



Contents

| | |
|--|-----------|
| 00 - Technical data | 1 |
| 1 Identification | 1 |
| 1.1 Engine number/engine data | 1 |
| 2 Safety information | 2 |
| 2.1 Safety precautions when working on the fuel system | 2 |
| 2.2 Safety precautions when using testers and measuring instruments during a road test | 3 |
| 2.3 Safety precautions when working on the cooling system | 3 |
| 2.4 Safety precautions when working on vehicles with start/stop system | 4 |
| 2.5 Safety precautions when working on the SCR system | 4 |
| 2.6 Safety precautions when working on the exhaust system | 5 |
| 3 Repair instructions | 6 |
| 3.1 Rules for cleanliness | 6 |
| 3.2 General notes | 6 |
| 3.3 General repair instructions | 7 |
| 3.4 Performing adaptations after renewing a component | 8 |
| 3.5 Cleaning engine | 8 |
| 3.6 Nuts, bolts | 8 |
| 3.7 Identification plates | 8 |
| 3.8 Use of impact wrenches | 9 |
| 3.9 Foreign material in engine | 9 |
| 3.10 Contact corrosion | 9 |
| 3.11 Routing and attachment of pipes, hoses and wiring | 10 |
| 3.12 Installing radiators and condensers | 10 |
| 10 - Removing and installing engine | 11 |
| 1 Removing and installing engine | 11 |
| 1.1 Removing engine | 11 |
| 1.2 Securing engine to engine and gearbox support | 26 |
| 1.3 Installing engine | 28 |
| 2 Assembly mountings | 31 |
| 2.1 Assembly overview - assembly mountings | 31 |
| 2.2 Supporting engine in installation position | 32 |
| 2.3 Removing and installing engine mountings | 34 |
| 2.4 Removing and installing torque reaction support and cross member | 35 |
| 3 Engine cover panel | 40 |
| 3.1 Removing and installing engine cover panel | 40 |
| 13 - Crankshaft group | 41 |
| 1 Cylinder block (pulley end) | 41 |
| 1.1 Assembly overview - cylinder block (pulley end) | 41 |
| 1.2 Assembly overview - sealing flange (pulley end) | 44 |
| 1.3 Removing and installing poly V-belt | 46 |
| 1.4 Removing and installing poly V-belt tensioner | 47 |
| 1.5 Removing and installing vibration damper | 48 |
| 1.6 Removing and installing bracket for ancillaries | 51 |
| 1.7 Removing and installing sealing flange (pulley end) | 52 |
| 2 Cylinder block (gearbox end) | 56 |
| 2.1 Assembly overview - cylinder block (gearbox end) | 56 |
| 2.2 Removing and installing drive plate | 58 |
| 2.3 Renewing cylinder block cover (gearbox end) | 60 |
| 2.4 Removing and installing sealing flange (gearbox end) | 62 |
| 2.5 Renewing needle bearing in drive plate | 71 |



| | | |
|-----------|---|------------|
| 3 | Crankshaft | 74 |
| 3.1 | Assembly overview - crankshaft | 74 |
| 3.2 | Crankshaft dimensions | 75 |
| 3.3 | Measuring axial clearance of crankshaft | 75 |
| 4 | Pistons and conrods | 77 |
| 4.1 | Assembly overview - pistons and conrods | 77 |
| 4.2 | Removing and installing pistons | 81 |
| 4.3 | Measuring piston projection at TDC | 82 |
| 4.4 | Checking pistons and cylinder bores | 84 |
| 4.5 | Separating parts of new conrod | 86 |
| 4.6 | Checking radial clearance of conrod bearings | 86 |
| 15 | Cylinder head, valve gear | 88 |
| 1 | Toothed belt drive | 88 |
| 1.1 | Assembly overview - toothed belt guard | 88 |
| 1.2 | Assembly overview - toothed belt | 88 |
| 1.3 | Removing and installing toothed belt guard | 90 |
| 1.4 | Detaching toothed belt from camshaft | 93 |
| 1.5 | Removing and installing toothed belt | 105 |
| 2 | Cylinder head | 119 |
| 2.1 | Assembly overview - cylinder head cover | 119 |
| 2.2 | Assembly overview - cylinder head | 121 |
| 2.3 | Removing and installing cylinder head | 124 |
| 2.4 | Removing and installing cylinder head cover | 133 |
| 2.5 | Removing and installing seals for injectors | 135 |
| 2.6 | Removing and installing camshaft housing | 135 |
| 2.7 | Checking compression | 140 |
| 3 | Valve gear | 143 |
| 3.1 | Assembly overview - valve gear | 143 |
| 3.2 | Removing and installing camshaft oil seal | 147 |
| 3.3 | Removing and installing camshaft control valve 1 N205 | 152 |
| 3.4 | Removing and installing camshaft adjuster | 154 |
| 3.5 | Removing and installing control valve from camshaft control valve 1 N205 | 158 |
| 3.6 | Removing and installing valve stem oil seals | 162 |
| 4 | Inlet and exhaust valves | 173 |
| 4.1 | Checking valve guides | 173 |
| 4.2 | Checking valves | 174 |
| 4.3 | Valve dimensions | 174 |
| 17 | Lubrication | 175 |
| 1 | Sump/oil pump | 175 |
| 1.1 | Assembly overview - sump/oil pump | 175 |
| 1.2 | Engine oil | 178 |
| 1.3 | Removing and installing sump | 178 |
| 1.4 | Removing and installing oil pump | 185 |
| 1.5 | Removing and installing oil level and oil temperature sender G266 | 185 |
| 2 | Engine oil cooler | 187 |
| 3 | Oil filter/oil pressure switches | 188 |
| 3.1 | Assembly overview - oil filter housing/oil pressure switches | 188 |
| 3.2 | Removing and installing oil pressure switch F22 | 190 |
| 3.3 | Removing and installing oil pressure switch for reduced oil pressure F378 | 193 |
| 3.4 | Removing and installing oil filter housing | 195 |
| 3.5 | Removing and installing valve for oil pressure control N428 | 197 |
| 3.6 | Checking oil pressure | 198 |

