job No.
Engine	
Checking compression pressure.	01–010
Checking cylinder for leaks	015
Evaluating cylinder bores	020
Removal and installation of engine (oil capacity)	030
Crankcase breather	
Operation	040
A. Standard version and (USA) Federal starting 1984	
8. (USA) California starting 1984	
Cylinder crankcase	
Measuring cylinder bores	110
Renewing, boring and honing cylinder liners	115
Facing cylinder crankcase parting surface	120
Knocking out and inserting steel balls in main oil duct	130
Replacing core hole closing cover in cylinder crankcase	140
Timing housing cover and cylinder crankcase cover	
Removal and installation of timing housing cover	210
Removal and installation of end cover	222
Oil pan	
Removal and installation of oil pan	310
Cylinder head	
Cylinder head bolts and tightening cylinder head bolts	405
Removal and installation of cylinder head	415
Removal and installation of prechambers	417
Facing cylinder head parting surface	418
Pressure-testing cylinder head	420

01-010 Checking compression pressure

Test values with engine at operating temperature in bar gauge pressure	
Compression pressure, normal	24-30
Minimum compression pressure	approx. 15
Permissible difference between individual cylinders	max. 3

Tightening torques	Nm
Coupling nuts of injection lines (reference value)	1 O-20
Injection nozzles in prechambers	70 + 10

Special tools

Compression pressure recorder with accessories	 11004-6367	001 5894721 00
Contact handle for rotating engine (component of compression pressure recorder 001 589 46 21 00)	 11004-8487	001 5894621 08
Box end wrench element, open, 14 mm, 1/4" drive, for coupling nut of injection line	 11004-10520	000 589 770300

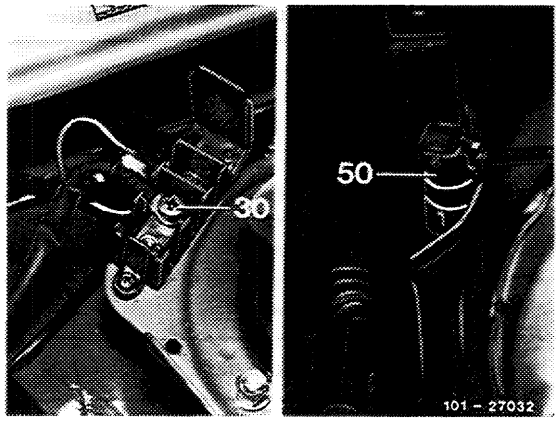
Note

Check compression pressure at 80 °C coolant temperature. Compression pressure can be checked only via prechambers. If minimum compression pressure is less than specified, check cylinders for leaks (01–015).

Checking

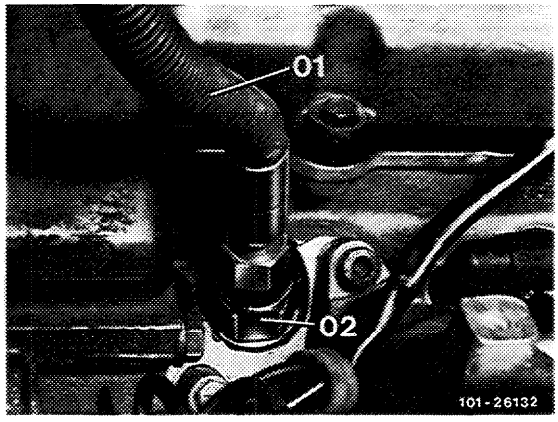
1 Remove injection nozzles (07-230).

2 Connect contact handle for rotating engine to cable connector, terminal 30 and 50, on fire wall.



3 Rotate engine several times with transmission in idle position, so that residue and soot are thrown out.

Attention!
While rotating engine, push stop lever downwards by means of an extension, so that the injection pump is not injecting.



Compression pressure recorder, connected to prechamber

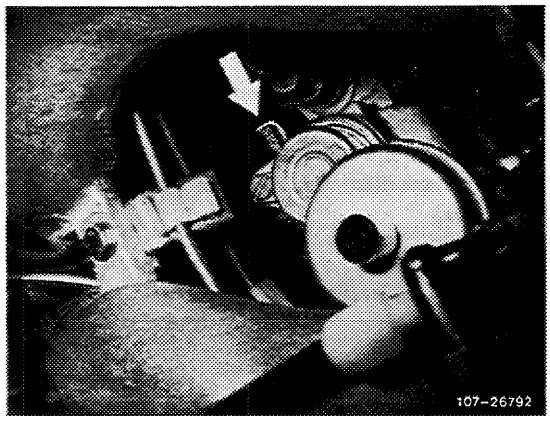
01 Compression pressure recorder
02 Connection

4 Screw adapter (component of compression pressure recorder) into prechamber. Connect compression pressure recorder.

5 Rotate engine 8 times for checking engine.

Attention!
While rotating engine, push stop lever downwards by means of an extension, so that the injection pump is not injecting.

6 Install new nozzle reeds prior to installing injection nozzle.



01-015 Checking cylinders for leaks

Data

Total pressure loss	max. 25 %
On valves and cylinder head gasket	max. 10 %
On pistons and piston rings	max. 20 %

Tightening torques	Nm
Coupling nuts of injection lines (reference value)	**1 O-20**
Injection nozzles in prechambers	70+10

Conventional tools

Cylinder leak tester	e.g. Bosch, EFAW 210 A SUN, CLT 228
Couplings or connections	e.g. Bosch order no. 1 687 010 016

Checking

1 Run engine up to operating temperature.

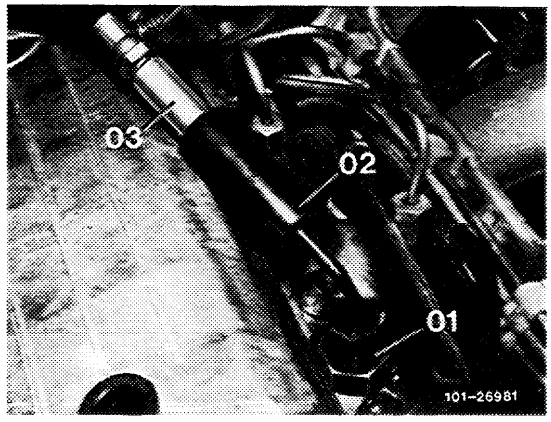
2 Remove injection nozzles (07-230).

3 Remove air cleaner cover.

4 Remove oil filler cap.

5 Remove radiator closing cap and fill up with coolant.

6 Screw adapter (01) and angle piece (02) into prechamber of 1 st cylinder.



01 Connection
02 Angle piece
03 Connecting hose

7 Set piston of 1st cylinder to ignition TDC.

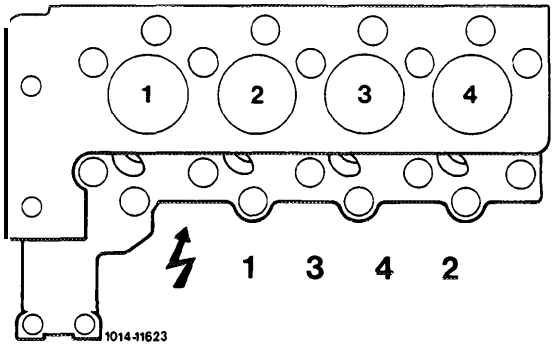
8 Connect cylinder leak tester to a compressed air system, calibrate tester.

9 Screw connecting hose (03) of tester to screw-in member. Make sure that crankshaft is not rotating **while screwing in hose.**

10 Read pressure loss on tester.

11 Check by listening whether the pressure escapes via intake manifold, exhaust, oil filler cap, pre-chamber of adjacent cylinder or radiator cap.

12 Check all cylinders in ignition sequence.



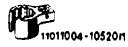
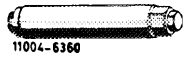
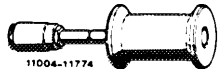
Note: There is a possibility that the piston ring gaps of the individual pistons are directly one above the other, so that the test result will be misrepresented.

When in doubt, continue running vehicle and check cylinders for leaks once again later on.

01-020 Evaluating cylinder bores

Tightening torques	Nm
Coupling nuts for injection lines (reference value)	1 O-20
Hex. head bolt for cylinder head cover	10
Threaded ring for prechamber in cylinder head	100 ± 10
Injection nozzle in prechamber	70 + 10

Special tools

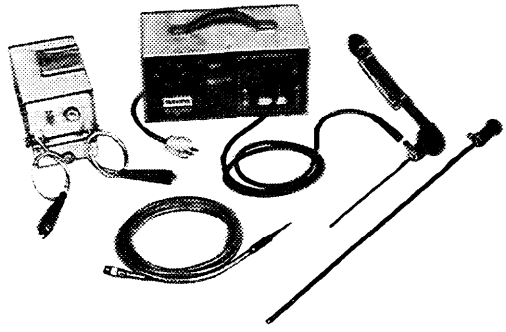
Box end wrench element, open, 14 mm, 1/4" drive, for coupling nut of injection line	 11011004-10520n	000 589 77 03 00
Wrench element for threaded ring of prechamber	 11004-6360	615589000700
Impact puller for prechamber	 11004-11774	601 589 06 33 00

Conventional tool

Cylinder illuminating lamp	e.g. Karl Storz GmbH, D-7200 Tuttlingen Motoskop TW (cold light) with lens probes 103 26 CW (570 mm) and 103 26 CT (210 mm)

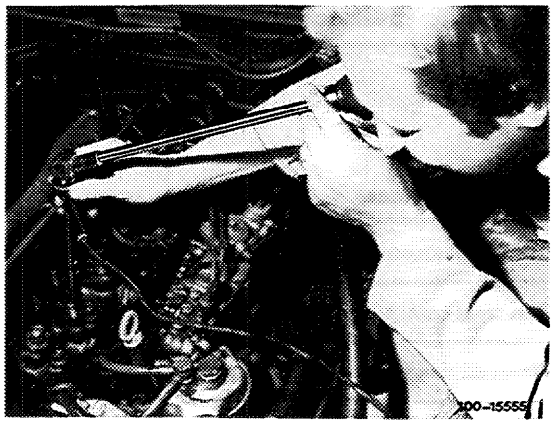
Note

The visual checkup can be made by means of a cylinder illuminating lamp with cylinder head mounted. Remove prechambers for this purpose (01-417).



103-15713

When evaluating scored or streaky cylinder running surfaces, it is often hard for workshop to decide whether the damage is already significant and requires removal or repair of engine, or whether the marks are insignificant. The following information will help to make an expert and correct decision.

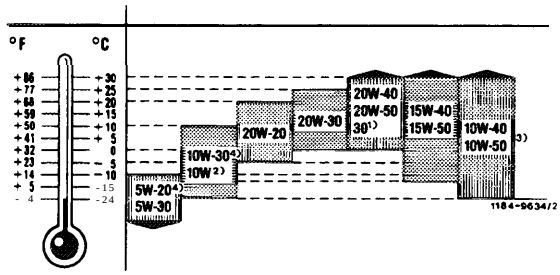


The first difference on cylinder running surfaces is between “optical streaks” and “seizure streaks”. In most cases, “optical streaks” are about 3 mm wide and are caused by ring gap, on which honing traces are still visible; with “seizure streaks”, however, the honing traces are no longer seen.

With “streaks in direction of land” (in direction of piston pin) shaft streaks or seizures are not possible, since there is no contact between piston skirt and cylinder liner.

01-030 Removal and installation of engine (oil capacity)

Specified viscosity classes according to SAE during lasting ambient temperatures



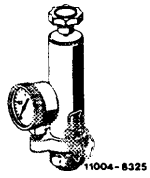
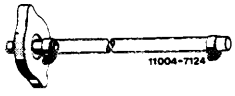
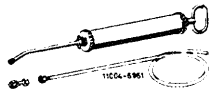
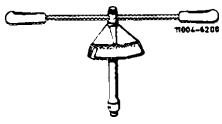
1) SAE 40 may be used during lasting outside temperatures above + 30 °C (+ 86 °F).
2) Do not use.
3) All-season oil.
4) For oils identified on sheets 226.1 and 227.1 of Specifications for service products with footnote 1), the following applies:
SAE 5 W-20 below + 10 °C
SAE 10 W-30 in temperate zones all seasons

Oil capacity in liters (for approved engine oils refer to Specifications for service products)

Engine (total filling capacity during complete refill)	7.3

Tightening torques	N m
Oil drain plug to oil pan	25
Nuts for oil filter cover	20-25
Screws for engine carrier on engine mount, front	35 + 10

Special tools

Tester for cooling system and radiator cap		001 589 48 21 00
Radiator cap with hose for leak test		605 589 00 25 00
Syringe for removing oil		112589007200
Torque wrench, double-arm, 3/8" square, 8-32 Nm		001 589 51 21 00
Torque wrench, single-arm, emitting signal with plug-in ratchet, 1/2" square, 25-130 Nm		001 589 66 21 00

Conventional tools

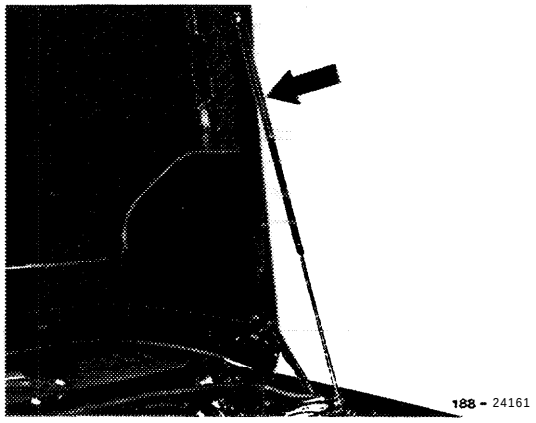
Socket wrench 7 mm on flexible shaft for hose clamps with worm drive	e.g. Hazet, D-5630 Remscheid order no. 426-7
Engine hoist no. 3180	e.g. Backer, D-5630 Remscheid, Herderstraße

Note

Remove and install engine with transmission.

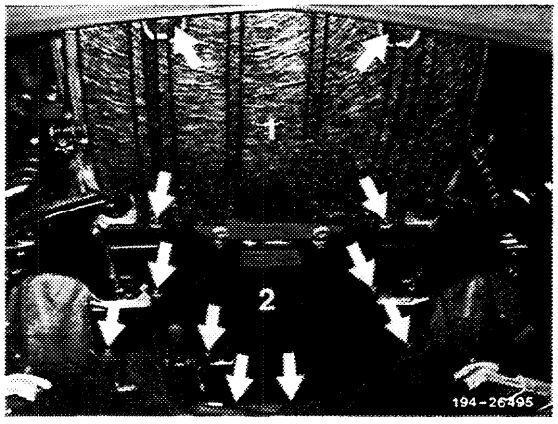
Removal

1 Put engine hood in vertical position.
For this purpose, the engine hood can be set vertically (90°) by simply pushing hood up, In vertical position, the engine hood is secured by means of a detent lever.

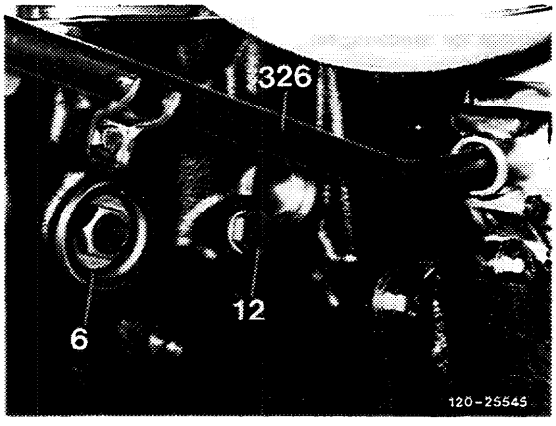


Engine hood in vertical position

2 Completely remove noise capsule below. For this purpose, unscrew sheet-metal screws (arrows).

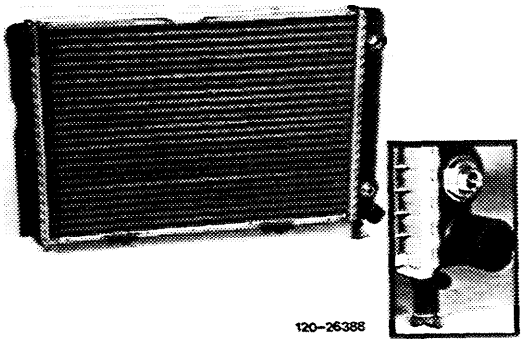


3 Completely drain coolant (20–010).



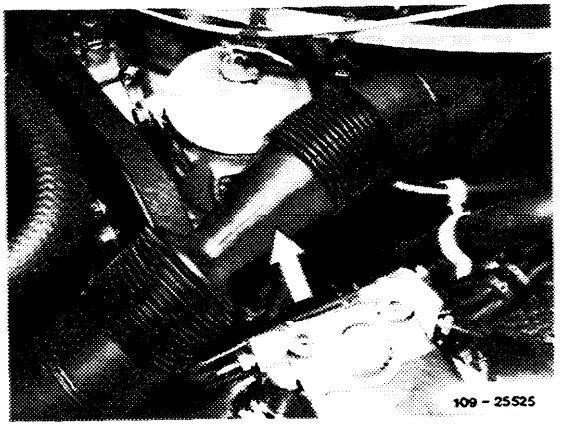
12 Drain plug of cylinder crankcase

To facilitate collection of coolant, plug an extension hose to drain connection of radiator.

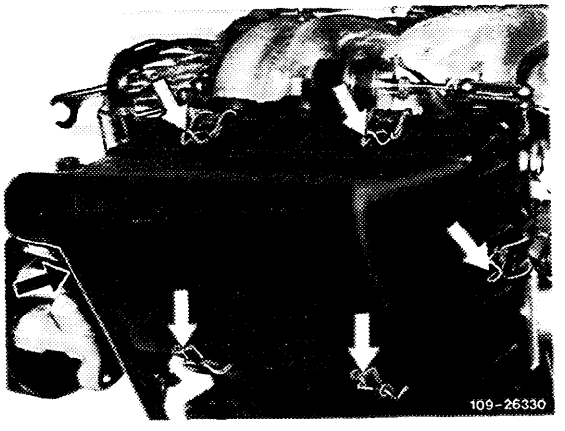


Drain plug on radiator

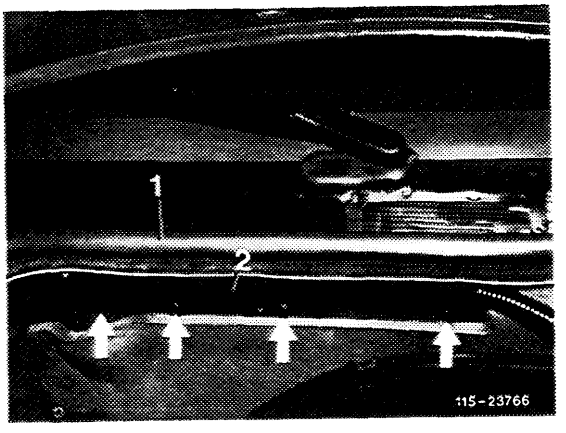
4 Remove air hose (arrow).



