



Contents

00 - Technical data	1
1 Safety information	1
1.1 Safety precautions when working on the fuel supply system	1
1.2 Safety measures when working on vehicles with a start/stop system	2
1.3 Safety precautions when using testers and measuring instruments during a road test	2
1.4 Safety precautions when working on the cooling system	2
1.5 Safety precautions when working on selective catalytic reduction (SCR) system	3
1.6 Safety precautions when working on the ignition system	3
1.7 Safety precautions when working on the exhaust system	4
2 Identification	5
2.1 Engine number/engine data	5
3 Repair notes	6
3.1 Rules for cleanliness	6
3.2 General information	6
3.3 General repair instructions	7
3.4 Foreign material in engine	7
3.5 Contact corrosion	7
3.6 Routing and attachment of lines	8
3.7 Fitting radiator and condensers	8
3.8 Checking vacuum system	8
10 - Removing and installing engine	9
1 Removing and installing engine	9
1.1 Removing motor	9
1.2 Separating engine and gearbox	16
1.3 Securing engine on engine and gearbox support	17
1.4 Installing motor	18
2 Assembly mountings	22
2.1 Assembly overview - assembly mountings	22
2.2 Removing and installing engine mounting	29
2.3 Removing and installing engine mounting	34
2.4 Removing and installing gearbox mounting	34
2.5 Removing and installing damper weight	35
2.6 Supporting engine in installation position	35
3 Engine cover panel	39
3.1 Assembly overview – engine cover panel	39
3.2 Removing and installing engine cover panel	39
13 - Crankshaft group	40
1 Cylinder block, pulley end	40
1.1 Assembly overview – cylinder block, pulley end	40
1.2 Assembly overview – sealing flange, pulley end	43
1.3 Removing and installing poly-V belt	44
1.4 Removing and installing poly V-belt tensioner	47
1.5 Removing and installing vibration damper	47
1.6 Removing and installing bracket for ancillaries	50
1.7 Removing and installing engine support	51
1.8 Removing and installing sealing flange, pulley end	56
1.9 Renewing caps in cylinder block, pulley end	58
2 Cylinder block, gearbox side	60
2.1 Assembly overview – cylinder block, gearbox side	60
2.2 Removing and installing flywheel	62



2.3	Removing and installing sealing flange on gearbox side	64
2.4	Renewing caps in cylinder block (gearbox end)	79
3	Crankshaft	81
3.1	Assembly overview - crankshaft	81
3.2	Crankshaft dimensions	83
3.3	Renewing needle bearing in crankshaft	83
3.4	Measuring axial clearance of crankshaft	85
3.5	Measuring radial clearance of crankshaft	85
3.6	Removing and installing crankshaft	86
4	Pistons and conrods	88
4.1	Assembly overview – pistons and conrods	88
4.2	Removing and installing pistons	90
4.3	Measuring piston projection at TDC	91
4.4	Checking piston and cylinder bore	94
4.5	Separating new conrod	96
4.6	Checking radial clearance of conrods	96
4.7	Removing and installing oil spray jets	96
15	Cylinder head, valve gear	98
1	Cylinder head	98
1.1	Assembly overview – cylinder head	98
1.2	Assembly overview – camshaft housing	100
1.3	Assembly overview - cylinder head cover	102
1.4	Removing and installing cylinder head	105
1.5	Removing and installing cylinder head cover	112
1.6	Removing and installing injector seals	113
1.7	Removing and installing camshaft housing	114
1.8	Checking compression	119
1.9	Checking combustion chamber for leaks	120
2	Toothed belt drive	123
2.1	Assembly overview – toothed belt cover	123
2.2	Assembly overview – toothed belt	123
2.3	Removing and installing toothed belt guard	125
2.4	Removing and installing toothed belt	128
2.5	Removing toothed belt from camshaft	139
3	Valve gear	144
3.1	Assembly overview – valve gear	144
3.2	Measuring axial play of camshaft	146
3.3	Removing and installing camshaft oil seal	147
3.4	Checking hydraulic compensation elements	149
3.5	Removing and installing valve stem oil seals	149
3.6	Removing and installing roller rocker fingers and hydraulic compensation elements	160
4	Inlet and exhaust valves	161
4.1	Checking valve guides	161
4.2	Checking valves	162
4.3	Valve dimensions	162
17	Lubrication	163
1	Sump, oil pump	163
1.1	Assembly overview – sump/oil pump	163
1.2	Engine oil	167
1.3	Removing and installing oil sump	167
1.4	Removing and installing oil pump	172
1.5	Removing and installing oil level and oil temperature sender G266	173
1.6	Removing and installing oil pump drive pulley	173



