

## Contents

<b>00 - Technical data</b>	<b>1</b>
1     Identification	1
2     Safety information	2
3     Repair instructions	3
<b>10 - Removing and installing engine</b>	<b>4</b>
1     Removing and installing engine	4
1.1    Removing engine	4
1.2    Separating engine and gearbox	15
1.3    Removing engine from scissor-type assembly platform	20
1.4    Securing engine to engine and gearbox support	20
1.5    Installing engine	21
2     Assembly mountings	24
2.1    Assembly overview - assembly mountings	24
2.2    Supporting engine in installation position	26
2.3    Removing and installing engine mountings	29
2.4    Removing and installing gearbox mounting	31
3     Engine cover panel	33
<b>13 - Crankshaft group</b>	<b>34</b>
1     Cylinder block (pulley end)	34
1.1    Assembly overview - cylinder block (pulley end)	34
1.2    Assembly overview - sealing flange (pulley end)	34
1.3    Removing and installing poly V-belt	34
1.4    Removing and installing poly V-belt tensioner	34
1.5    Removing and installing vibration damper	34
1.6    Removing and installing bracket for ancillaries	37
1.7    Removing and installing engine support	37
1.8    Removing and installing sealing flange (pulley end)	39
1.9    Renewing cylinder block sealing cap (pulley end)	39
2     Cylinder block (gearbox end)	40
3     Crankshaft	41
4     Pistons and conrods	42
<b>15 - Cylinder head, valve gear</b>	<b>43</b>
1     Toothed belt drive	43
2     Cylinder head	44
2.1    Assembly overview - cylinder head cover	44
2.2    Assembly overview - cylinder head	44
2.3    Removing and installing cylinder head cover	44
2.4    Removing and installing seals for injectors	44
2.5    Removing and installing cylinder head	44
2.6    Removing and installing camshaft housing	45
2.7    Checking compression	45
3     Valve gear	46
4     Inlet and exhaust valves	47
<b>17 - Lubrication</b>	<b>48</b>
1     Sump/oil pump	48
1.1    Assembly overview - sump/oil pump	48
1.2    Engine oil	48

1.3	Removing and installing lower part of sump .....	48
1.4	Removing and installing upper part of sump .....	48
1.5	Removing and installing oil pump .....	49
1.6	Removing and installing oil level and oil temperature sender G266 .....	49
<b>2</b>	<b>Engine oil cooler .....</b>	<b>50</b>
<b>3</b>	<b>Oil filter/oil pressure switches .....</b>	<b>51</b>
3.1	Assembly overview - oil filter .....	51
3.2	Assembly overview - oil pressure switches/oil pressure control .....	51
3.3	Removing and installing oil filter housing .....	51
3.4	Removing and installing oil pressure sender G10 .....	51
3.5	Removing and installing valve for oil pressure control N428 .....	52
3.6	Checking oil pressure .....	52
3.7	Removing and installing piston cooling jet control valve N522 .....	52
<b>19 - Cooling .....</b>	<b>53</b>	
<b>1</b>	<b>Cooling system/coolant .....</b>	<b>53</b>
1.1	Connection diagram - coolant hoses .....	53
1.2	Checking cooling system for leaks .....	57
1.3	Draining and filling cooling system .....	57
1.4	Checking filling quality .....	66
1.5	Removing and installing coolant expansion tank .....	66
<b>2</b>	<b>Coolant pump/thermostat assembly .....</b>	<b>68</b>
2.1	Assembly overview - coolant pump/thermostat .....	68
2.2	Assembly overview - electric coolant pump .....	68
2.3	Assembly overview - coolant valves .....	70
2.4	Assembly overview - coolant temperature senders .....	71
2.5	Removing and installing electric coolant pump .....	71
2.6	Removing and installing coolant pump .....	75
2.7	Removing and installing mixing valve for charge air cooler .....	75
2.8	Removing and installing coolant valve for cylinder head N489 .....	77
2.9	Removing and installing coolant distribution module .....	77
2.10	Removing and installing temperature sensor G18 .....	77
2.11	Removing and installing temperature sender for engine temperature regulation G694 .....	78
2.12	Removing and installing coolant temperature sender G62 .....	79
<b>3</b>	<b>Coolant pipes .....</b>	<b>80</b>
3.1	Assembly overview - coolant pipes .....	80
3.2	Removing and installing coolant pipes .....	81
3.3	Removing and installing coolant pipes for gearbox .....	83
<b>4</b>	<b>Radiators/radiator fans .....</b>	<b>85</b>
4.1	Assembly overview - radiators/radiator fan .....	85
4.2	Removing and installing radiator .....	89
4.3	Removing and installing water radiator for charge air cooling circuit .....	94
4.4	Removing and installing radiator cowl .....	96
4.5	Removing and installing radiator fans .....	99
<b>21 - Turbocharging/supercharging .....</b>	<b>101</b>	
<b>1</b>	<b>Turbocharger .....</b>	<b>101</b>
<b>2</b>	<b>Charge air system .....</b>	<b>102</b>
2.1	Assembly overview - charge air system .....	102
2.2	Assembly overview - hose connections for charge air system .....	102
2.3	Removing and installing charge pressure sender G31 .....	102
2.4	Removing and installing air intake pipe .....	102
2.5	Removing and installing charge air temperature sender .....	102
2.6	Checking charge air system for leaks .....	102