5 Remove air cleaner cover (arrows).

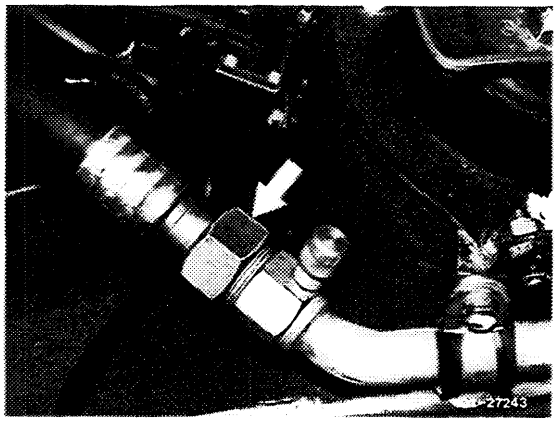


6 Disconnect battery positive line. For this purpose, pull off rubber strip (1) above bulkhead. Remove clips (arrows). Swivel holder (2) in upward direction and place battery positive cable over engine.

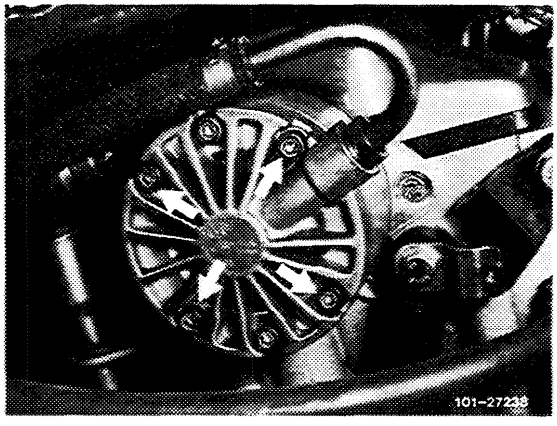


7 Remove radiator (20-420).

8 On vehicles with air-conditioning system, drain system (83–516), disconnect refrigerant hoses (arrow) and close free ends of refrigerant hoses with plastic plugs.

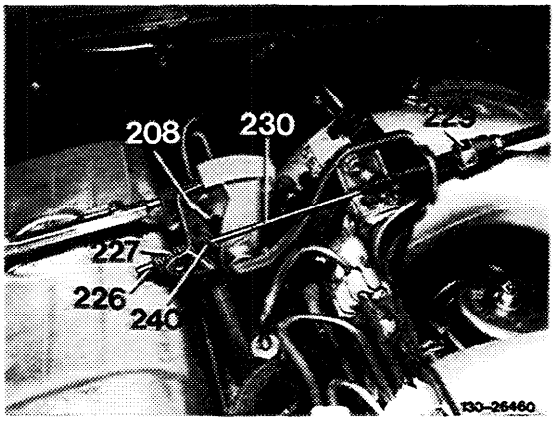


9 On vehicles with level control, unscrew hex. socket screws (arrows) and put pressure oil pump with connected lines aside. Remove driver.



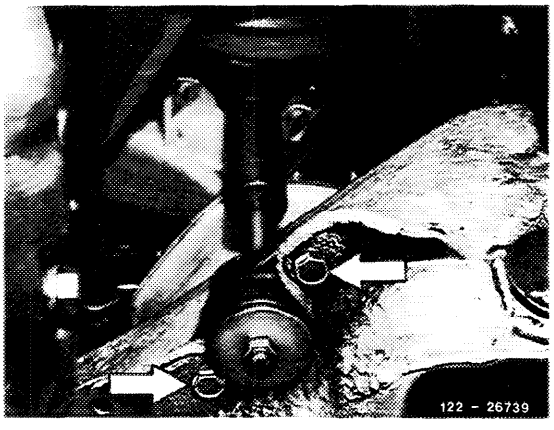
10 Draw oil from reservoir of power steering pump with syringe for oil removal and disconnect hoses.

11 Disconnect bowden wire (230) while pushing out slotted guide piece (240) on angle lever and remove bowden wire.

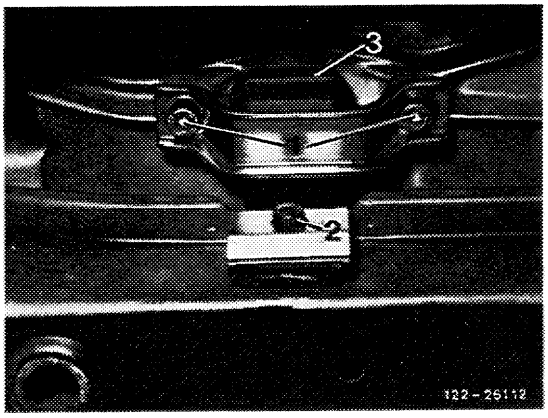


12 Disconnect all coolant, vacuum, oil, fuel and electric lines leading toward engine.

13 Unscrew engine shock absorber on cross member, while unscrewing fastening screws (arrows) for this purpose.



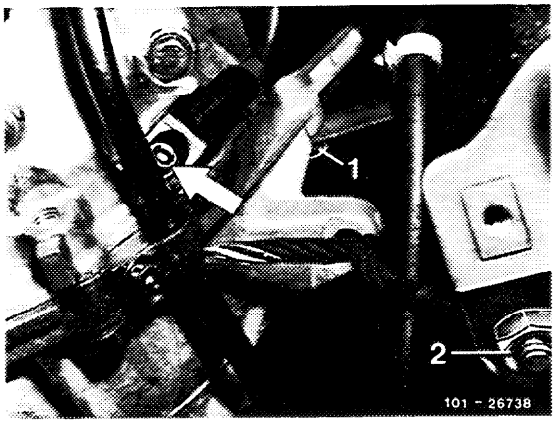
14 **Remove engine stop. For this purpose, unscrew adjusting screw (2) as well as hex. head screws (1) and remove engine stop with holder.**



15 Remove the lower of the two starter fastening screws (1) and put holder with tachometer shaft aside. Disconnect ground connecting line (2).

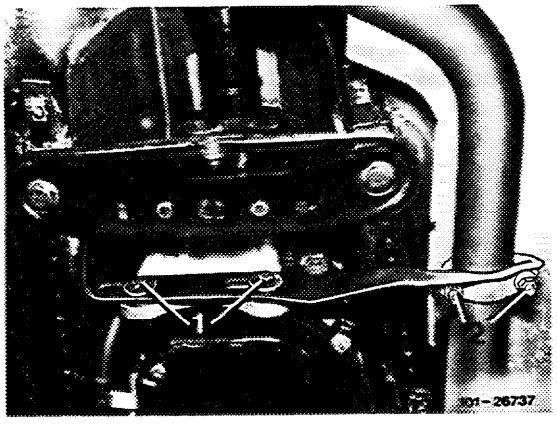
On vehicles with rpm sensor, unscrew line on oil pan (arrow).

16 Unscrew exhaust system on flange of exhaust manifold.



17 Unscrew fastening screws for exhaust lateral support (1), loosen nuts (2) and swivel holder in downward direction.

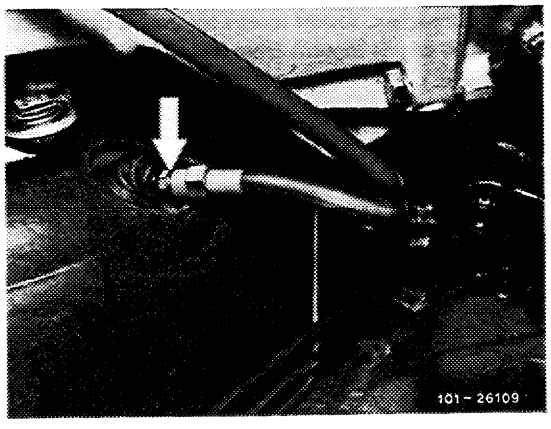
18 Unscrew propeller shaft on transmission, loosen nut of slide piece as well as fastening screws for propeller shaft intermediate bearing and slide propeller shaft back as far as possible. Also unscrew heat guide plate on vehicle floor.



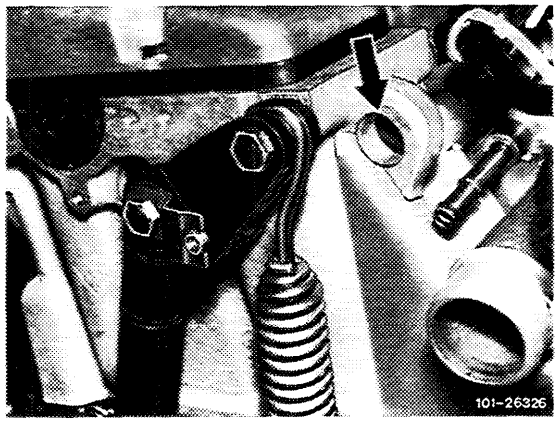
19 Unscrew drive shaft for tachometer on rear transmission cover.

20 Separate oil line from clutch master cylinder to slave cylinder (arrow).

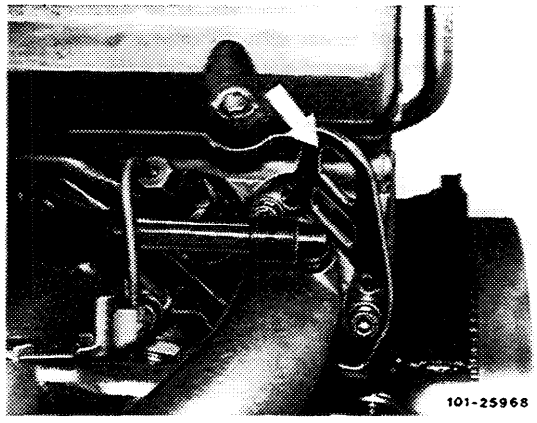
21 Remove shift rods from transmission shift levers while removing clip locks for this purpose.



22 Engage ropes of engine hoist on suspension eyes of engine (arrows). Tighten ropes.

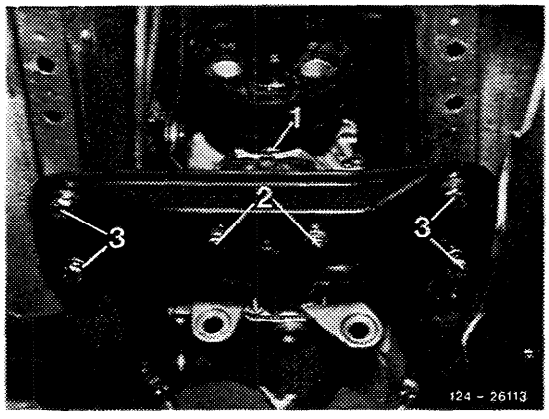


Suspension eye front



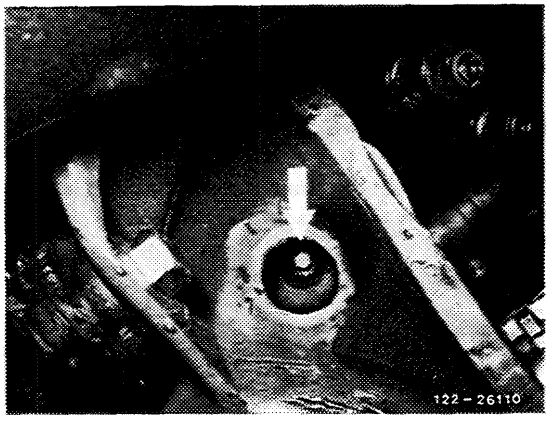
Suspension eye rear

23 Remove rear engine carrier with engine mount. For this purpose, unscrew hex. nut (1) and screw out hex. head screws (3).

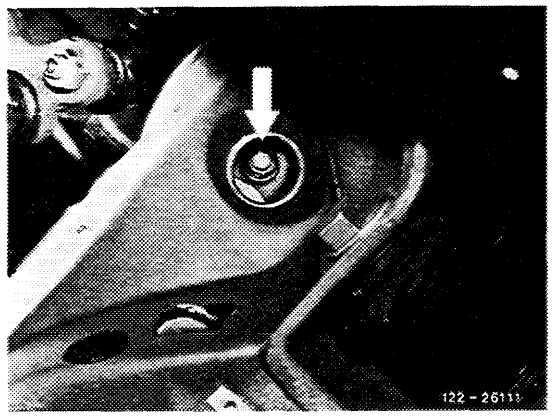


Rear engine carrier
shown on S-speed transmission

24 Unscrew hex. socket screws for engine carrier on both front engine mounts from below (arrow).



Hex. socket screw for engine carrier left



Hex. socket screw for engine mount right

25 Lift out engine with transmission in diagonal position of approx. 45".

Installation

26 Check engine mounts, engine shock absorbers, oil and fuel hoses and renew, if required.

27 Prior to flanging on manual transmission, check condition of radial ball bearing in crankshaft and of throw-out bearing of clutch; renew, if required.

28 To install engine, reverse removal procedure. Pay attention to specified torques of fastening screws and nuts.

Check installation position of shielding plates on engine mounts.

29 Screw on propeller shaft and adjust (41–020).

30 Adjust engine stop (22–220).

31 Check oil level in engine and transmission and correct, if required.

32 On vehicles with air conditioning, fill system (83–514).

33 Check all drain plugs for specified tightening torque.

34 Clean air cleaner element and renew, if required.

35 Check for leaks with engine running.

A. Standard version and (USA) Federal starting 1984

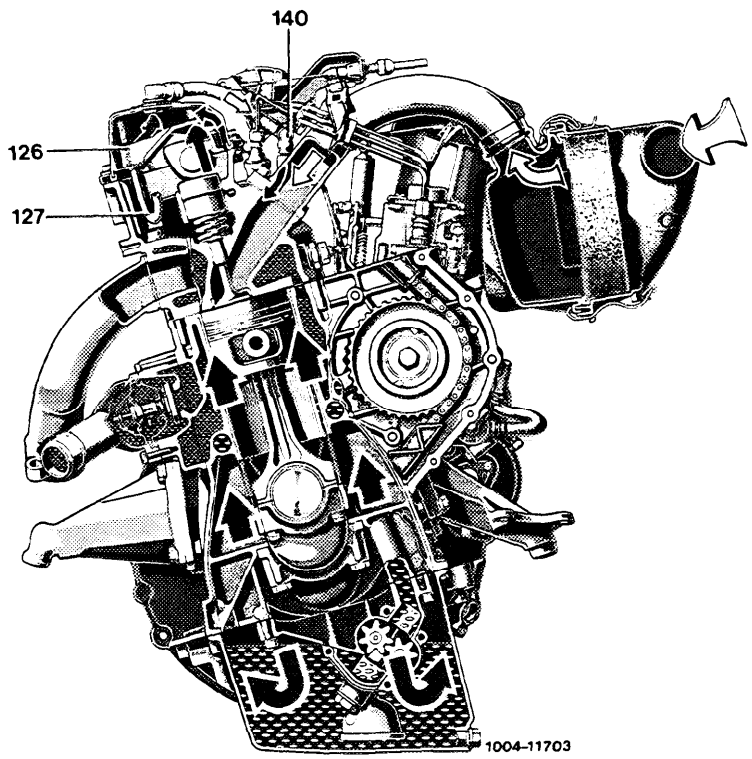
Engine601.911

The closed engine breather requires no service.

Depending on intake manifold vacuum, the engine blow-by gases are flowing through oil separator (126) in cylinder head cover and a hose line to distributing pipe (140) on intake manifold.

From here they are uniformly distributed to all the cylinders and fed to the combustion chambers together with the intake air.

The oil separated in oil separator (126) flows back to cylinder head through return pipe (127).



126 Oil separator
127 Return pipe
140 Distributing pipe
⇦ Fresh air
⇦ Blow-by gases

B. (USA) California starting 1984

Engine 601.921

Engine breather

The closed engine breather requires no service.

Operation

Depending on intake manifold vacuum, the engine blow-by gases are flowing through oil separator (126) in cylinder head cover and a hose line to distributing pipe (140) on intake manifold.

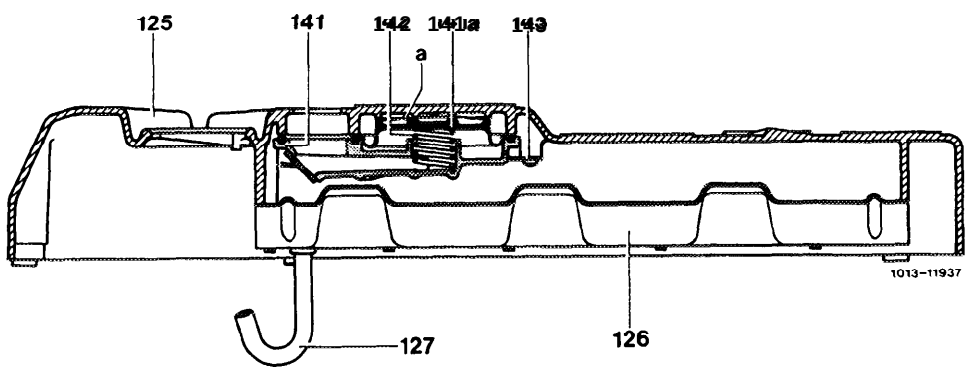
From here they are uniformly distributed to all the cylinders and fed to the combustion chambers together with the intake air.

The oil separated in oil separator (126) flows back to cylinder head through return pipe (127).

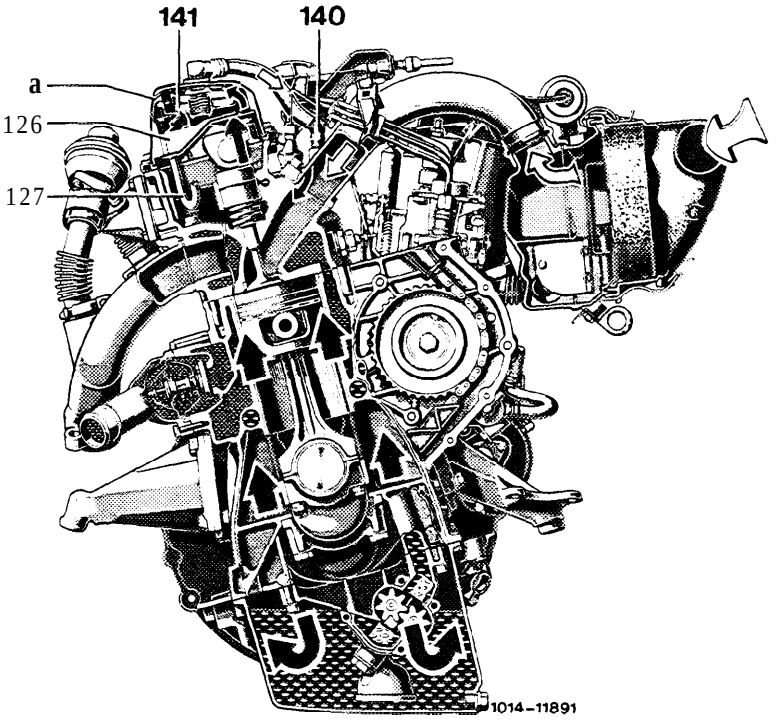
Since on engine in California version the vacuums are considerably higher under influence of throttle valve in intake system, the oil separator (126) is provided with a pressure control valve (141, diagram valve).

The valve prevents an excessive vacuum in cylinder crankcase and the resultant loss of oil (suction).

