

## Contents

<b>00 - Technical data</b>	<b>1</b>
1 Engine number	1
2 Engine data	2
3 Safety precautions	3
4 General repair instructions	5
4.1 Rules for cleanliness when working on fuel supply system and injection system	5
4.2 Contact corrosion	5
4.3 Installing radiators and condensers	5
4.4 Checking vacuum system	5
4.5 Routing and attachment of pipes, hoses and wiring	6
<b>10 - Removing and installing engine</b>	<b>7</b>
1 Removing engine	7
2 Separating engine and gearbox	30
3 Securing engine to engine and gearbox support	34
4 Installing engine	37
5 Assembly mountings	44
5.1 Assembly overview - assembly mountings	44
5.2 Checking adjustment of assembly mountings	46
5.3 Adjusting assembly mountings	47
<b>13 - Crankshaft group</b>	<b>52</b>
1 Dismantling and assembling engine	52
1.1 Assembly overview - poly V-belt drive	52
1.2 Removing and installing poly V-belt	53
1.3 Removing and installing crankshaft pulley	56
1.4 Removing and installing bracket for ancillaries	58
1.5 Assembly overview - toothed belt drive	61
1.6 Removing and installing toothed belt	64
1.7 Detaching toothed belt from camshaft sprocket	74
1.8 Checking semi-automatic tensioning roller for toothed belt	78
2 Removing and installing sealing flanges and flywheel/drive plate	81
2.1 Assembly overview - sealing flanges and flywheel/drive plate	81
2.2 Renewing crankshaft oil seal (pulley end)	83
2.3 Removing and installing sealing flange (pulley end)	86
2.4 Removing and installing sealing flange (gearbox end)	90
2.5 Removing and installing flywheel	93
2.6 Removing and installing drive plate	94
3 Crankshaft	96
3.1 Assembly overview - crankshaft	96
3.2 Crankshaft dimensions	99
3.3 Extracting and driving in needle bearing for crankshaft	100
3.4 Removing and installing chain sprocket	101
4 Pistons and conrods	104
4.1 Assembly overview - pistons and conrods	104
4.2 Piston and cylinder dimensions	109
<b>15 - Cylinder head, valve gear</b>	<b>110</b>
1 Cylinder head	110
1.1 Assembly overview - cylinder head	110
1.2 Removing and installing cylinder head cover	113



1.3	Removing and installing cylinder head	114
1.4	Checking compression	125
<b>2</b>	<b>Valve gear</b>	<b>129</b>
2.1	Assembly overview - valve gear	129
2.2	Measuring axial clearance of camshaft	131
2.3	Measuring radial clearance of camshaft	132
2.4	Renewing camshaft oil seal	132
2.5	Removing and installing camshaft	135
2.6	Renewing valve stem oil seals with cylinder head installed	140
2.7	Renewing valve stem oil seals with cylinder head removed	145
2.8	Checking supporting elements with hydraulic clearance compensation	150
2.9	Valve dimensions	152
2.10	Checking valve guides	152
2.11	Checking valves	153
2.12	Machining valve seats	153
<b>17</b>	<b>- Lubrication</b>	<b>157</b>
<b>1</b>	<b>Lubrication system</b>	<b>157</b>
1.1	Assembly overview - sump, oil pump	157
1.2	Removing and installing sump	159
1.3	Removing and installing oil pump	163
1.4	Assembly overview - oil filter, oil filter bracket	164
1.5	Removing and installing oil pressure switch F1	166
1.6	Checking oil pressure and oil pressure switch	167
1.7	Engine oil	169
1.8	Checking engine oil level	169
<b>19</b>	<b>- Cooling</b>	<b>170</b>
<b>1</b>	<b>Cooling system</b>	<b>170</b>
1.1	Connection diagram - coolant hoses	170
1.2	Draining and filling cooling system	171
1.3	Removing and installing coolant pump	177
1.4	Removing, installing and checking thermostat	179
1.5	Removing and installing coolant pipe	181
1.6	Assembly overview - radiator and radiator fans	185
1.7	Removing and installing radiator	187
1.8	Removing and installing radiator fan V7 and radiator fan 2 V177	190
1.9	Assembly overview - engine pre-heating system for vehicles with engine codes CCSA, CMXA	192
1.10	Checking cooling system for leaks	193
<b>26</b>	<b>- Exhaust system</b>	<b>195</b>
<b>1</b>	<b>Silencers and exhaust manifold - vehicles with engine codes BGU, BSE, BSF, CCSA</b>	<b>195</b>
1.1	Assembly overview - silencers and exhaust manifold on vehicles with engine codes BGU, BSE, BSF, CCSA	195
1.2	Separating centre and rear silencers	198
1.3	Removing and installing front exhaust pipe with catalytic converter	199
1.4	Removing and installing exhaust manifold	202
1.5	Stress-free alignment of exhaust system	203
1.6	Checking exhaust system for leaks	204
<b>2</b>	<b>Silencers and exhaust manifold - vehicles with engine code CMXA</b>	<b>206</b>
2.1	Assembly overview - silencers and exhaust manifold	206
2.2	Separating centre and rear silencers	209
2.3	Removing and installing front exhaust pipe with catalytic converter	211
2.4	Removing and installing exhaust manifold	214
2.5	Stress-free alignment of exhaust system	216

2.6	Checking exhaust system for leaks .....	217
<b>3</b>	<b>Exhaust gas recirculation system - vehicles with engine code BGU .....</b>	<b>218</b>
3.1	Assembly overview - exhaust gas recirculation system .....	218
3.2	Checking adaption of zero position for exhaust gas recirculation valve N18 .....	220
3.3	Removing and installing exhaust gas recirculation valve N18 with exhaust gas recirculation potentiometer G212 .....	222
<b>4</b>	<b>Secondary air system - vehicles with engine codes BGU, BSE, CCSA, CMXA .....</b>	<b>225</b>
4.1	Principle and function .....	225
4.2	Assembly overview - secondary air system for vehicles with engine code BGU .....	225
4.3	Assembly overview - secondary air system for vehicles with engine codes BSE, CCSA, CMXA .....	226
4.4	Checking combination valve for secondary air system for proper operation and leakage ..	228
4.5	Removing and installing combination valve for secondary air system .....	229
4.6	Removing and installing secondary air pump .....	230