| | |
|---|------------|
| 19 - Cooling | 199 |
| 1 Cooling system/coolant | 199 |
| 1.1 Connection diagram - coolant hoses | 199 |
| 1.2 Draining and filling cooling system | 203 |
| 1.3 Checking filling quality of cooling system | 214 |
| 1.4 Checking cooling system for leaks | 216 |
| 2 Coolant pump/thermostat assembly | 219 |
| 2.1 Assembly overview - coolant pump/thermostat | 219 |
| 2.2 Assembly overview - electric coolant pump | 221 |
| 2.3 Assembly overview - coolant temperature senders | 221 |
| 2.4 Removing and installing electric coolant pump | 222 |
| 2.5 Removing and installing coolant pump | 226 |
| 2.6 Checking thermostat | 227 |
| 2.7 Removing and installing coolant valve for cylinder head N489 | 227 |
| 2.8 Removing and installing coolant temperature sender G62 | 227 |
| 3 Coolant pipes | 230 |
| 3.1 Assembly overview - coolant pipes | 230 |
| 3.2 Removing and installing coolant pipes | 232 |
| 4 Radiators/radiator fans | 247 |
| 4.1 Assembly overview - radiators/radiator fans | 247 |
| 4.2 Removing and installing radiator | 250 |
| 4.3 Removing and installing water radiator for charge air cooling circuit | 256 |
| 4.4 Removing and installing radiator cowl | 261 |
| 4.5 Removing and installing radiator fan V7 | 270 |
| 4.6 Removing and installing radiator fan 2 V177 | 271 |
| 4.7 Removing and installing radiator fan control unit | 271 |
| 21 - Turbocharging/supercharging | 274 |
| 1 Turbocharger | 274 |
| 1.1 Assembly overview - turbocharger | 274 |
| 1.2 Removing and installing turbocharger | 277 |
| 1.3 Renewing vacuum unit for turbocharger | 281 |
| 2 Charge air system | 291 |
| 2.1 Assembly overview - charge air system | 291 |
| 2.2 Removing and installing charge pressure sender G31 | 294 |
| 2.3 Removing and installing charge air temperature sender | 294 |
| 2.4 Checking charge air system for leaks | 296 |
| 23 - Mixture preparation - injection | 301 |
| 1 Injection system | 301 |
| 1.1 Overview of fitting locations - injection system | 301 |
| 1.2 Overview - fuel system | 307 |
| 1.3 Filling and bleeding fuel system | 308 |
| 1.4 Checking fuel system for leaks | 309 |
| 2 Vacuum system | 310 |
| 2.1 Connection diagram - vacuum system | 310 |
| 2.2 Checking vacuum system | 310 |
| 3 Air filter | 312 |
| 3.1 Assembly overview - air filter housing | 312 |
| 3.2 Removing and installing air filter housing | 315 |
| 4 Intake manifold | 317 |
| 4.1 Assembly overview - intake manifold | 317 |
| 4.2 Removing and installing throttle valve module J338 | 321 |
| 4.3 Removing and installing intake manifold | 323 |