To vent diaphragm chamber in pressure control valve, the cylinder head cover is provided with a bore (a). Make sure that this bore is not closed or will not be closed by dirt or preservation compound.



125 Cylinder head cover
126 Oil separator
127 Return pipe
141 Diaphragm housing (pressure control valve)
141a Diaphragm
142 Spring
143 Holder
a Vent bore



126 Oil separator
127 Return pipe
140 Distributing pipe
141 Pressure control valve
a Bore 3 mm dia.

⇦ Fresh air
⇦ Blow-by gases

01-I 10 Measuring cylinder bores

Data

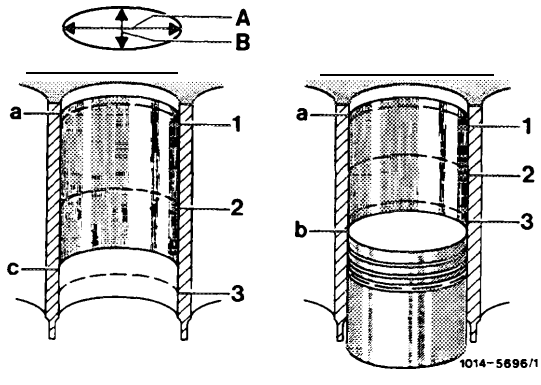
Engine[1]			601	
Version		Group Code letter	Piston dia.	Cylinder dia.
Std (standard)	Cylinder 1-4	A	86.970-86.976	87 .OOO-87.006
		X	above 86.975-86.983	above 87.006-87.012
		8	above 86.982-86.988	above 87.012–87.018
Max. wear limit in driving or transverse direction				0.10
Permissible out-of-round and conicity			when new	0.014
			wear limit	0.05
Permissible deviation, vertically in relation to crankshaft axis, with reference to cylinder height				0.05
Permissible roughness (ℜ 3 Z)				0.003-0.006
Permissible waviness				50 % of roughness

[1]) There are no repair stages for these engines.

Measu ri ng

Measure the cleaned cylinder bores with an internal measuring instrument at measuring points 1, 2 and 3 in longitudinal direction A (piston pin axis) and in transverse direction 8.

With piston installed the measuring point 3 is barely above piston, which should be at BDC.



A Longitudinal direction
B Transverse direction
a Upper reversing point of 1st piston ring
b BDC of piston
c Lower reversing point of oil scraper ring

01-I 15 Renewing, boring and honing cylinder liners

Data

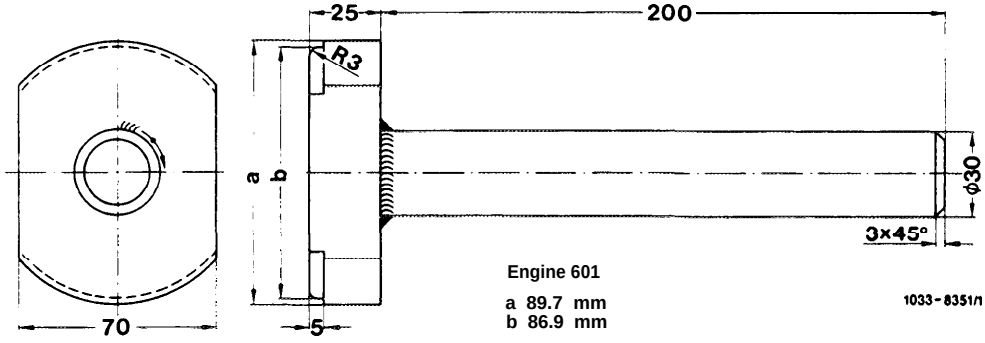
Engine')			601	
Version		Group Code letter	Piston dia.	Cylinder dia.
Std (standard)	Cylinder I - 4	A	86.980-86.976	87.000-87.006
		X	above 86.975-86.983	above 87.006-87.012
		B	above 86.982-86.988	above 87.012-87.018

Basic bore in cylinder crankcase for cylinder liner	90.000 90.035
Permissible out-of-round of basic bore in cylinder crankcase	0.01
Permissible out-of-round and conicity of cylinder bore	0.01
Permissible roughness of cylinder bore (R 3 Z)	0.003-0.006
Permissible waviness of cylinder bore	50 % of roughness
Honing angle	25"
Roughness of cylinder crankcase parting surface	0.006-0.016
Chamfer of cylinder bores	refer to Fig.

[1]) There are no repair stages for these engines,

Self-made tool

Mandrel for pressing out or knocking out cylinder liners



Note

Only approved cylinder liners may be installed on principle (refer to replacement parts data).

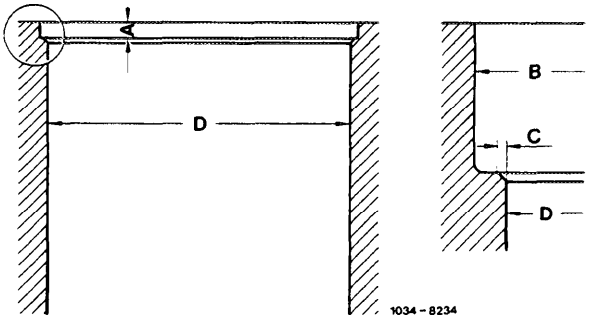
Renewing

1 Press out cylinder liners with self-made mandrel and a press or knock out with a hammer.

2 Thoroughly clean basic bore.

3 Measure basic bore (D) in cylinder crankcase.

When boundary dimensions (refer to Table) are exceeded, do no longer use cylinder crankcase.



A 4.3-4.6 mm
B 92.65-92.75 mm
C 0.25-0.35 mm
D 90.00-90.035 mm

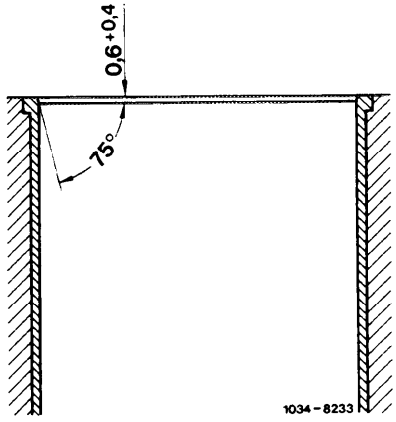
4 Position new cylinder liners. Place a steel plate of pertinent size on liner flange and press in bushing by means of a press or knock in by meanf of a hammer.

After pressing or knocking in, leave cylinder liner for an additional 7 seconds under press pressure (settling pressure) or apply a few settling blows with hammer.

5 **Mill off or grind off the projecting flange of bushing. Remove as little as possible from cylinder crankcase parting surface. Guide milling cutter or grinding wheel centrally over cylinder bores.**

6 **Enlarge (bore) cylinder liners in two steps. For honing, leave an allowance of 0.03 mm in bores.**

7 **Chamfer cylinder liners.**



8 **Hone cylinder bores.**

9 **Measure cylinder bores and select matching pistons (01-I 10).**

01-120 Facing cylinder crankcase parting surface

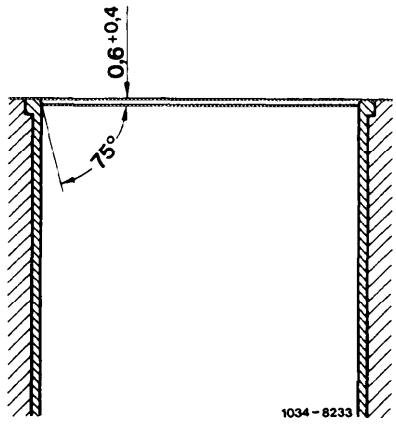
Data		
Height of cylinder crankcase when new		300-299.95
Minimum height following a required material removal		
Permissible unevenness of parting surface	in longitudinal direction	0.10
	in transverse direction	0.05
Permissible roughness of upper parting surface		0.006-0.016
Permissible deviation from parallel between upper and lower crankcase parting surface in longitudinal direction		0.1
Pressing off pressure with air under water in bar gauge pressure		1.5
Chamfer of cylinder bores		refer to Note
Distance between piston crown and cylinder crankcase parting surface	engine 601.911	+ 0.65 to + 1.05
	engine 601.921	+ 0.50 to + 0.90

Note

Prior to facing, check piston standout (projection). Do not exceed piston standout of 0.9 or 1.05 mm (03–316).

Chamfer cylinder bores after facing.

Check timing, if cylinder crankcase parting surface has been refinished (05–215).



01-130 Knocking out and inserting steel balls in main oil duct

Special tool

Knocking-in mandrel for steel ball	 11004-11746	601 589 08 15 00

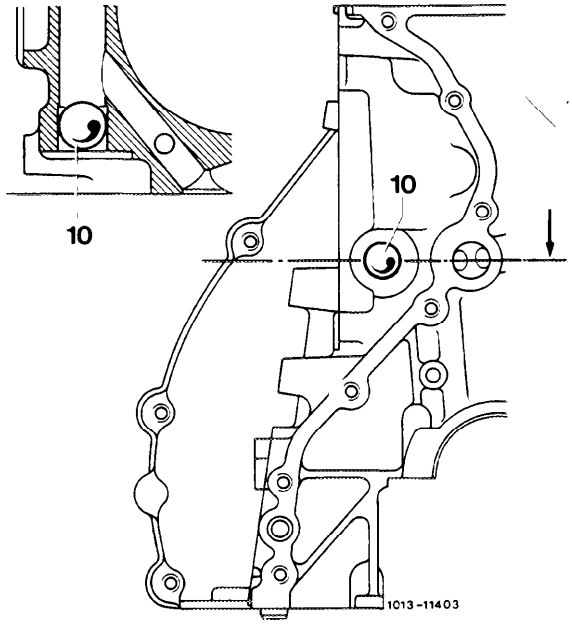
Note

The main oil duct is closed with steel balls, 17 mm dia. at the front, 15 mm dia. at the rear.

When reconditioning engine, the steel balls must be knocked out from the rear for cleaning main oil ducts.

Undamaged steel balls can be used several times without refinishing of ball seat.

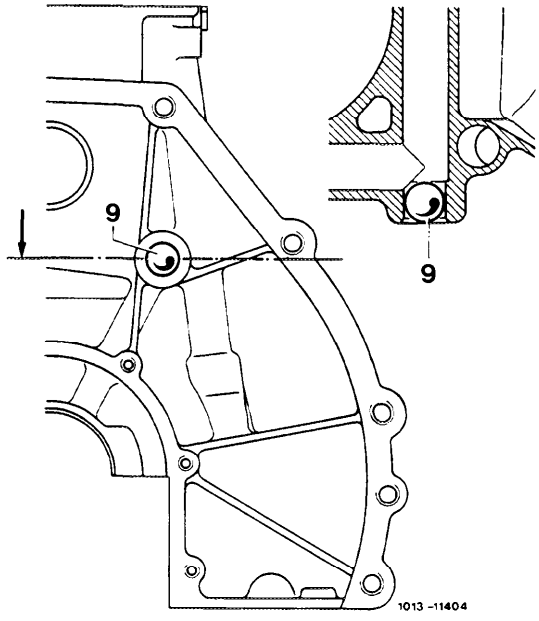
Renew damaged steel balls.



10 Steel ball, front

In the event of leaks, reseat steel balls in cylinder crankcase with a knocking-in mandrel for approx. 1 mm (dimension is indicated on knocking-in mandrel).

If the leaks are still not yet repaired, knock out both steel balls and close the respective main oil duct end with closing plug (front) M 18 x 1.5, part no. 000906 018000 or (rear) M 16 x 1.5, part no. 000906 0 16002.



9 Steel bail, rear

For this purpose, cut threads M 18 x 1.5, 10 mm deep, at main duct front. Thoroughly remove chips from oil ducts.

Coat closing plug M 18 x 1.5 with sealing glue Loctite 241, part no. 002 989 94 71 and screw in.

Cut threads M 16 x 1.5 mm approx. 14 mm deep into main oil duct on main oil duct rear.

Thoroughly remove chips from oil duct.

Coat closing plug M 16 x 1.5 with sealing glue Loctite 241, part no. 002 989 94 71 and screw in.

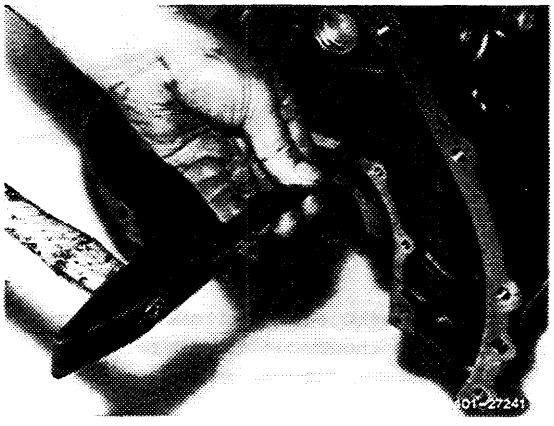
Main oil duct front and rear

Knocking out

1 Remove coolant pump with housing (20–230).

2 Remove transmission and flywheel (03-410).

3 Knock out both steel balls from the rear to the front by means of a round steel bar (approx. 14 mm and approx. 550 mm long).



Knocking in

4 Thoroughly clean bore in pressing in range of steel ball.

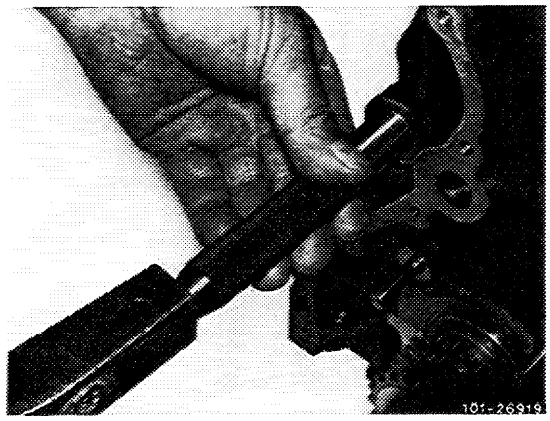
5 Coat spherical indentation on knocking-in mandrel with grease and place steel ball into indentation.

103-13405

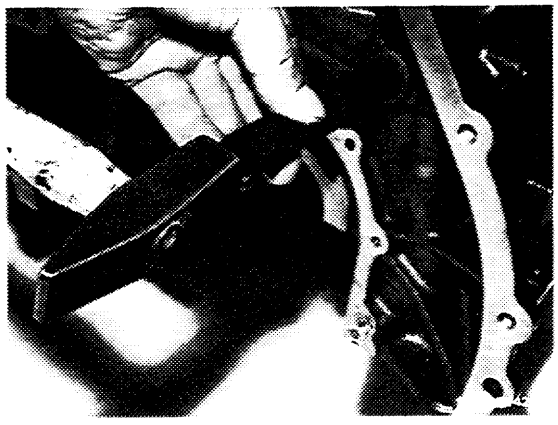
6 Position steel balls and knock in up to stop on mandrel.

7 Mount all removed or disassembled parts.

8 Run engine warm and check for leaks.



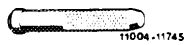
Knocking in steel ball, front



Knocking in steel bail, rear

01-140 Replacing core hole cover in cylinder crankcase

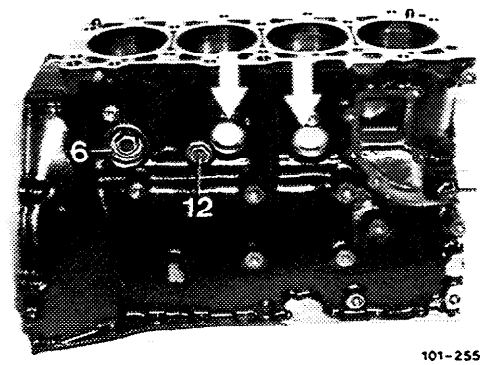
Special tools

Knocking-in mandrel for cover, 17 mm dia.	 11004-11745	601 589 07 15 00
Knocking-in mandrel for cover, 34 mm dia.	 11004-9625	102589001500

Note

The core holes in cylinder crankcase are closed with sheet metal covers (17 mm dia. or 34 mm dia.).

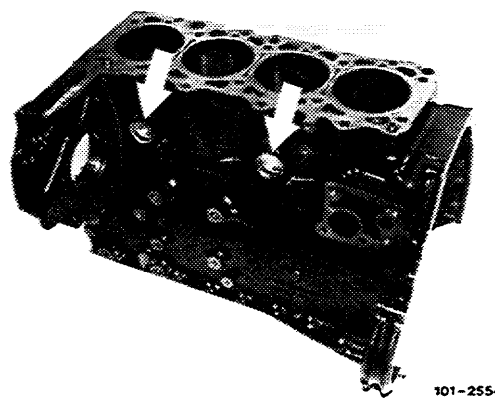
Be sure to replace leaking covers on principle.



Cylinder crankcase
Driving direction, right

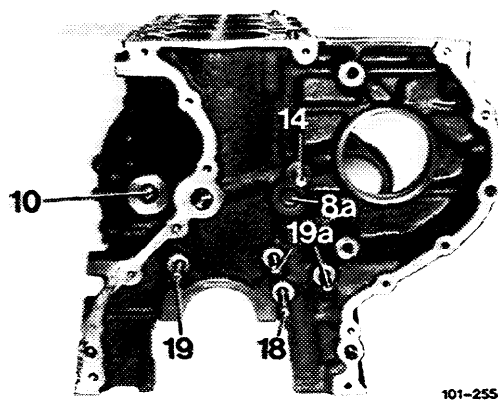
101-25547

At the right (driving direction) a closing plug (6, M 38 x 1.5) is retained. A coolant preheater can be placed into this core hole.



Cylinder crankcase
Driving direction, left

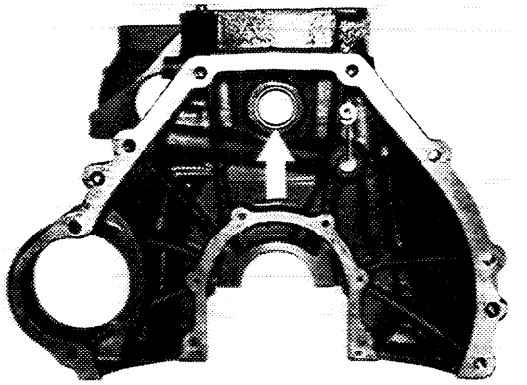
101-25546



Cylinder crankcase
Face, front

8a Core hole cover, front

101-25550

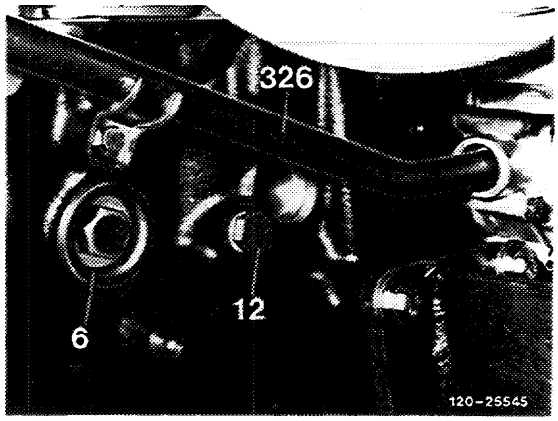


Cylinder crankcase
Transmission side
Arrow = core hole cover, rear

Renewing

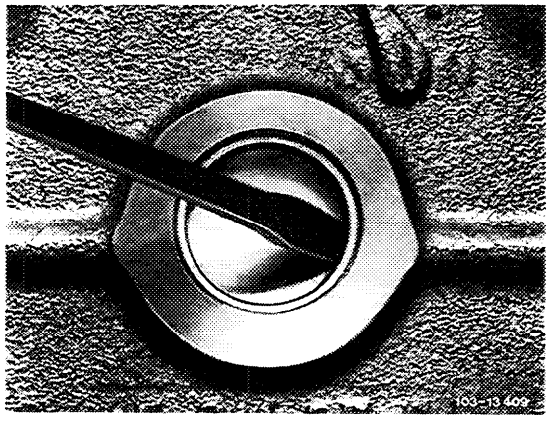
1 Completely drain coolant (20-010).

