

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 working on vehicles with start/stop system	2
2.3 Safety precautions when using testers and measuring instruments during a road test	3
2.4 Safety precautions when working on the cooling system	3
2.5 Safety precautions when working on the exhaust system	3
2.6 Safety precautions when working on the SCR system	4
2.7 Safety precautions when working on the glow plug system	5
2.8 Safety precautions when working on the subframe	5
3 Repair instructions	6
3.1 Identification plates	6
3.2 Use of impact wrenches	6
3.3 Nuts, bolts	7
3.4 Rules for cleanliness	7
3.5 General notes	8
3.6 General repair instructions	9
3.7 Foreign material in engine	10
3.8 Contact corrosion	10
3.9 Routing and attachment of pipes, hoses and wiring	11
3.10 Installing radiators and condensers	11
3.11 Performing adaptations after renewing a component	11
3.12 Adapting learnt values for SCR system	12
3.13 Checking vacuum system	12
10 - Removing and installing engine	14
1 Removing and installing engine	14
2 Assembly mountings	15
13 - Crankshaft group	16
1 Cylinder block (pulley end)	16
1.1 Assembly overview - cylinder block (pulley end)	16
1.2 Assembly overview - sealing flange (pulley end)	22
1.3 Removing and installing poly V-belts	23
1.4 Removing and installing poly V-belt tensioner	25
1.5 Removing and installing bracket for ancillaries	27
1.6 Removing and installing engine support	28
1.7 Removing and installing pulley	28
1.8 Renewing crankshaft oil seal (pulley end)	31
1.9 Removing and installing sealing flange (pulley end)	33
2 Cylinder block (gearbox end)	35
2.1 Assembly overview - cylinder block (gearbox end)	35
2.2 Removing and installing drive plate	35
2.3 Renewing crankshaft oil seal (gearbox end)	37
3 Crankshaft	40
3.1 Assembly overview - crankshaft	40
3.2 Crankshaft dimensions	42
3.3 Allocation of main bearing shells	42
3.4 Measuring axial clearance of crankshaft	44
3.5 Measuring radial clearance of crankshaft	45



3.6	Checking sender wheel	45
4	Transmission shaft	47
4.1	Assembly overview - transmission shaft	47
4.2	Removing and installing transmission shaft	47
4.3	Removing and installing gear wheel for coolant pump drive	48
4.4	Renewing roller bearing	48
5	Pistons and conrods	51
5.1	Assembly overview - pistons and conrods	51
5.2	Removing and installing pistons	53
5.3	Removing and installing oil spray jets	57
5.4	Measuring piston projection at TDC	58
5.5	Checking pistons and cylinder bores	60
5.6	Checking radial clearance of conrod bearings	62
15	- Cylinder head, valve gear	63
1	Timing chain cover	63
1.1	Assembly overview - timing chain cover	63
1.2	Removing and installing timing chain cover	67
2	Chain drive	77
2.1	Assembly overview - camshaft timing chains	77
2.2	Assembly overview - drive chain for high-pressure pump	79
2.3	Assembly overview - drive chain for oil pump	80
2.4	Removing camshaft timing chain from camshafts	81
2.5	Removing and installing camshaft timing chain	94
2.6	Removing and installing drive chain for high-pressure pump	104
2.7	Installing intermediate drive	106
3	Cylinder head	113
3.1	Assembly overview - cylinder head	113
3.2	Assembly overview - cylinder head cover	115
3.3	Removing and installing cylinder head	118
3.4	Removing and installing cylinder head cover	128
3.5	Removing and installing seals for injectors	135
3.6	Checking compression	136
4	Valve gear	138
4.1	Assembly overview - valve gear	138
4.2	Measuring axial clearance of camshaft	146
4.3	Measuring radial clearance of camshaft	148
4.4	Removing and installing camshaft	148
4.5	Removing and installing cam actuators	163
4.6	Removing and installing valve stem oil seals	169
5	Inlet and exhaust valves	180
5.1	Reworking valve seats	180
5.2	Checking valve guides	180
5.3	Checking valves	181
5.4	Valve dimensions	181
17	- Lubrication	182
1	Sump/oil pump	182
1.1	Assembly overview - sump/oil pump	182
1.2	Engine oil	188
1.3	Removing and installing lower part of sump	188
1.4	Removing and installing upper part of sump	190
1.5	Removing and installing oil pump	195
1.6	Removing and installing oil level and oil temperature sender G266	197
2	Engine oil cooler	199