| | | |
|-----------|--|------------|
| 5 | Injectors/high-pressure reservoir (rail) | 328 |
| 5.1 | Assembly overview - injectors | 328 |
| 5.2 | Assembly overview - high-pressure reservoir (rail) | 330 |
| 5.3 | Checking injectors | 332 |
| 5.4 | Performing adaption of correction values for injectors | 332 |
| 5.5 | Checking for injectors sticking open | 333 |
| 5.6 | Checking return flow rate of injectors with engine running | 335 |
| 5.7 | Checking return flow rate of injectors at starter cranking speed | 339 |
| 5.8 | Removing and installing injectors | 340 |
| 5.9 | Removing and installing high-pressure pipes | 344 |
| 5.10 | Removing and installing high-pressure reservoir (rail) | 348 |
| 6 | High-pressure pump | 350 |
| 6.1 | Assembly overview - high-pressure pump | 350 |
| 6.2 | Removing and installing high-pressure pump | 352 |
| 7 | Senders and sensors | 358 |
| 7.1 | Removing and installing fuel temperature sender G81 | 358 |
| 7.2 | Removing and installing air mass meter G70 | 359 |
| 7.3 | Checking fuel pressure regulating valve N276 | 360 |
| 7.4 | Removing and installing fuel pressure regulating valve N276 | 361 |
| 7.5 | Removing and installing fuel pressure sender G247 | 367 |
| 7.6 | Removing and installing exhaust gas pressure sensor 1 G450 | 369 |
| 7.7 | Removing and installing pressure differential sender G505 | 370 |
| 7.8 | Removing and installing NOx sender G295 | 371 |
| 8 | Lambda probe | 373 |
| 8.1 | Assembly overview - Lambda probe | 373 |
| 8.2 | Removing and installing Lambda probe | 374 |
| 9 | Engine control unit | 377 |
| 9.1 | Removing and installing engine control unit J623 | 377 |
| 26 | Exhaust system | 386 |
| 1 | Exhaust pipes/silencers | 386 |
| 1.1 | Assembly overview - silencers | 386 |
| 1.2 | Removing and installing front exhaust pipe | 390 |
| 1.3 | Separating exhaust pipes/silencers | 395 |
| 1.4 | Removing and installing silencers | 398 |
| 1.5 | Stress-free alignment of exhaust system | 399 |
| 1.6 | Checking exhaust system for leaks | 402 |
| 2 | Emission control system | 403 |
| 2.1 | Assembly overview - emission control system | 403 |
| 2.2 | Removing and installing catalytic converter | 406 |
| 2.3 | Removing and installing emission control module | 407 |
| 2.4 | Removing and installing exhaust flap control unit J883 | 430 |
| 3 | SCR (selective catalytic reduction) system | 432 |
| 3.1 | Assembly overview - reducing agent tank | 432 |
| 3.2 | Assembly overview - reducing agent supply line | 436 |
| 3.3 | Assembly overview - delivery unit for reducing agent | 437 |
| 3.4 | Assembly overview - control unit for reducing agent metering system | 439 |
| 3.5 | Disconnecting reducing agent supply line | 441 |
| 3.6 | Draining reducing agent tank | 444 |
| 3.7 | Removing and installing delivery unit for reducing agent | 447 |
| 3.8 | Removing and installing injector for reducing agent N474 | 451 |
| 3.9 | Removing and installing reducing agent tank | 454 |
| 3.10 | Removing and installing transfer pump for reducing agent V436 | 461 |
| 3.11 | Removing and installing control unit for reducing agent metering system J880 | 464 |
| 3.12 | Adapting SCR learnt values | 466 |

| | | |
|-----------|--|------------|
| 4 | Exhaust gas temperature regulation | 468 |
| 4.1 | Assembly overview - exhaust gas temperature regulation | 468 |
| 4.2 | Removing and installing parts of exhaust gas temperature regulation | 470 |
| 5 | Exhaust gas recirculation | 477 |
| 5.1 | Assembly overview - exhaust gas recirculation system | 477 |
| 5.2 | Removing and installing exhaust gas recirculation control motor V338 | 479 |
| 5.3 | Removing and installing exhaust gas recirculation control motor 2 V339 | 480 |
| 5.4 | Removing and installing exhaust gas recirculation cooler | 482 |
| 5.5 | Checking exhaust gas recirculation cooler for leaks | 484 |
| 28 | - Glow plug system | 489 |
| 1 | Glow plug system | 489 |
| 1.1 | Assembly overview - glow plug system | 489 |
| 1.2 | Removing and installing glow plug | 491 |
| 1.3 | Removing and installing automatic glow period control unit J179 | 495 |
| 1.4 | Removing and installing Hall sender G40 | 495 |
| 1.5 | Removing and installing engine speed sender G28 | 496 |