2 Remove unit parts which prevent access (e.g. transmission, injection pump, etc.).

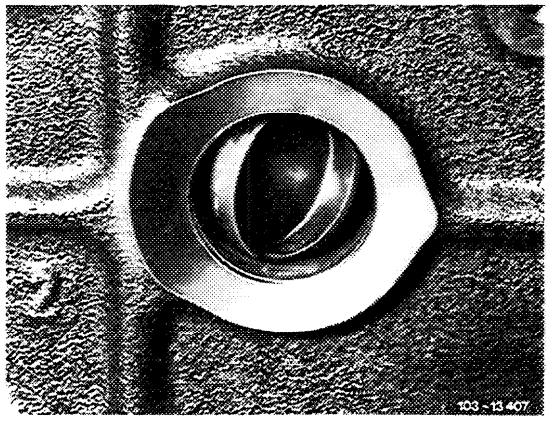


6 Closing plug
12 Drain plug on crankcase

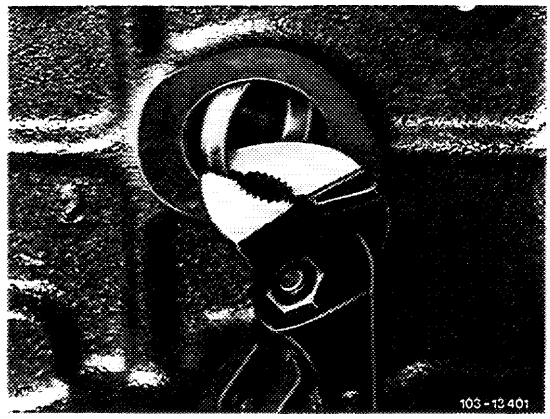
3 Position a chisel with narrow blade or a screwdriver in deep-drawn edge of closing cover.



4 Carefully knock in cover on one side until it has turned around its own longitudinal axis (approx. 90").

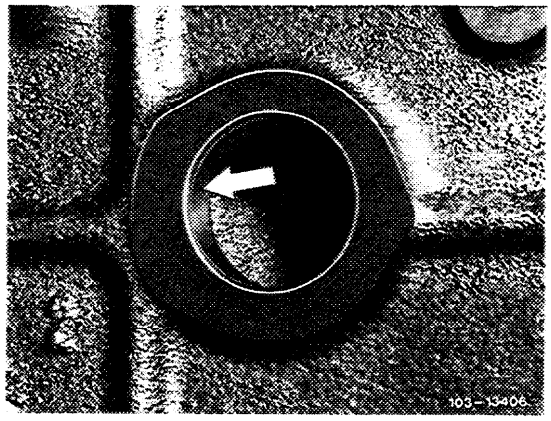


5 Position water pump pliers at flange of projecting part and pull out cover.



6 Thoroughly clean core hole from residue. Sealing surface must be free of grease (arrow).

7 Coat core hole with sealing glue Loctite 241, part no. 002 989 94 71.

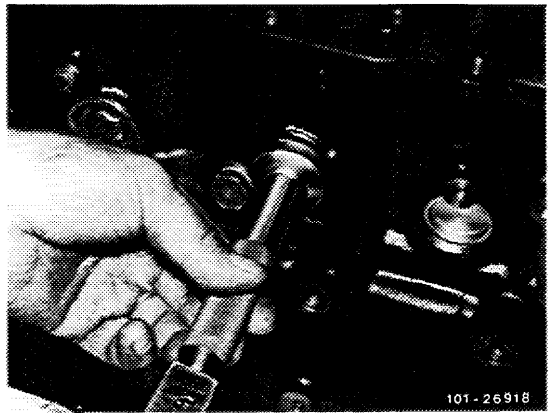


8 Knock in new closing cover by means of pertinent knocking-in mandrel.

9 Attach removed unit parts.

10 Fill in coolant (20–010).

Note: The sealing glue should cure approx. 45 minutes before filling in coolant.

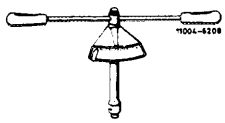
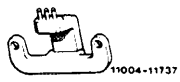


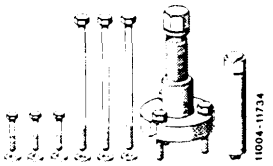
11 Run engine warm and check for leaks.

01-210 Removal and installation of timing housing cover

Tightening torques		Nm
Hex. head screw to crankshaft front		370 + 40
Screws M 8 x 12 for pulley to hub		25
Oil drain plug to oil pan		25
Oil pan to cylinder crankcase	M 6	10
	M 8	25
Central screw for fan to coolant pump		25
Adjusting screw for front engine stop		130
Engine carrier to engine mount front		35 + 10
Screws for cylinder head cover		10
Cylinder head screws M 8 (reference value)		25
Screws for timing housing cover	M 6	10
	M 8	25

Special tools

Torque wrench, double-arm, 3/8" square, 8-32 Nm		001 589 51 21 00
Torque wrench, single-arm, emitting signal with plug-in ratchet 1/2" square, 40-200 Nm		001 589 67 21 00
Torque wrench single-arm, with ratchet, 3/4" square, 150–800 Nm		001 589 74 21 00
Detent		601 589 02 40 00
Screwdriver with tommy handle for hex. socket screws 6 mm, 440 mm long		116589030700
Sleeve for pushing in radial sealing ring, front		601 589 03 14 00

Puller for flange on crankshaft		601 589 08 33 00
Box end-Allen wrench 13 x 14 mm		117589020700

Conventional tools

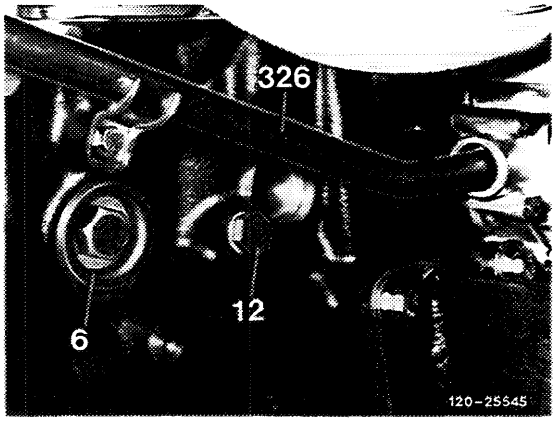
Connection 3/4'' square socket to 1/2'' square head	e.g. Hazet, D-5630 Remscheid order no. 1058 R. 1
Engine hoist no. 3180	e.g. Backer, D-5630 Remscheid, Herderstraße
Socket wrench 7 mm on flexible shaft for hose clamps with worm drive	e.g. Hazet, D-5630 Remscheid order no. 426-7

Removal

1 Completely remove noise capsule.

2 Drain engine oil.

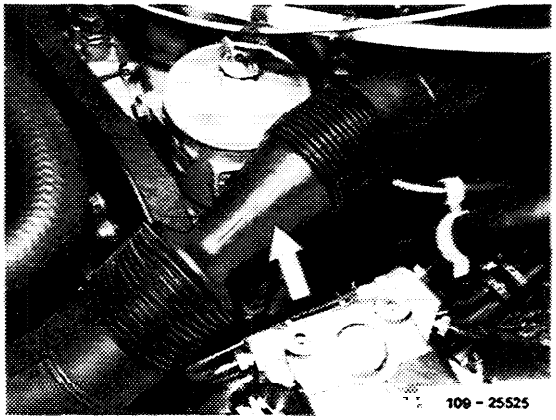
3 Completely drain coolant (20–010).



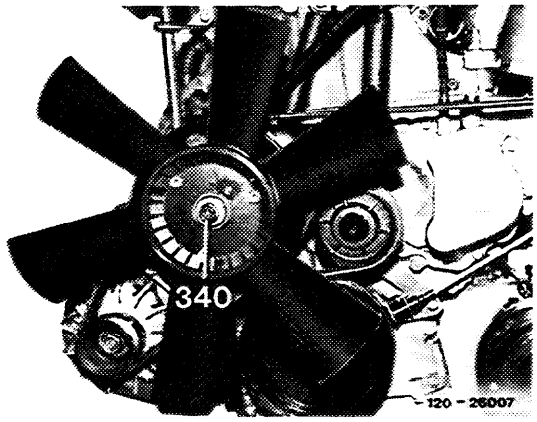
4 Remove air hose (arrow).

5 Remove radiator (20-420).

6 Disconnect negative terminal on battery.

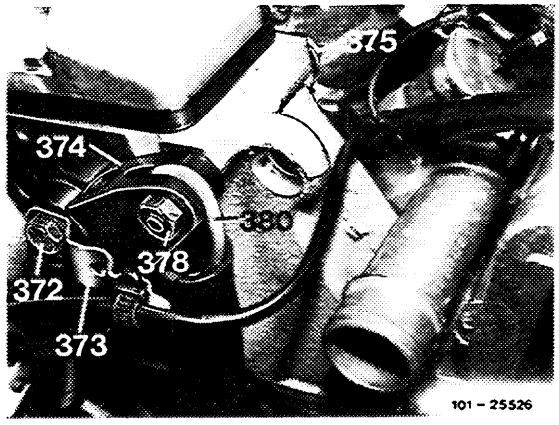


7 Unscrew collar screw (340) and remove fan.

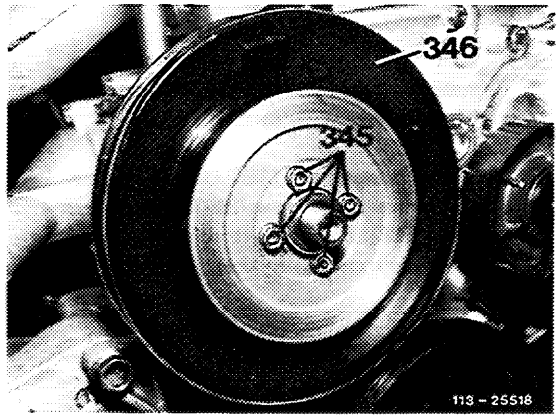


8 Slacken V-belt and remove. For this purpose, unscrew flange nut (378). Insert a mandrel into spring tensioning lever (374) and releave hex. screw (375) against draw spring (380) until spring can be pushed back in direction of intake manifold.

Release spring tensioning lever and remove V-belt.



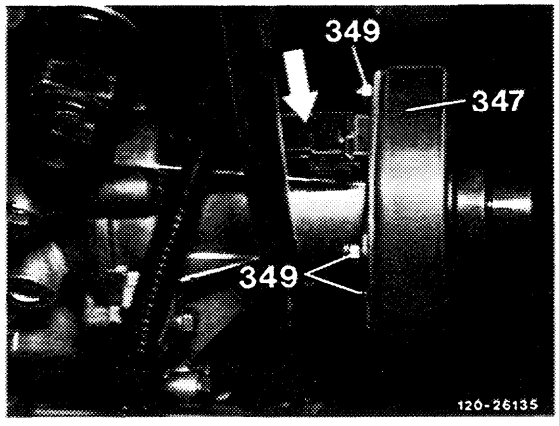
9 Unscrew hex. socket screws (345) of coolant pump pulley and **remove pulley** (346).

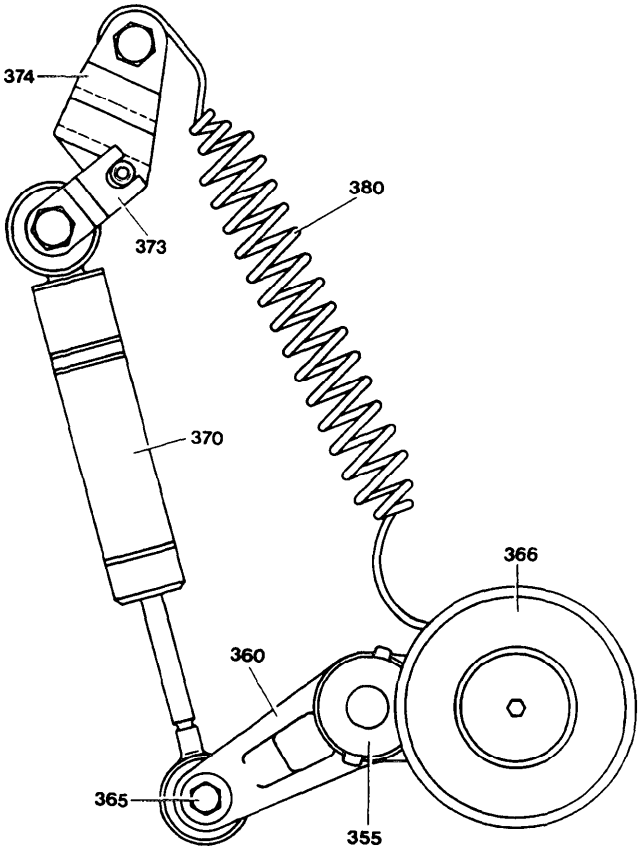


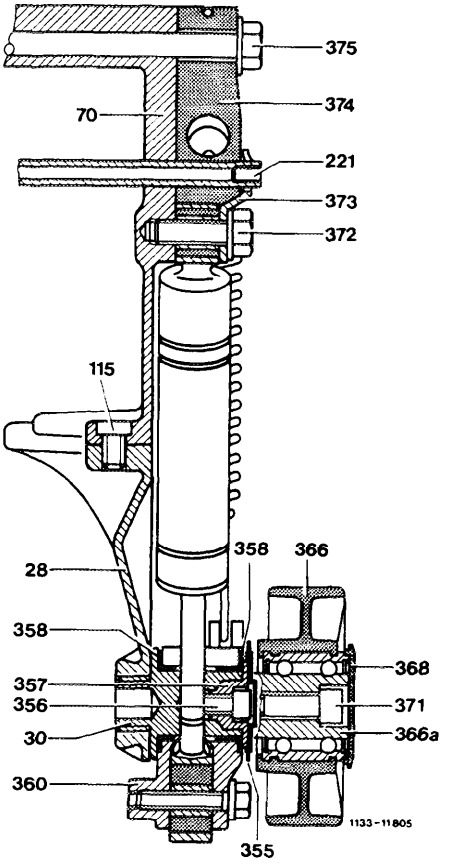
10 Pull cable from magnetic body (arrow).

11 Unscrew magnetic body (347) from magnet carrier on fastening nuts (349).

Note: The magnet carrier is glued to coolant pump housing and should not be pulled off.







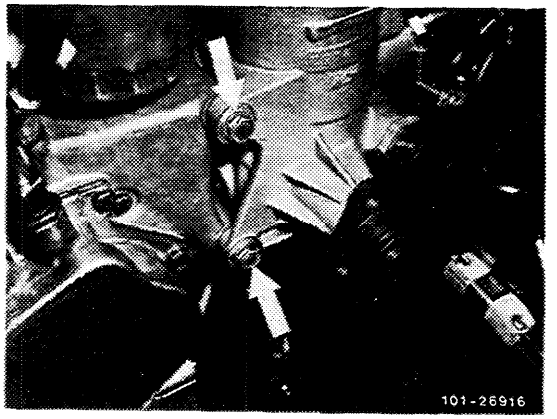
355 Closing cover M 6 x 25
356 Hex. socket screw
357 Lock washer
360 Tensioning lever
372 Hex. screw M 8 x 30
373 Holder

12 Completely remove V-belt tensioning device. Unscrew hex. screw (372) for this purpose.

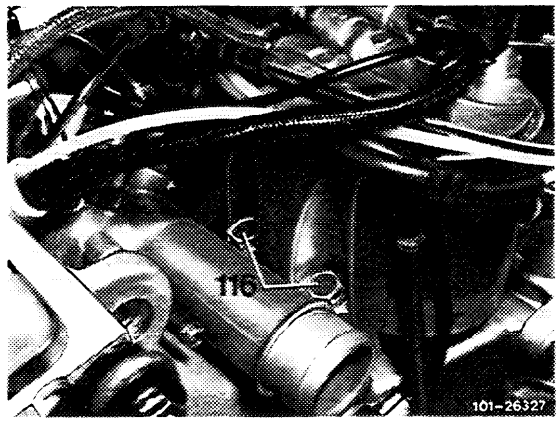
13 Remove closing cover (355). Unscrew screw **(356)** and remove lock washer (357). Remove tensioning lever **(360)** together with shock absorber and draw spring from bearing bolt.

14 On vehicles with power steering, unscrew pulley for high pressure pump.

15 Unscrew both hex. screws for high pressure oil pump fastening (arrows) and put high pressure oil pumps with lines connected aside.

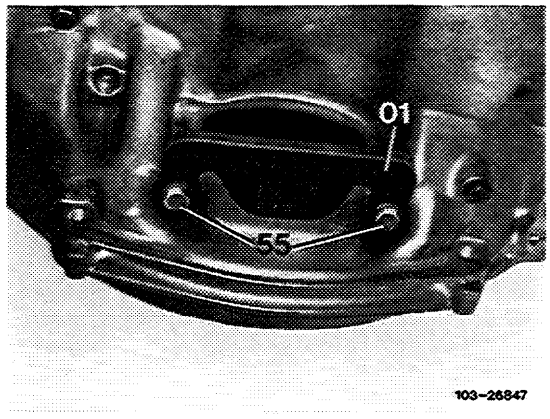


16 Unscrew the front screw of the two screws for fastening fuel filter (116).



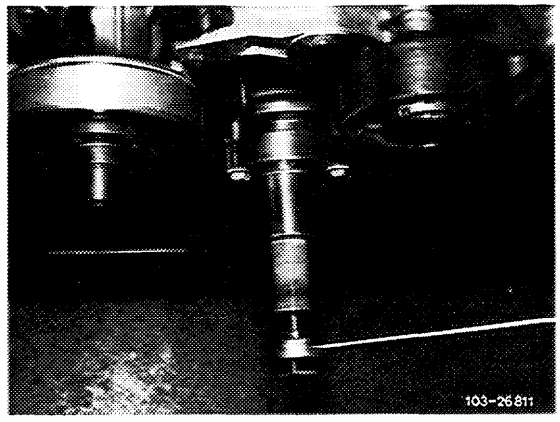
17 Unscrew crankshaft pulley.