<b>23 - Mixture preparation - injection</b>	<b>103</b>
<b>1 Injection system</b>	<b>103</b>
1.1 Overview - fuel system	103
1.2 Overview of fitting locations - injection system	104
1.3 Filling and bleeding fuel system	114
1.4 Checking fuel system for leaks	114
<b>2 Air filter</b>	<b>115</b>
2.1 Assembly overview - air filter housing	115
2.2 Removing and installing air filter housing	117
<b>3 Intake manifold</b>	<b>119</b>
3.1 Assembly overview - intake manifold	119
3.2 Removing and installing throttle valve module GX3	119
3.3 Removing and installing intake manifold	119
<b>4 Injectors/high-pressure reservoir (rail)</b>	<b>121</b>
4.1 Assembly overview - injectors	121
4.2 Assembly overview - high-pressure reservoir (rail)	121
4.3 Checking injectors	121
4.4 Removing and installing injectors	121
4.5 Removing and installing high-pressure pipes	121
4.6 Removing and installing high-pressure reservoir (rail)	122
<b>5 High-pressure pump</b>	<b>123</b>
<b>6 Senders and sensors</b>	<b>124</b>
6.1 Removing and installing air mass meter G70	124
6.2 Removing and installing fuel pressure sender G247	125
6.3 Removing and installing temperature and pressure sender for low-pressure fuel system GX20	125
6.4 Removing and installing pressure differential sender G505	125
6.5 Checking fuel pressure regulating valve N276	125
6.6 Removing and installing fuel pressure regulating valve N276	126
<b>7 Lambda probe</b>	<b>127</b>
7.1 Assembly overview - Lambda probe	127
7.2 Removing and installing Lambda probe	128
7.3 Removing and installing NOx senders	128
7.4 Removing and installing particulate sensor G784	130
<b>8 Engine control unit</b>	<b>131</b>
8.1 Assembly overview - engine control unit	131
8.2 Removing and installing engine control unit J623	131
<b>26 - Exhaust system</b>	<b>133</b>
<b>1 Exhaust pipes/silencers</b>	<b>133</b>
1.1 Assembly overview - silencer	133
1.2 Removing and installing front exhaust pipe	137
1.3 Removing and installing silencers	137
1.4 Stress-free alignment of exhaust system	139
1.5 Checking exhaust system for leaks	140
<b>2 Emission control system</b>	<b>141</b>
2.1 Assembly overview - emission control system	141
2.2 Removing and installing catalytic converter	141
2.3 Removing and installing particulate filter	141
2.4 Removing and installing ammonia trap	141
2.5 Removing and installing exhaust flap control unit J883	141
<b>3 SCR (selective catalytic reduction) system</b>	<b>142</b>
3.1 Assembly overview - reducing agent tank	142

3.2	Assembly overview - reducing agent supply line .....	144
3.3	Assembly overview - injector for reducing agent .....	145
3.4	Assembly overview - delivery unit .....	145
3.5	Disconnecting reducing agent supply line .....	147
3.6	Releasing pressure in SCR system .....	147
3.7	Draining reducing agent tank .....	147
3.8	Removing and installing reducing agent tank .....	150
3.9	Removing and installing injector for reducing agent N474 .....	151
3.10	Removing and installing injector 2 for reducing agent N758 .....	151
3.11	Removing and installing control unit for reducing agent metering system J880 .....	151
3.12	Removing and installing pump for reducing agent V437 .....	152
3.13	Removing and installing pressure sender for reducing agent metering system G686 .....	154
3.14	Removing and installing connection for SCR supply line .....	157
<b>4</b>	<b>Exhaust gas temperature regulation .....</b>	<b>159</b>
4.1	Assembly overview - exhaust gas temperature regulation .....	159
4.2	Removing and installing parts of exhaust gas temperature regulation .....	159
<b>5</b>	<b>Exhaust gas recirculation .....</b>	<b>160</b>
5.1	Assembly overview - exhaust gas recirculation system .....	160
5.2	Removing and installing exhaust gas recirculation control motor V338 .....	160
5.3	Removing and installing exhaust gas recirculation control motor 2 V339 .....	160
5.4	Removing and installing exhaust gas recirculation cooler .....	160
5.5	Checking exhaust gas recirculation cooler for leaks .....	161
<b>28 - Glow plug system .....</b>	<b>162</b>	
<b>1</b>	<b>Glow plug system .....</b>	<b>162</b>
1.1	Assembly overview - glow plug system .....	162
1.2	Removing and installing glow plug .....	162
1.3	Removing and installing automatic glow period control unit J179 .....	162
1.4	Removing and installing Hall sender G40 .....	162
1.5	Removing and installing engine speed sender G28 .....	162