2.1	Assembly overview - engine oil cooler	199
2.2	Removing and installing engine oil cooler	200
3	Crankcase breather	203
3.1	Assembly overview - crankcase breather system	203
3.2	Removing and installing crankcase breather module	203
4	Oil filter/oil pressure switches	205
4.1	Assembly overview - oil filter	205
4.2	Removing and installing oil temperature sender G8	205
4.3	Removing and installing oil pressure sender G10	206
4.4	Checking oil pressure	207
4.5	Removing and installing oil filter housing	208
4.6	Removing and installing valve for oil pressure control N428	209
19	Cooling	210
1	Cooling system/coolant	210
1.1	Connection diagram - coolant hoses	210
1.2	Checking cooling system for leaks	210
1.3	Draining and filling cooling system	213
2	Coolant pump/thermostat assembly	217
2.1	Assembly overview - coolant pump	217
2.2	Assembly overview - electric coolant pump	218
2.3	Assembly overview - thermostat	218
2.4	Assembly overview - coolant valves	220
2.5	Assembly overview - coolant temperature senders	220
2.6	Removing and installing electric coolant pump	220
2.7	Removing and installing coolant pump	221
2.8	Removing and installing housing for map-controlled engine cooling system thermostat F265	222
2.9	Removing and installing coolant temperature senders G62/G83	226
2.10	Removing and installing coolant temperature sender 3 G812	227
2.11	Removing and installing coolant valves	227
3	Coolant pipes	233
4	Radiators/radiator fans	234
21	Turbocharging/supercharging	235
1	Turbochargers	235
1.1	Assembly overview - turbochargers	235
1.2	Assembly overview - electric compressor/control unit for electric compressor J1123	244
1.3	Assembly overview - charge air recirculation module GX37	245
1.4	Removing and installing turbochargers	246
1.5	Removing and installing electric compressor with control unit for electric compressor J1123	254
1.6	Removing and installing charge air recirculation module GX37	257
1.7	Removing and installing sender 1 for turbocharger speed G688	259
1.8	Removing and installing sender 2 for turbocharger speed G689	259
1.9	Removing and installing temperature sender for engine cover panel G765	261
2	Charge air system	263
2.1	Assembly overview - charge air system	263
2.2	Assembly overview - hose connections for charge air system	266
2.3	Removing and installing charge air cooler	267
2.4	Checking charge air system for leaks	267
23	Mixture preparation - injection	269
1	Injection system	269
1.1	Overview - fuel system	269



1.2	Overview of fitting locations - injection system	269
1.3	Filling and bleeding fuel system	269
1.4	Checking fuel system for leaks	270
2	Vacuum system	271
2.1	Connection diagram - vacuum system	271
2.2	Checking vacuum system	271
3	Air filter	272
4	Intake manifold	273
4.1	Assembly overview - intake manifold	273
4.2	Removing and installing intake manifold	274
4.3	Removing and installing intake manifold flap control unit GX14 / intake manifold flap control unit 2 GX15	278
4.4	Removing and installing throttle valve module GX3 / throttle valve module 2 GX4	280
5	Injectors/high-pressure reservoir (rail)	281
5.1	Assembly overview - injectors	281
5.2	Checking injectors	285
5.3	Performing adaption of correction values for injectors	286
5.4	Checking return flow rate of injectors with engine running	287
5.5	Checking return flow rate of injectors at starter cranking speed	290
5.6	Checking pressure retention valve in fuel return line	294
5.7	Checking for injectors sticking open	295
5.8	Removing and installing injectors	298
5.9	Removing and installing high-pressure pipes	305
5.10	Removing and installing high-pressure reservoir (rail)	307
6	Senders and sensors	312
6.1	Removing and installing intake air temperature sender G42 / intake air temperature sender 2 G299	312
6.2	Removing and installing air mass meter G70 / air mass meter 2 G246	312
6.3	Removing and installing intake manifold pressure sender G71	312
6.4	Removing and installing fuel temperature sender G81	313
6.5	Removing and installing fuel pressure sender G247	314
6.6	Removing and installing fuel pressure sender for low pressure G410	316
6.7	Checking fuel pressure regulating valve N276	317
6.8	Removing and installing fuel pressure regulating valve N276	317
7	High-pressure pump	321
7.1	Assembly overview - high-pressure pump	321
7.2	Removing and installing high-pressure pump	324
8	Lambda probe	331
8.1	Assembly overview - Lambda probe	331
8.2	Removing and installing Lambda probe	331
8.3	Removing and installing NOx senders	334
8.4	Removing and installing particulate sensor G784	334
9	Engine control unit	335
26	Exhaust system	336
1	Exhaust pipes/silencers	336
1.1	Assembly overview - silencers	336
1.2	Removing and installing front exhaust pipe	336
1.3	Separating exhaust pipes/silencers	336
1.4	Removing and installing silencers	336
1.5	Stress-free alignment of exhaust system	336
1.6	Checking exhaust system for leaks	336
2	Emission control system	337
3	SCR (selective catalytic reduction) system	338

3.1	Assembly overview - reducing agent tank	338
3.2	Assembly overview - reducing agent supply line	338
3.3	Assembly overview - injector for reducing agent	338
3.4	Assembly overview - control unit for reducing agent metering system	339
3.5	Draining reducing agent tank	339
3.6	Removing and installing reducing agent tank	339
3.7	Removing and installing injector for reducing agent N474	340
3.8	Removing and installing control unit for reducing agent metering system J880	341
4	Exhaust gas temperature regulation	342
4.1	Assembly overview - exhaust gas temperature regulation	342
4.2	Removing and installing parts of exhaust gas temperature regulation	345
5	Exhaust gas recirculation	356
5.1	Assembly overview - exhaust gas recirculation system	356
5.2	Removing and installing exhaust gas recirculation cooler	358
5.3	Removing and installing exhaust gas recirculation temperature sensor G98	360
5.4	Removing and installing pressure sender for exhaust gas recirculation G691	361
6	Exhaust manifolds	364
6.1	Assembly overview - exhaust manifolds	364
6.2	Removing and installing exhaust manifolds	368
28	Glow plug system	375
1	Glow plug system	375
1.1	Assembly overview - glow plug system	375
1.2	Removing and installing glow plug	377
1.3	Removing and installing Hall sender G40	380
1.4	Removing and installing engine speed sender G28	381