18 Unscrew hex. screw for flange. For this purpose, mount detent, part no. 601 589 02 40 00, to oil pan.

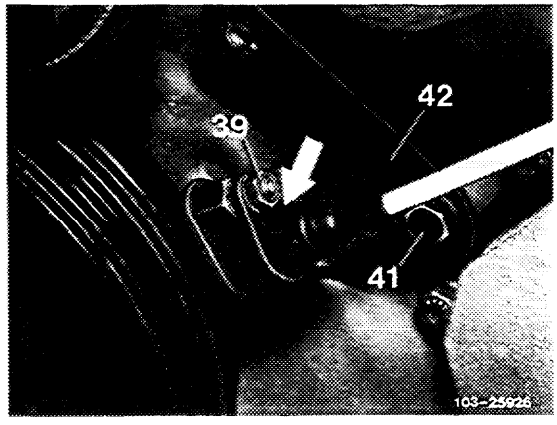


19 Pull off crankshaft flange manually.

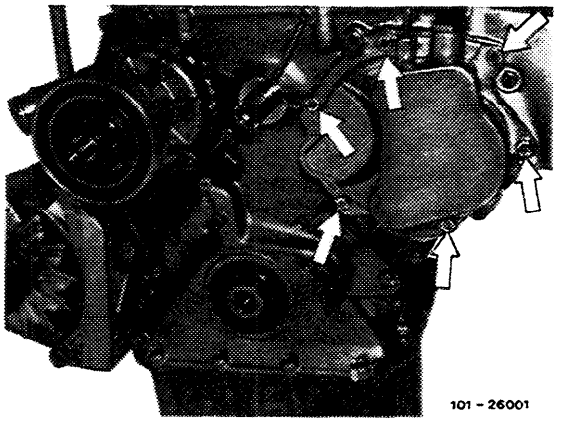
If hard to move, pull off crankshaft flange with puller, part no. 601 589 08 33.



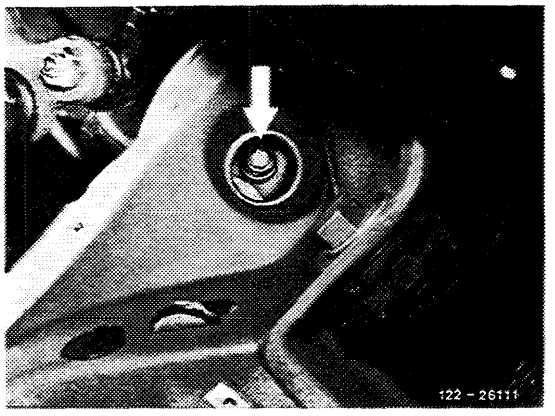
20 On vehicles with TDC transmitter, unscrew hex. nut (39), pull TDC transmitter line out of holder (42) and put aside.



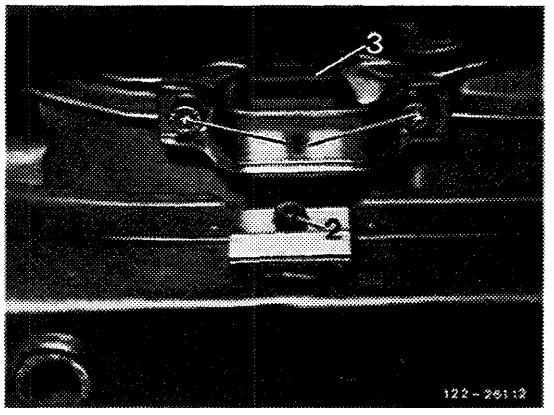
21 Unscrew vacuum pump (arrows).



22 Unscrew both fastening screws for engine carrier on engine mount (arrow).



23 Unscrew engine stop on frame cross member. For this purpose, unscrew adjusting screw (2) as well as hex. screws (1).

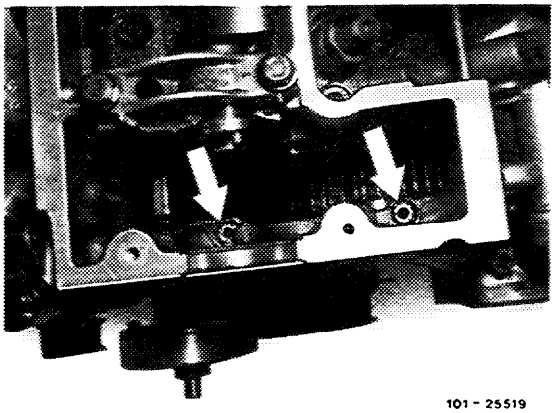


24 Attach rope of engine hoist at front suspension eye (arrow) and lift engine with a crane.

25 Unscrew fastening screws for oil pan front in range of timing housing cover. Loosen all remaining fastening screws.

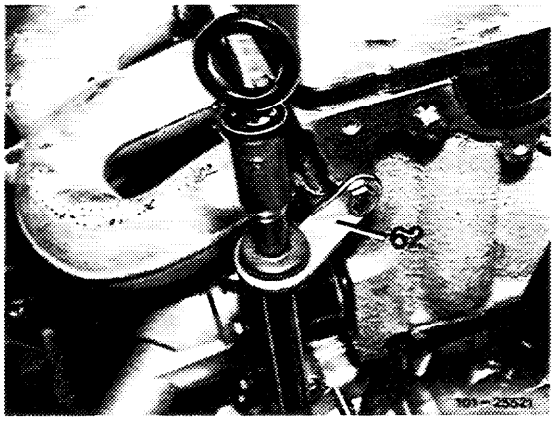
26 Lower engine again into engine mounts.

27 Remove cylinder head cover.

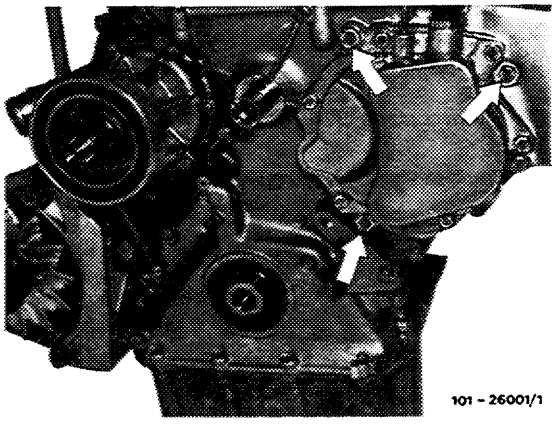


28 Unscrew the two cylinder head screws M 8 (arrows) in chain box with Allen wrench 6 mm, 440 mm long.

29 Unscrew holder for oil dipstick guide tube (62).



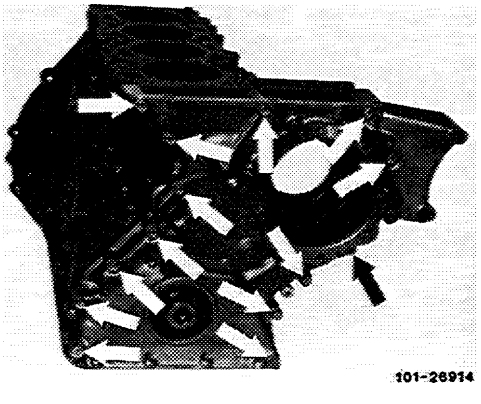
30 Unscrew fastening screws (arrows) for injection pump. Remove square nuts on flange of injection pump.



31 Unscrew remaining fastening screws for timing housing cover (arrows).

32 Remove timing housing cover.

Attention!
Do not damage cylinder head gasket. Renew damaged cylinder head gasket.



33 Clean parting surfaces.

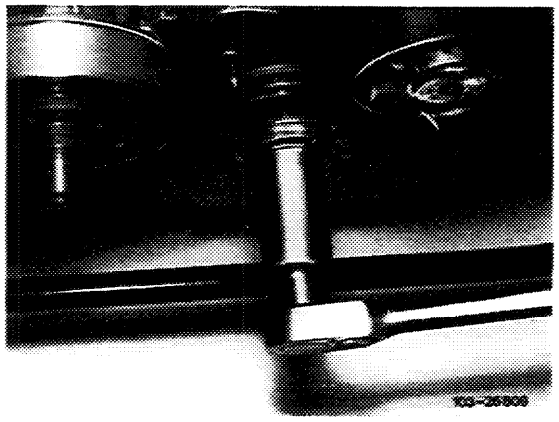
34 Coat timing housing cover parting surface with sealing compound "Curil T", part no. 001 98947 20.

35 Carefully position timing housing cover, while paying attention to cylinder head gasket,

36 Screw on timing housing cover. Pay attention to different screw lengths.

37 If the radial sealing ring has been removed, insert new radial sealing ring with sleeve, part no. 601 589 03 14 00.

38 For further installation proceed vice versa.



39 Adjust engine stop (22–220).

40 Check and correct oil level in engine.

41 Fill in coolant (20-010).

42 Pressure-test cooling system with tester.

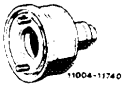
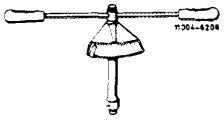
43 Run engine, check for leaks,

01–222 Removal and installation of end cover

Tightening torques

Fastening screws for end cover		10 Nm
Necked-down screws for flywheel and driven plate	initial torque	30 + 10 Nm
	angle of rotation torque	90-100”

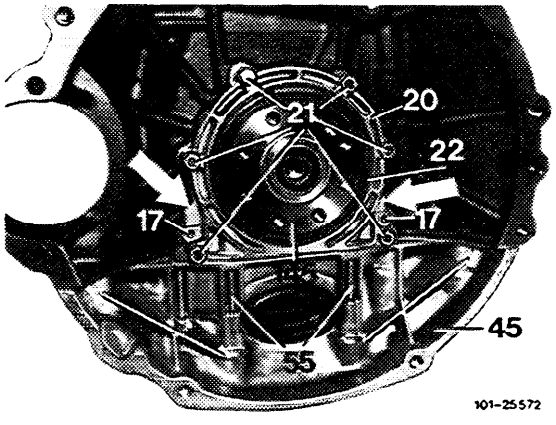
Special tools

Installation tool for rear crankshaft radial sealing ring and end cover		601 589 03 43 00
Torque wrench, double-arm, 3/8” square, 8-32 Nm		001 589 51 21 00
Torque wrench, single-arm, emitting signal, with plug-in ratchet, 1/2” square, 25-130 Nm		001 589 66 21 00

Note

The central installation position for crankshaft center is located by means of two clamping sleeves (17).

The end cover is sealed in relation to cylinder crankcase with sealing compound Loctite 573, part no. 001 989 45 20.



17 Clamping sleeve
20 End cover
21 Combination screw (M 6 x 22)
22 Radial sealing ring
55 Combination screw (M 6 x 85)
145 Crankshaft

Removal

1 Remove transmission (26-020 or 27–600).

2 Remove flywheel or driven plate (03-410).

3 Unscrew fastening screws (21 and 55) and force off end cover on both lugs (arrows).

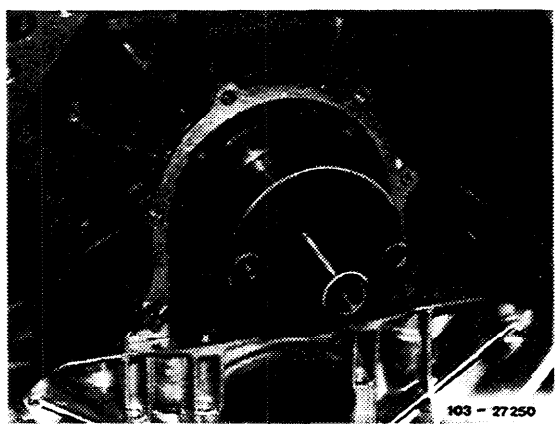
4 Clean sealing surfaces on cylinder crankcase and end cover.

5 Check whether radial sealing ring is damaged. Renew radial sealing ring.

Installation

6 Coat end cover on sealing surface uniformly with sealing compound "Loctite 573", part no. 001 989 45 20.

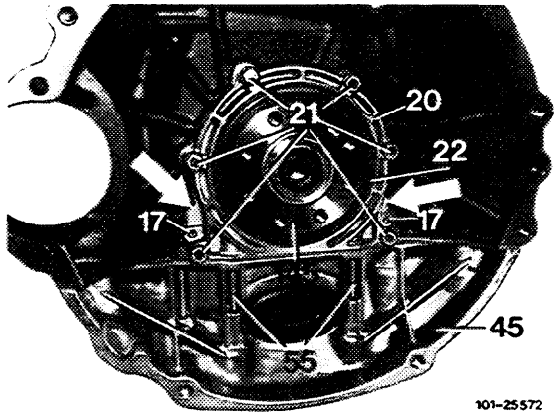
7 Slip end cover with pressed in radial sealing ring over screwed on assembly sleeve. Pay attention to oil pan gasket.



8 Tighten fastening screws (21 and 55) to 10 Nm.

Tighten fastening screws (55) first.

9 Run engine warm and check for leaks.



01-310 Removal and installation of oil pan

Oil capacity in liters	
Oil pan	5
Oil filter	1.5

Tightening torques		Nm
Oil drain plug to oil pan		25
Oil pan to cylinder crankcase	M 6	10
	M 8	25
Adjusting screw for front engine stop		130
Adjusting screw for rear engine mount		30
Engine carrier to engine mount front		35 + 10

Special tools

Torque wrench with plug-in ratchet, 1/2'' square, 25-l 30 Nm		001 589 66 21 00
Torque wrench with plug-in ratchet, 1/2'' square, 40-200 Nm		001 5896721 00
Screwdriver with tommy handle for hex. socket screws 5 mm, 300 mm long		116589020700
Screwdriver with tommy handle for hex. socket screws 6 mm, 440 mm long		116589030700
Box end-Allen wrench 13 x 14 mm		117589020700

Conventional tool

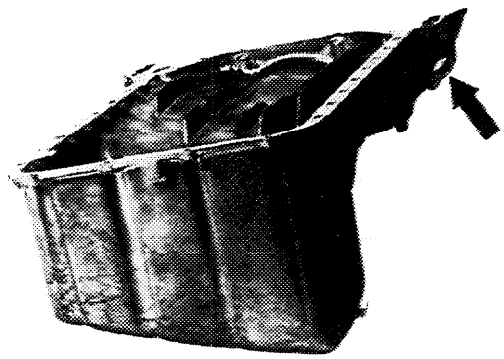
Engine hoist no. 3180	e.g. Backer, D-5630 Remscheid, Herderstraße

Note

The engines are provided with a light alloy oil pan. The pan is sealed in relation to cylinder crankcase by means of a gasket.

At the rear left (arrow) is the rpm sensor for refrigerant compressor shutoff, EG R (California version) and revolution counter.

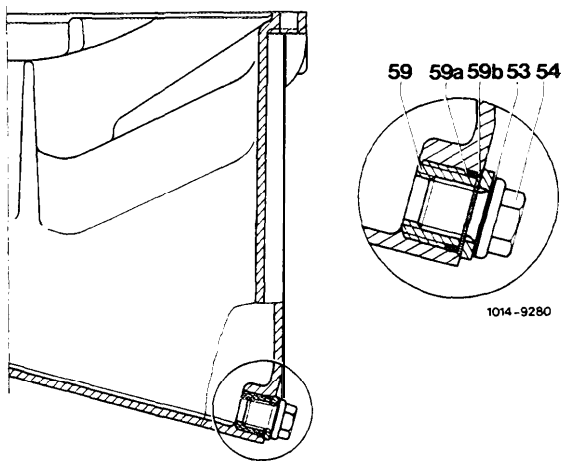
To make sure that the oil pan floor in range of oil pump strainer is horizontal with engine installed (engine installation position tilted 15" to the right), the oil pan floor has also a tilt of 15° in relation to cylinder crankcase parting surface.



101-26985

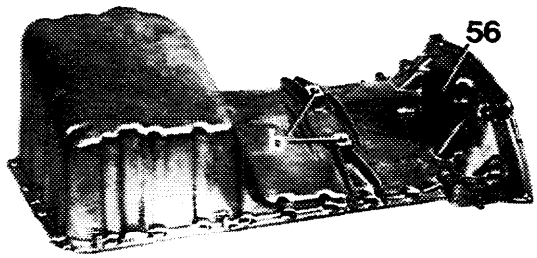
The oil drain plug (54, M 12 x 1.5) is attached at front left.

The threaded bushing is sealed by an O-ring (59a) and is locked against rotation by means of a toothed collar (59b), which digs into oil pan when inserted.



1014-9280

53 Sealing ring
54 Oil drain plug M 12 x 1.5
59 Threaded bushing
59a O-ring
59b Toothed collar



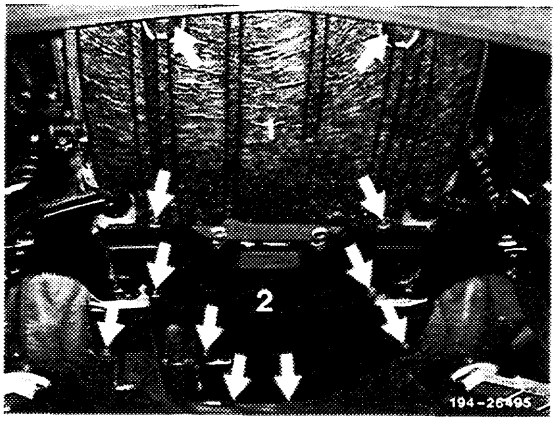
56 Closing cover
b Fastening points for engine stop

101-26986

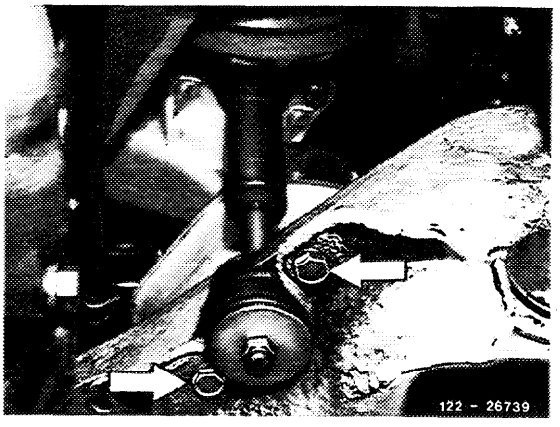
Removal

1 Remove noise capsule.

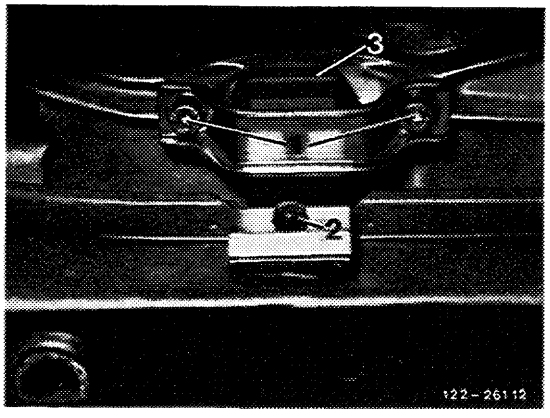
2 Drain engine oil.



3 Unscrew engine shock absorber on cross member. Unscrew fastening screws (arrows) for this purpose.

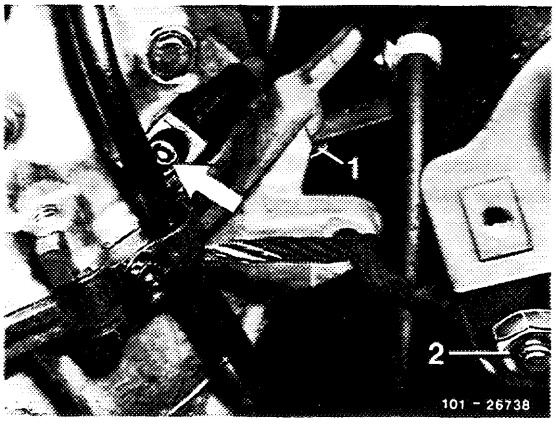


4 Remove engine stop. For this purpose, unscrew adjusting screw (2) as well as hex. screws (1) and engine stop with holder.

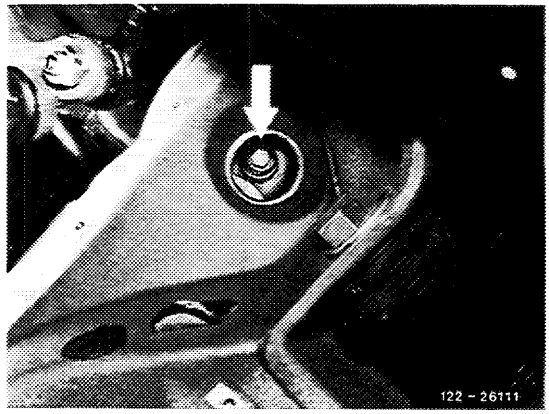


5 On vehicles with rpm sensor, disconnect line on oil pan (arrow).

6 Disconnect ground connecting line on transmission.



7 Unscrew hex. socket screws for engine carrier on both front engine mounts from below (arrow).

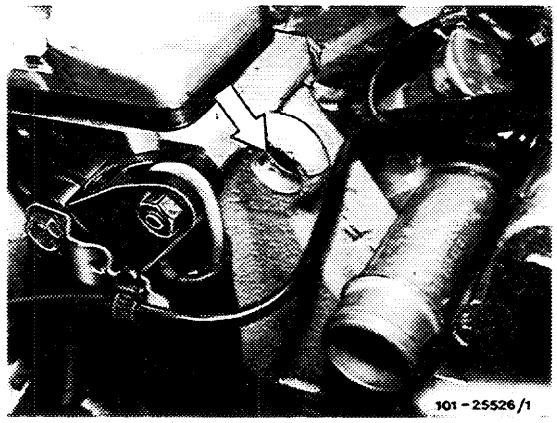


Hex. socket screw for engine carrier right

8 Unscrew torsion bar on side members right and left.

9 Engage rope of engine hoist at front suspension eye of engine (arrow).

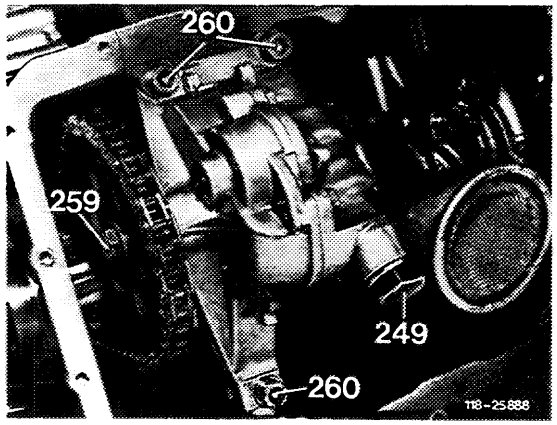
Lift engine with a crane. Pay attention to fan and fan cover.



10 Unscrew oil pan.

11 Unscrew screw (259) on sprocket and remove sprocket from drive shaft.

12 Unscrew oil pump and remove. For this purpose, unscrew fastening screws (260).



13 Remove oil pan in forward direction. Pull torsion bar down for this purpose.

14 Clean parting surfaces.

Installation

15 Place oil pan over bogie.

16 Install oil pump (18-210).

17 Mount oil pan with new gasket.

18 Lower engine and screw engine carrier to engine mount.

19 Adjust engine stop (22-220).

20 Fill in engine oil.

21 Run engine warm and check for leaks,

22 For further installation proceed vice versa.

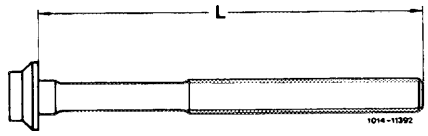
Tightening torques and angles of rotation for cylinder head screws on cold engine

Double hex. socket cylinder head screws (necked-down cylinder head screws)	1st stage	25 Nm	–
	2nd stage	40 Nm	–
	Setting interval	10 min	
	3rd stage	–	90°
	4th stage		90°

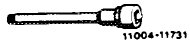
Tighten cylinder head screws M 8 with screwdriver with tommy handle.

Dimensions of double hex socket cylinder head screws

Thread dia.	Length when new	Max. length (renew)
M 10	80	83.6
M 10	102	105.6
M 10	115	118.6

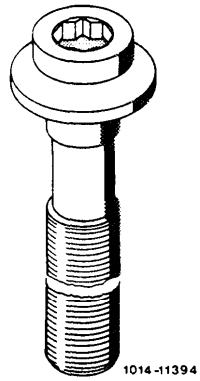


Special tools

Screwdriver element 1/2" square, 140 mm long for double hex. socket cylinder head screws M 10 on cylinder head		601 58900 1000
Screwdriver with tommy handle for hex. socket screws 6 mm, 440 mm long		116589030700
Torque wrench single-arm, emitting signal, with plug-in ratchet, 1/2" square, 25-130 Nm		001 589 66 21 00

Note

To obtain a uniform and high screw pre-tensioning force, double hex. socket — necked-down — cylinder head screws are installed with a machined flange. They have a tapered-down shank and are mounted without washers.



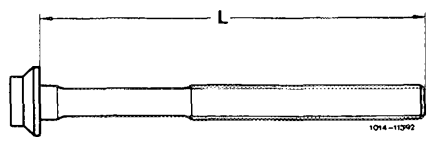
Retightening of cylinder head screws during inspection at 1000-1500 km or in the event of repairs after 1000-l 500 km is no longer required.

The double hex. socket cylinder head screws are tightened to initial torque and angle of rotation torque (refer to Table).

Since these cylinder head screws are subject to a lasting elongation after tightening, they must be renewed after the max. longitudinal dimensions named in Table shown below are exceeded.

Dimensions of cylinder head screws

Thread dia.	Lenghts when new (L)	Max. length (L) (renew)
M 10	80	83.6
M 10	102	105.6
M 10	115	118.6



Owing to the different lengths of cylinder head screws, attention must be paid to fit the bolts in the proper locations during assembly. Insert cylinder head screws according to the tightening diagram shown.

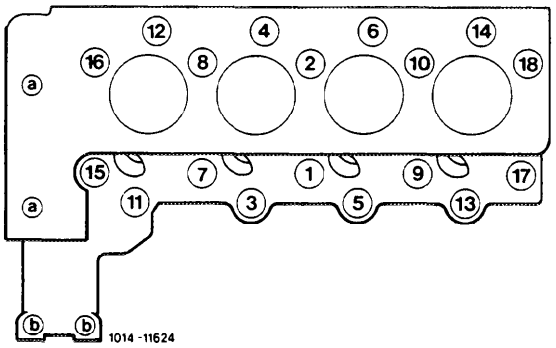
M 10 x 80 in bore 3, 5, 11, 13

M 10 x 102 in bore 2, 4, 6, 8, 10, 12, 14, 16, 18

M 10 x 115 in bore 1, 7, 9, 15, 17

M 8 x 30 in bore a

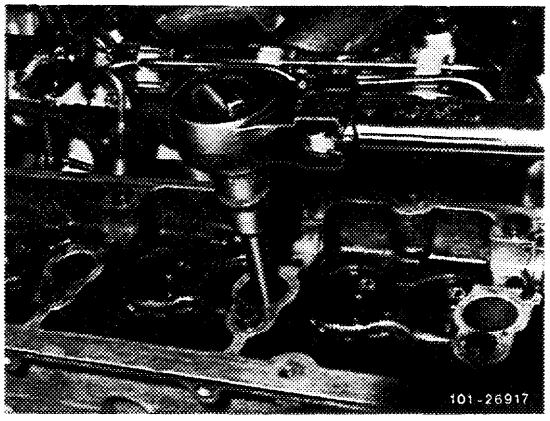
M 8 x 80 in bore b



Tighten cylinder head screws to initial torque and angle of rotation torque.

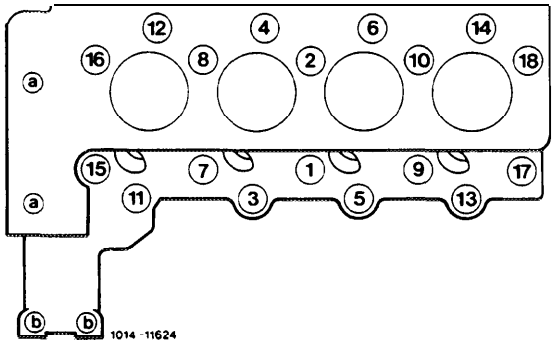
Estimate angle of rotation. For this purpose, place adjustable torque wrench in release position (locked) into plug-in ratchet. Position adjustable torque wrench with plug-in ratchet lengthwise in relation to engine and keep turning until it is transverse in relation to engine.

Do not use torsion bar torque wrench for angle of rotation.



Tighten cylinder head screws in steps in sequence of tightening pattern shown.

Do not release cylinder head screws after setting interval, but continue tightening.



After tightening according to tightening torque, a lo-minute setting interval must be maintained between the 2nd and the 3rd tightening step (refer to Table).

01-415 Removal and installation of cylinder head

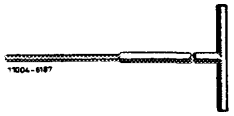
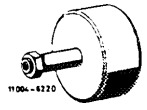
Timing at 2 mm valve lift

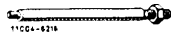
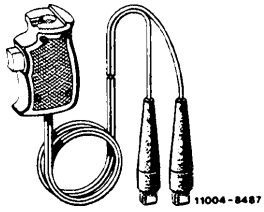
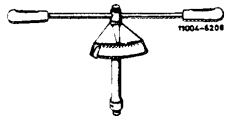
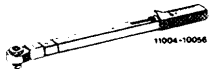
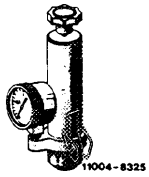
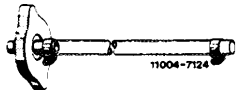
Engine	Camshaft code number[1])	Intake valve opens after TDC	Intake valve closes after BDC	Exhaust valve opens before BDC	Exhaust valve closes before TDC
601	05	with new timing chain			
		11°	17°	28°	15°
		with used timing chain (starting at approx. 20 000 km)			
		12°	18°	27°	14°

1) The camshaft code number is punched into flange of camshaft in range of TDC mark.

Tightening torques			Nm
Screws for cylinder head cover			10
Double hex. socket cylinder head screws (with cold engine)	initial torque	1st stage	25
		2nd stage	40
	setting interval	10 min	
	angle of rotation torque	3rd stage	90°
		4th stage	90°
Cylinder head screws M 8 (reference value)			25
Screw for camshaft timing gear			45
Chain tensioner			80
Coupling nuts for injection lines (reference value)			1 O-20
Hex. socket screws for intake manifold			10

Special tools

Screwdriver element 1/2'' square, 140 mm long for double hex. socket screws M 10 on cylinder head		601 589 00 10 00
Screwdriver with tommy handle for hex. socket screws 6 mm, 440 mm long		116589030700
Impact puller for bearing bolts (basic unit)		116589203300

Threaded bolt for impact puller M 6, 50 mm long		116589013400
Threaded bolt for impact puller M 6, 150 mm long		116589023400
Contact handle for rotating engine (component of compression pressure recorder 001 589 46 21 00)		001 589 46 21 08
Torque wrench, double-arm, 3/8'' square, 8-32 Nm		001 589 51 21 00
Torque wrench, single-arm, emitting signal, with plug-in ratchet 1/2'' square, 25-130 Nm		001 5896621 00
Box end wrench element, **open,** 14 mm, 1/4'' drive for coupling nut of injection line		000589770300
Tester for cooling system and radiator cap		001 589 48 21 00
Radiator cap with hose for leak test		605589002500

Conventional tool

Socket wrench hexagon 7 mm on flexible shaft for hose clamps with worm drive	e.g. Hazet, D-5630 Remscheid order no. 426-7

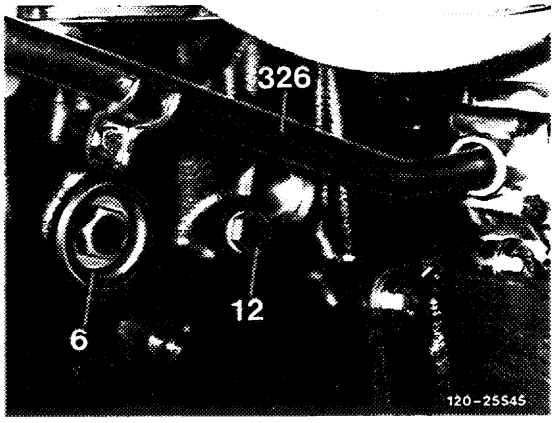
Note

Cylinder head should be removed with cooled down engine only. Remove together with exhaust manifold.

Removal

1 Set engine hood in vertical position.

2 Completely drain coolant (20-010).



12 Drain plug on cylinder crankcase

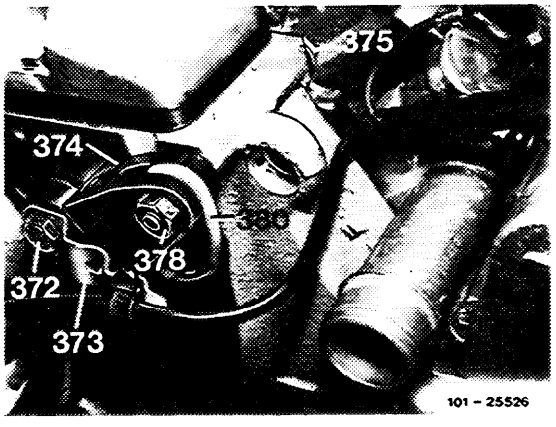
3 Disconnect negative line on battery.

4 Remove radiator (20-420).

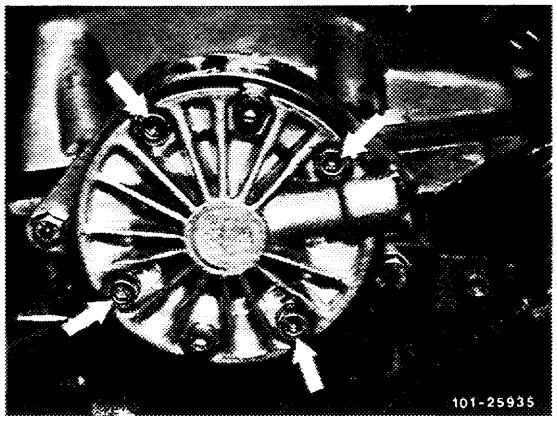
5 Completely remove air cleaner (09-410).

6 Slacken V-belt and remove. For this purpose, unscrew flange nut (378). insert a mandrel into spring tensioning lever (374) and relieve hex. screw (375) in relation to draw spring (380) until spring can be pushed back in direction of intake manifold.

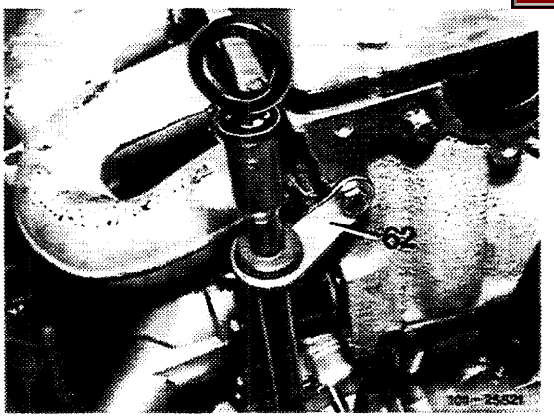
7 Unscrew hex. screw (372) for fastening shock absorber.



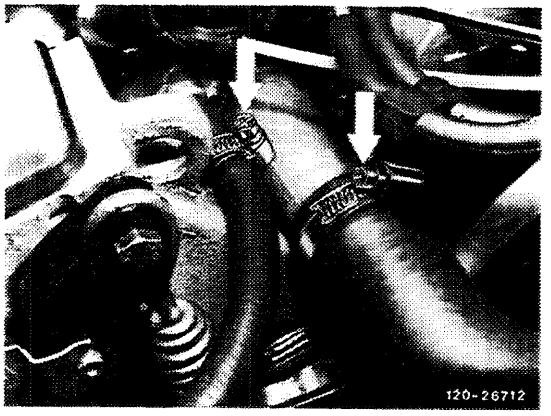
8 On vehicles with level control, unscrew hex. socket screws (arrows), place pressure oil pump with connected lines aside. Remove driver.



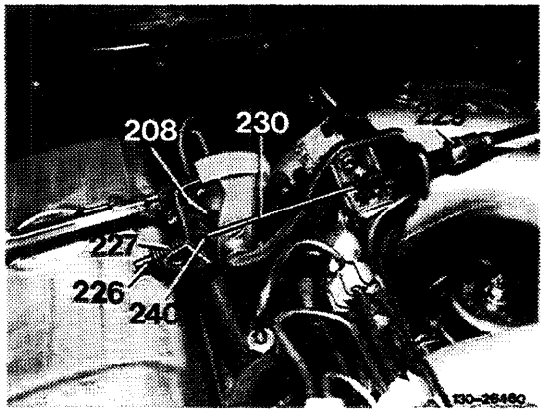
) Unscrew holder (62) for oil dipstick guide tube.



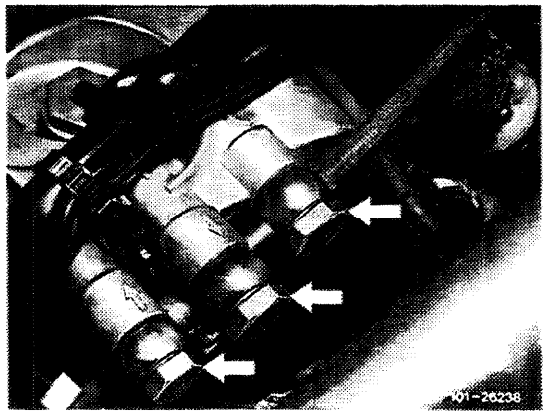
10 Disconnect coolant hoses (arrows) on coolant outlet connection and pull cable from temperature witch.



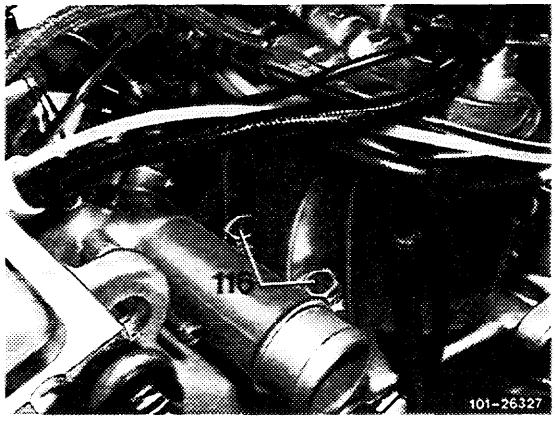
11 Disengage bowden *wire* (230) for engine regulation. For this purpose, push out slotted guide piece 240) on angle lever and remove bowden wire,



12 Pinch fuel lines and unscrew at fuel filter arrows).

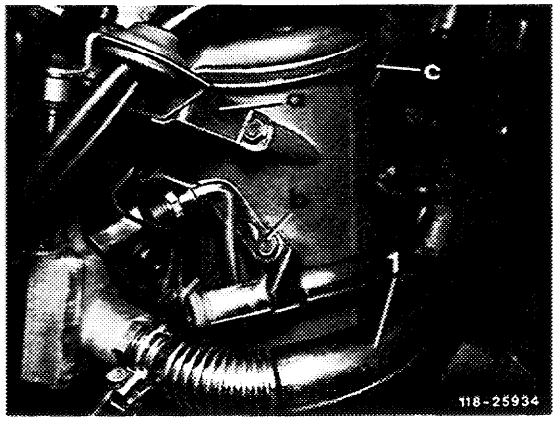


13 Unscrew both fastening screws (116) and remove fuel filter.



14 On engines with EGR, remove pipe line (1) between EGR valve and exhaust manifold.

15 Unscrew exhaust flange from exhaust manifold.



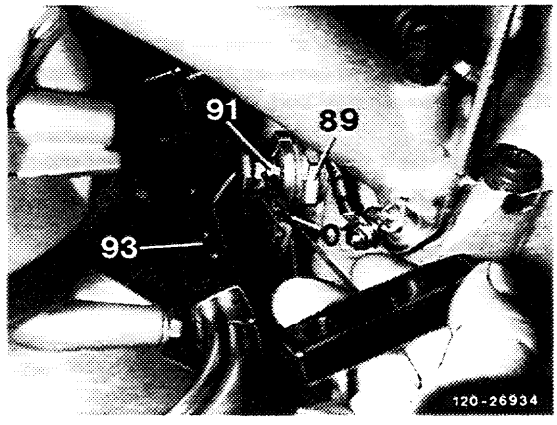
16 Remove injection lines.

17 Remove intake manifold.

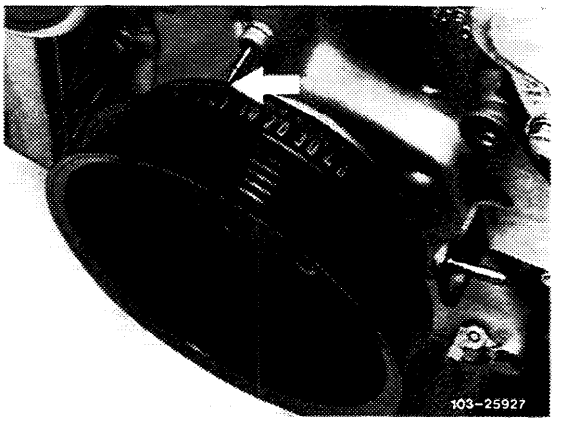
18 Remove cylinder head cover.

19 Pull off lock (91) for heater feed line (by means of a hook [01].

20 Unscrew pipe elbow (93) on oil filter and pull from connection (89).



21 Unscrew electric lines on pencil element glow plugs.

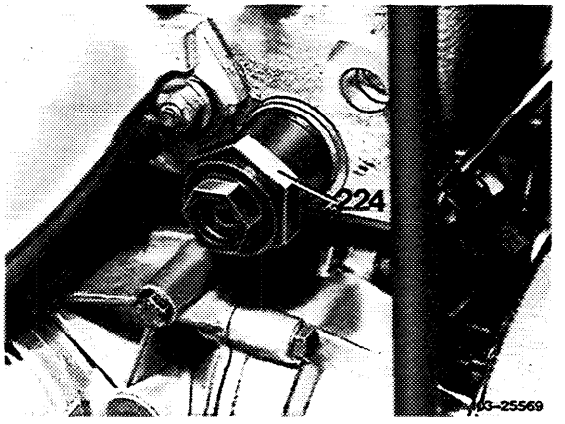


22 Set engine to ignition TDC of 1st cylinder.

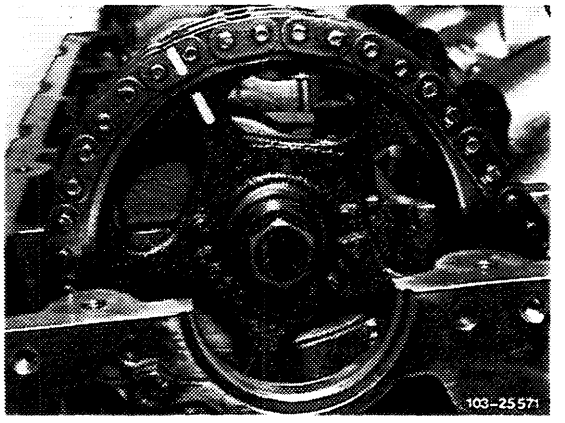
Attention!
Do not rotate engine at fastening screw of camshaft timing gear.

Do not rotate engine in reverse.

23 Completely remove chain tensioner (224) (05–310).



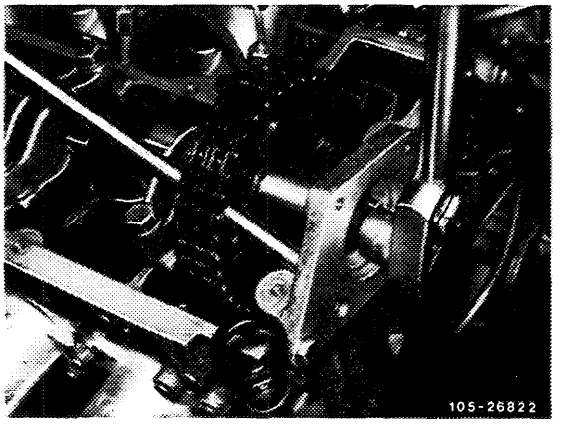
24 Mark camshaft timing gear and timing chain in relation to each other.



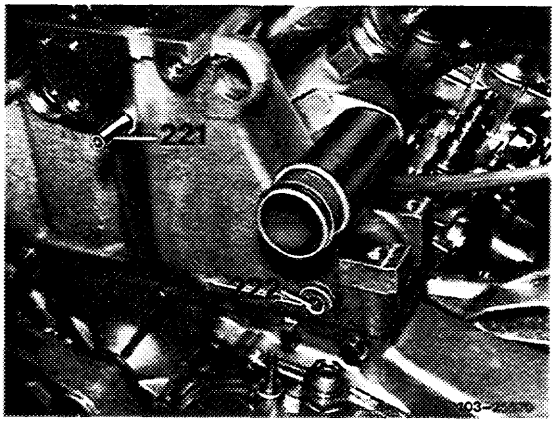
25 Remove camshaft (05–220). For this purpose, unscrew fastening screw of camshaft timing gear. Apply counterhold to camshaft timing gear by means of a screwdriver or steel bolt

Remove camshaft timing gear and lower timing chain into chain box.

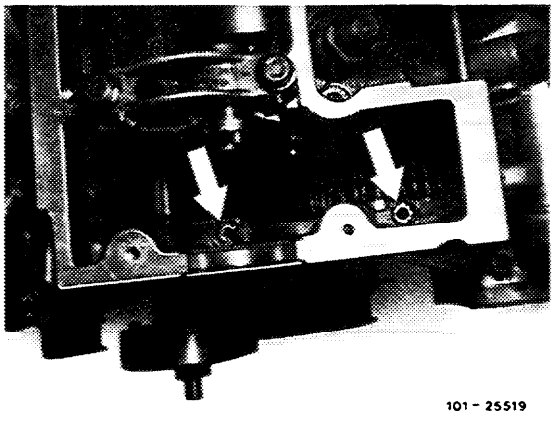
Note: Uniformly loosen all camshaft bearing caps.



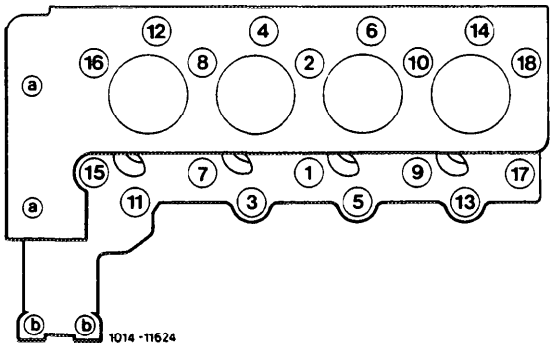
26 Knock out slide rail bolts (221 and 222) with impact puller and remove guide rail.



27 Unscrew both cylinder head screws M 8 (arrows) with screwdriver.



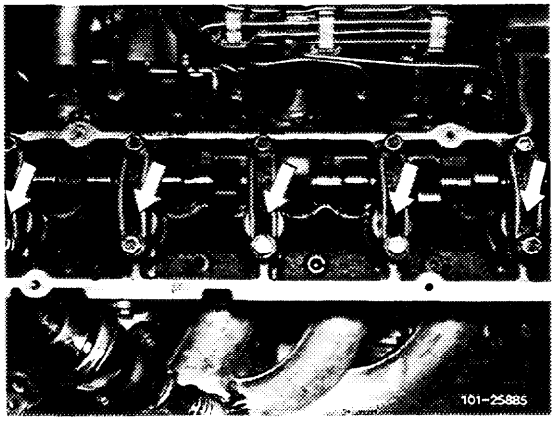
28 Loosen cylinder head screws in vice versa sequence of tightening diagram by means of screwdriver and unscrew.



Note: Cylinder head screws 2, 8, 10, 16 and 18 are located in shafts of camshaft bearing brackets (arrows).

29 Lift off cylinder head.

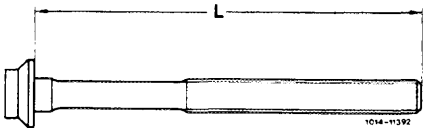
30 Clean cylinder crankcase and cylinder head parting surfaces.



31 Mount new cylinder head gasket.

32 Mount cylinder head. Pay attention to clamping sleeve for locating cylinder head.

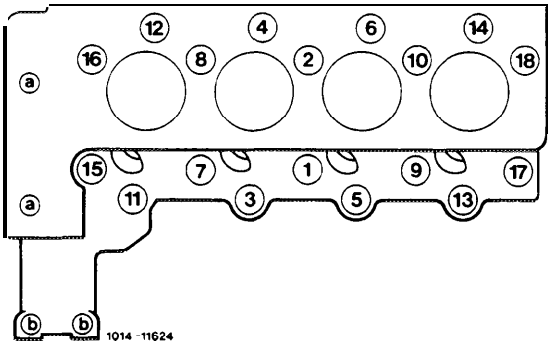
33 Measure length (L) of cylinder head screws. If the dimension named in Table is exceeded, use new cylinder head screws (01–405).



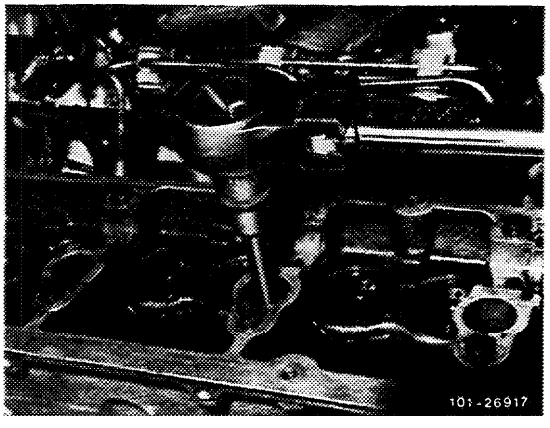
Thread dia.	Length (L) when new	Max. length (L)
M 10	80	83.6
M 10	102	105.6
M 10	115	118.6

34 Lubricate cylinder head screws on threads and on head contact surface and insert.

35 Tighten cylinder head screws in steps in sequence of tightening diagram, starting with screw 1.



Attention!
Tighten cylinder head screws to initial torque and angle of rotation torque (01-405).
Estimate angle of rotation. For this purpose, place adjustable torque wrench in release position (locked) into plug-in ratchet. Position adjustable torque wrench with plug-in ratchet lengthwise in relation to engine and keep turning until it is transverse in relation to engine.

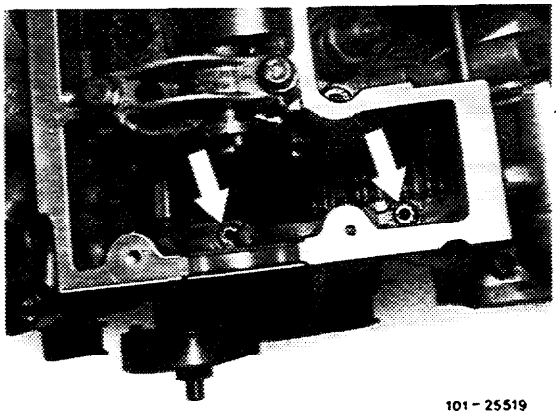


Do not use torsion bar torque wrench.

Tightening torques and angle of rotation torque of cylinder head screws

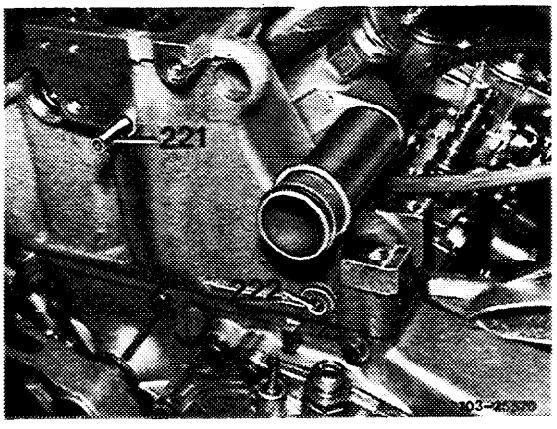
1st stage	**25** Nm
2nd stage	40 Nm
Setting interval	10 min
3rd stage	90°
4th stage	90°

36 Tighten screws M 8 (arrows) by means of screwdriver with tommy handle.



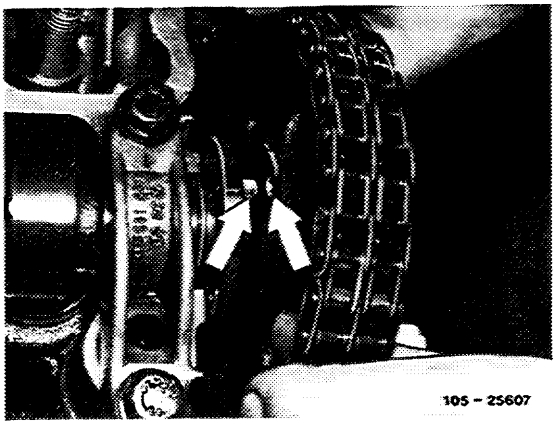
101 - 25519

37 Install guide rail for timing chain. For this purpose, insert slide rail bolts (221 and 222) into cylinder head.



38 Install camshaft, while paying attention to color mark.

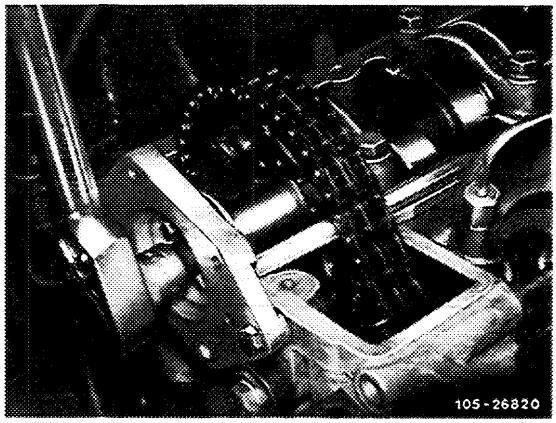
Note: The camshaft timing gear is centered by means of a cylindrical pin (arrows).



105 - 25607

39 Position fastening screw of camshaft timing gear and tighten to 45 Nm.

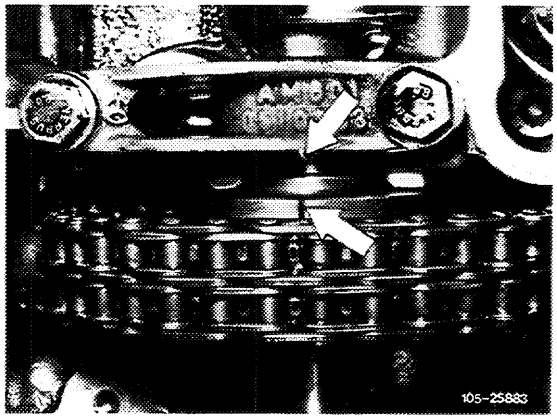
For this purpose, apply counterhold to camshaft timing gear with a screwdriver or steel pin.



40 Install chain tensioner and tighten to 80 Nm.

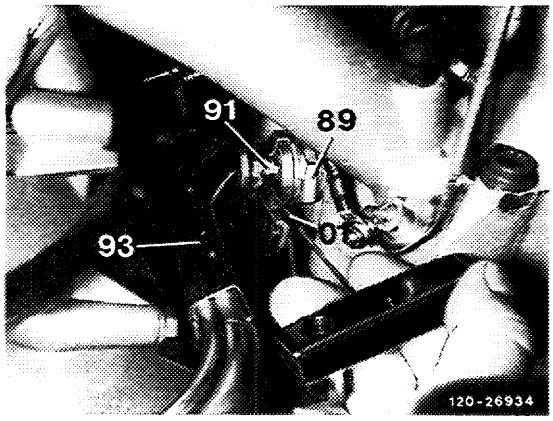
41 Rotate engine and set to ignition TDC of 1st cylinder. Check adjusting marks.

The notch in flange of camshaft must be in alignment with (cast-on) lug on cylinder head (arrow).



42 Mount electric lines for pencil element glow plugs.

43 Mount pipe elbow (93) with new O-ring.

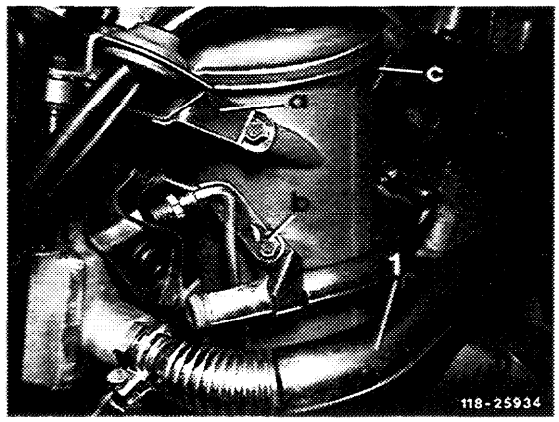


44 Install intake manifold.

45 Install injection lines.

46 Screw exhaust system to exhaust manifold.

47 On vehicles with EGR, install pipe line (1) between EGR valve and exhaust manifold.

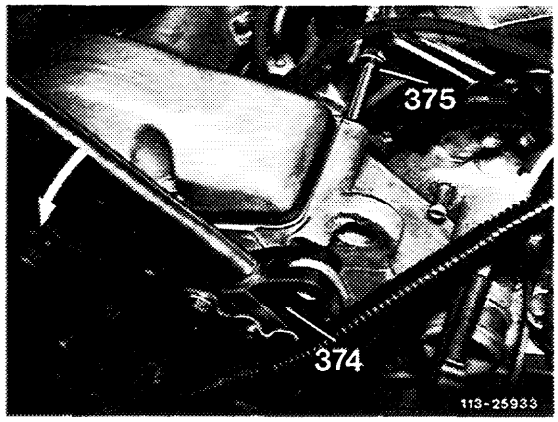


48 Install fuel filter and fuel lines,

49 Screw on holder for oil dipstick guide tube.

50 On vehicles with level control, mount pressure oil pump and driver.

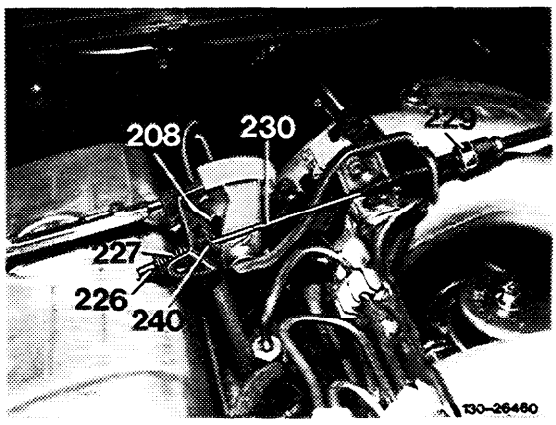
51 Mount tensioning device for V-belt. For this purpose, swivel spring tensioning lever (374) by means of a mandrel against force of draw spring (380) to the left until screw (375) can be pushed through spring tensioning lever. Position collar nut and tighten.



52 Mount cylinder head cover.

53 Engage bowden wire for engine regulation and adjust, if required (30-300).

54 Plug on cable for temperature switch.



55 For further installation proceed vice versa.

56 Fill in coolant (20-010) and pressure-test cooling system.

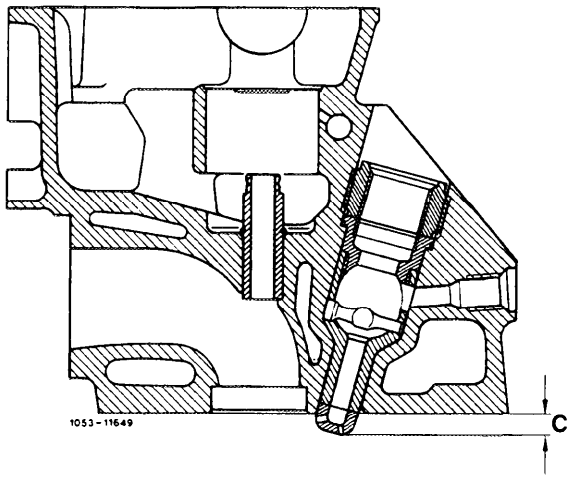
57 Run engine and check for leaks.

Note: Retightening of cylinder head screws is not required.

01-417 Removal and installation of prechambers

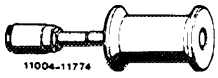
Data

hechamber standout on cylinder head
dimension "c" 7.6-8.1 mm



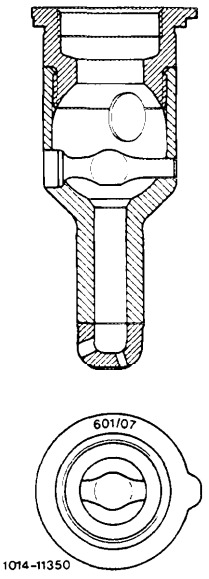
Tightening torques	Nm
Coupling nuts of injection lines (reference value)	1 O-20
Screws for cylinder head cover	10
Prechamber in cylinder head (threaded ring)	100 ± 10
Nozzle holder in prechamber	70 + 10

Special tools

Box end wrench element, open, 14 mm, 1/4" drive, for coupling nut of injection line	 11004-10520n	000589770300
Wrench element for threaded ring of prechamber	 11004-6360	615 589 00 07 00
Socket wrench element 27 mm, 1/2" square		001 589 65 09 00
Impact puller for prechamber	 11004-11774	601 589 06 33 00

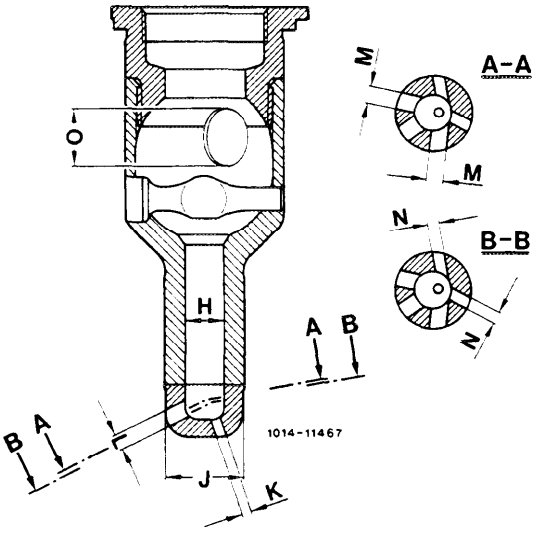
Note

The prechamber is identified at upper flange with code number 601/07.



6 burner bores of different diameter are located on prechamber lower half (burner neck) at different levels and angle positions.

The firing duct (H) has a diameter of 7 mm and the burner neck (J) of 14 mm.



H	Firing duct	7.0 mm dia.
J	Burner neck	14.0 mm dia.
K	Burner bore	1.5 mm dia.
L	Burner bore	2.0 mm dia.
M	Burner bore	3.2 mm dia.
N	Burner bore	3.0 mm dia.
0	Bore for glow plug	10.0 mm dia.

In **addition, the prechamber floor is designed as a spherical depression.**

This spherical shape provides uniform wall thicknesses in range of burner bores.

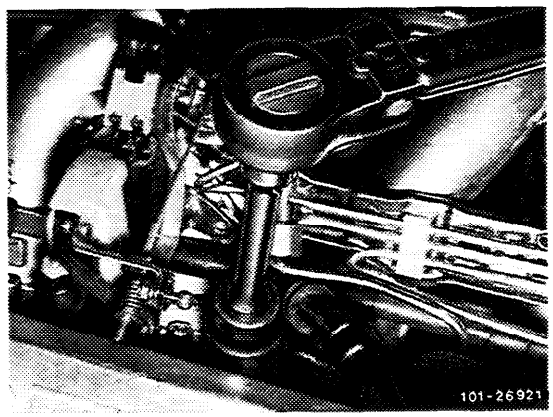
Removal

1 Unscrew injection lines from injection nozzles and loosen holder for injection lines on intake manifold.

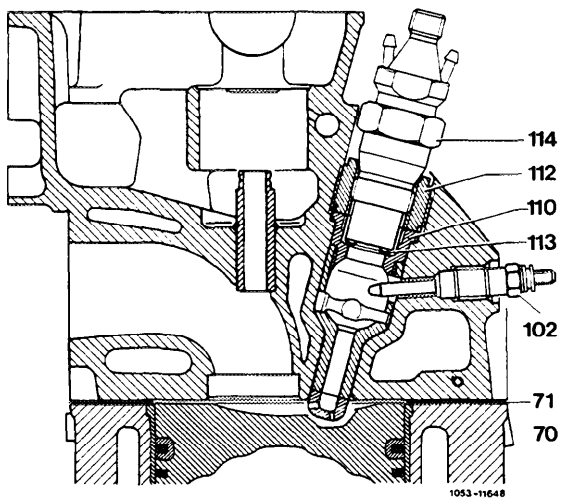
2 Pull fuel return flow hoses from injection nozzles.

3 Unscrew holder for bowden wire of engine regulation and put aside.

4 Unscrew nozzle holder complete with socket wrench element (27 mm).



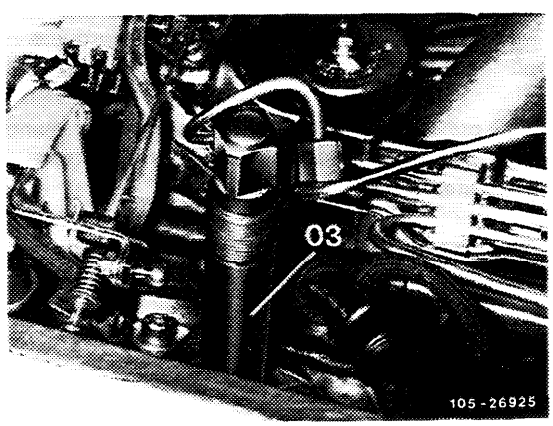
5 Remove pencil element glow plugs.



70 Cylinder crankcase
71 Cylinder head gasket
102 Pencil element glow plug
110 Prechamber
112 Threaded ring
113 Nozzle reed
114 Nozzle holder

6 Unscrew threaded ring (112) with pin wrench.

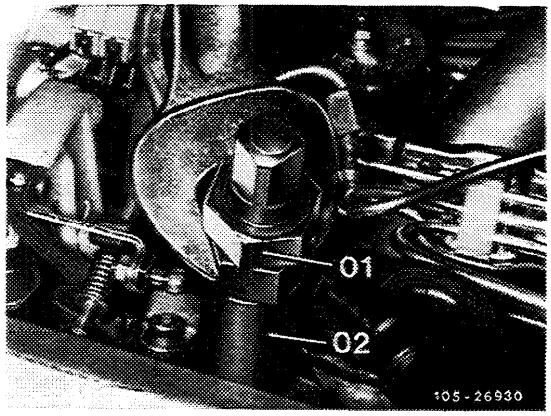
For this purpose, screw threaded member (03) into threaded ring, place sleeve (02) into grooves of threaded ring (arrows) and tighten with nut (01).



03 Threaded member

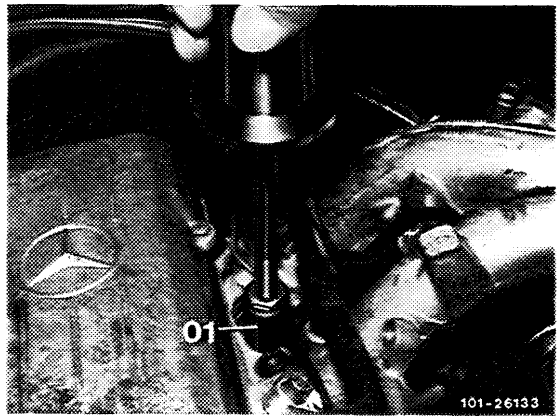
Sleeve (02) should be tight enough in grooves, so that it will not slip out of grooves when loosening threaded ring.

Insert wrench at hexagon of sleeve (02) and unscrew threaded ring.



01 Nut
02 Sleeve

7 Pull out prechamber with impact puller, part no. 601 589 06 33 00.



8 Cover bore in cylinder head.

Installation

Note: If the removed prechambers are again installed, check for perfect condition.

Ball pin should not be burnt or covered with scale.

In addition, if the burner tops are showing burn marks or cracks are showing in prechamber lower half, remove intake manifold and check inside for traces of oil.

If oil moistened spots are found, check vacuum pump for damage or renew vacuum control unit on injection pump.

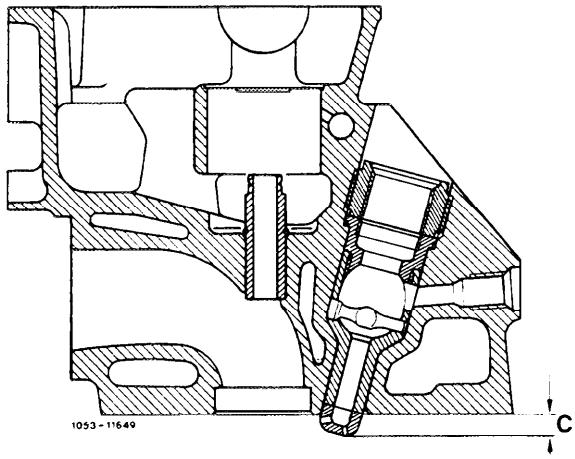
The vacuum lines (blackened by oil) are showing which of the two parts of the unit has failed.

If a cylinder head is faced at parting surface, the required distance (c) of 7.6-8.1 mm must be maintained.

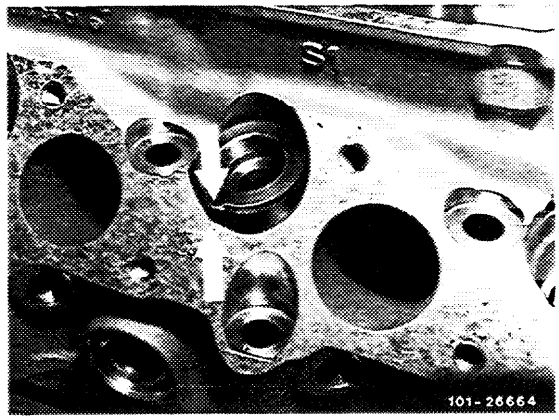
For this purpose, select appropriate sealing ring and insert between cylinder head and prechamber.

The following sealing rings are available:

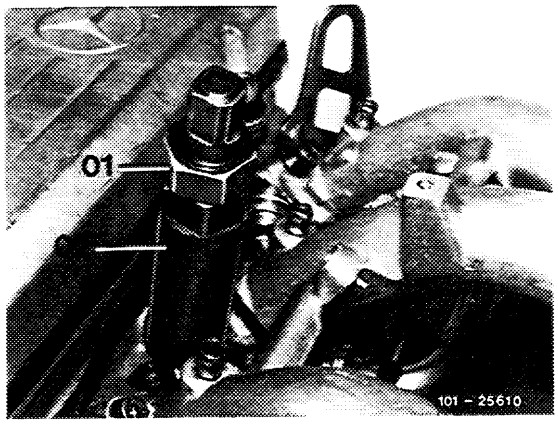
Thickness	Part no.



9 Position prechamber in such a manner that the lug is pointing toward recess in cylinder head (arrows).



10 Lubricate threaded ring (112 in Fig. item 5) and tighten with pin wrench to specified tightening torque (90-l 10 Nm).



11 Screw in glow plugs (102) and connect.

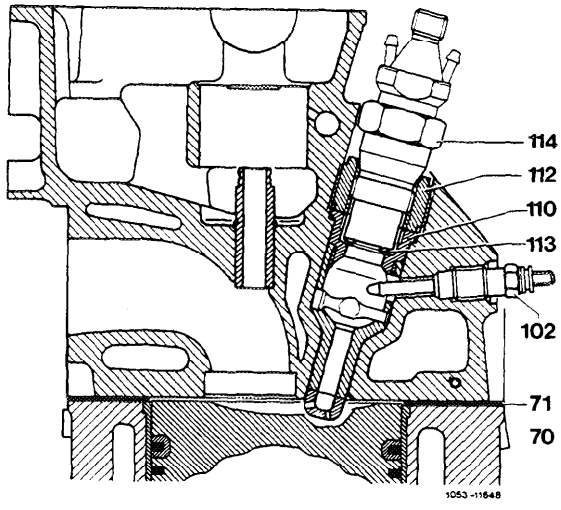
12 Insert new nozzle reed (113).

13 Completely screw in nozzle holder (114) and tighten to 70-80 Nm.

14 Plug fuel return hoses on injection lines.

15 Mount injection lines.

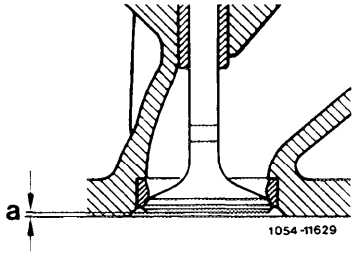
16 Screw on holder for bowden wire of engine regulation and adjust bowden wire, if required (30–300).



70 Cylinder crankcase
71 Cylinder head gasket
102 Pencil element glow plug
110 Prechamber
112 Threaded ring
113 Nozzle feed
114 Nozzle holder

01-418 Facing cylinder head parting surface

Data		
Total height of cylinder head		142-144
Minimum height after machining		
Permissible unevenness of parting surfaces	in longitudinal direction	0.08
	in transverse direction	0.0
Permissible deviation in parallel of upper parting surface in relation to lower surface in longitudinal direction		0.1
Roughness		0.016
Test pressure with air under water in bar gauge pressure		2
Minimum distance "a" with new valves and new valve seats		
	intake	+0.17 to -0.23
	exhaust	+O. 12 to -0.28
Max. distance "a" (depth) on new valves and machined valve seats		
	intake	1.0
	exhaust	

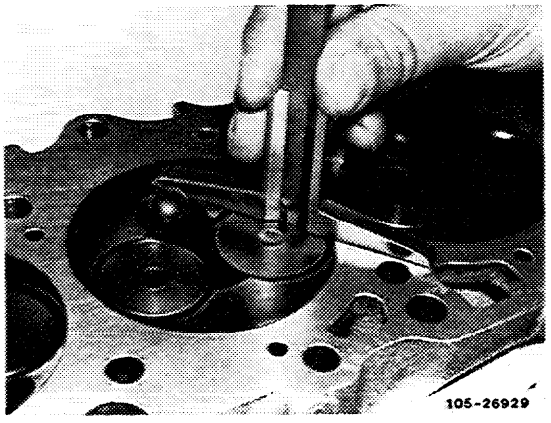


Facing

1 Face cylinder head parting surface.

2 Refinish valve seats until minimum distance "a" has been attained.

3 Check timing (05—215).

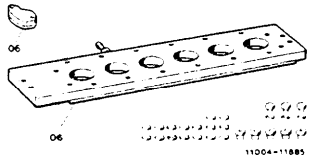
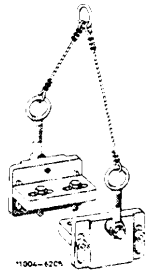


01-420 Pressure-testing cylinder head

Data

Test pressure with air under water in bar gauge pressure	2

Special tools

Pressure plate		601 589 00 25 00
Suspension device		115589346300

Conventional tool

Electrically heated water basin	e.g. Otto Dürr, D-71 23 Sachsenheim-Ochsenbach

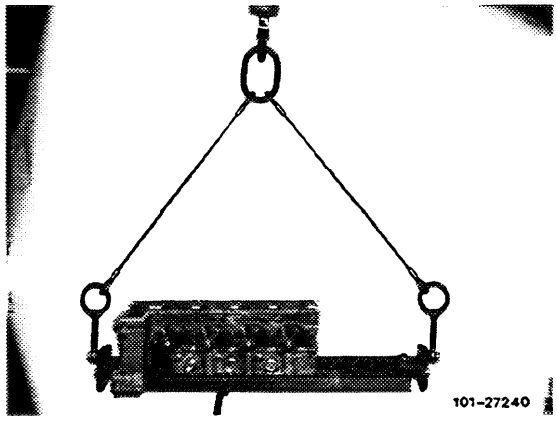
Pressure-testing

Pressure-test cylinder head if cracks (coolant losses) are suspected.

1 Screw pressure plate on cleaned cylinder head.

2 Close bores and connections.

3 Connect compressed air hose (1) and regulate compressed air to 2 bar gauge pressure.



4 Fasten cylinder head on suspension device and immerse into heated water basin (80 °C).

5 When air bubbles are rising, find leaking spot.