2	Engine oil cooler	178
3	Oil filter, oil pressure switch	179
3.1	Assembly overview - oil filter housing, oil pressure switch	179
3.2	Removing and installing oil pressure sender G10	181
3.3	Checking oil pressure	182
3.4	Removing and installing oil filter housing	182
3.5	Removing and installing valve for oil pressure control N428	184
4	Oil circuit	185
4.1	Assembly overview - oil circuit	185
4.2	Removing and installing oil supply lines	188
4.3	Removing and installing oil return line for turbocharger	190
19	Cooling	194
1	Cooling system/coolant	194
1.1	Connection diagram – coolant hoses	194
1.2	Draining and filling cooling system	218
1.3	Checking coolant level and topping up if necessary	226
1.4	Checking cooling system for leaks	227
1.5	Removing and installing coolant expansion tank	229
1.6	Assembly overview - coolant expansion tank	231
2	Coolant pump, regulation of cooling system	233
2.1	Assembly overview – coolant pump/thermostat	233
2.2	Assembly overview – electric coolant pump	234
2.3	Assembly overview – coolant temperature sender	239
2.4	Assembly overview – mixing valve for coolant regulation GX40	241
2.5	Assembly overview – 3/2-way valve	242
2.6	Assembly overview – thermostat	244
2.7	Removing and installing electric coolant pump	245
2.8	Removing and installing coolant pump	250
2.9	Removing and installing thermostat	250
2.10	Removing and installing mixing valve for coolant regulation GX40	252
2.11	Removing and installing thermostat	254
2.12	Removing and installing coolant temperature sender G62	257
2.13	Removing and installing radiator outlet coolant temperature sender G83	257
2.14	Removing and installing coolant temperature sender 2 G802	258
2.15	Removing and installing coolant temperature sender for charge air cooler G1130	260
2.16	Removing and installing coolant temperature sender 3 G812	261
2.17	Removing and installing 3/2-way valve	261
3	Coolant pipes	266
3.1	Assembly overview – coolant pipes	266
3.2	Removing and installing coolant pipes	271
4	Radiator, radiator fan	273
4.1	Assembly overview - radiator/radiator fan	273
4.2	Assembly overview - radiator cowl and radiator fans	275
4.3	Removing and installing radiator	276
4.4	Removing and installing radiator cowl with radiator fans	283
4.5	Removing and installing radiator fan V7	283
21	Turbocharging/supercharging	284
1	Turbocharger	284
1.1	Assembly overview – turbocharger	284
1.2	Removing and installing turbocharger	292
1.3	Checking vacuum unit for turbocharger, biturbo	300
1.4	Removing and installing connecting pipes	307
1.5	Removing and installing compressor housing and turbine housing, biturbo	309



1.6	Removing and installing connection for turbocharger	309
1.7	Removing and installing charge pressure control module GX34	311
2	Charge air system	314
2.1	Assembly overview – charge air system	314
2.2	Removing and installing charge air cooler	318
2.3	Removing and installing charge pressure sender G31	321
2.4	Removing and installing charge pressure sender 2 G447	322
2.5	Checking charge air system for leaks	322
2.6	Detaching and securing charge air cooler	324
2.7	Removing and installing bracket for charge air cooler	326
2.8	Checking charge air cooler for leaks	328
23	Mixture preparation - injection	331
1	Injection system	331
1.1	Filling/bleeding fuel system	331
1.2	Checking fuel system for leaks	331
2	Vacuum system	333
2.1	Connection diagram - vacuum system	333
2.2	Assembly overview - vacuum system	335
2.3	Removing and installing solenoid valve N274 / N529	340
3	Injectors/high-pressure reservoir (rail)	341
3.1	Assembly overview – injectors	341
3.2	Assembly overview - fuel rail	343
3.3	Adapting correction values for injectors	345
3.4	Testing injectors	345
3.5	Checking open injectors	346
3.6	Checking return flow rate of injectors with engine running	347
3.7	Checking return flow rate of injectors at starter speed	350
3.8	Removing and installing injectors	351
3.9	Removing and installing high-pressure lines	355
3.10	Removing and installing fuel rail	361
4	Air filter	363
4.1	Assembly overview – air filter housing	363
4.2	Removing and installing air filter housing	368
5	Intake manifold	370
5.1	Assembly overview – intake manifold	370
5.2	Removing and installing intake manifold	372
5.3	Removing and installing throttle valve module GX3	375
5.4	Removing and installing intake manifold flap valve N316	375
6	Senders and sensors	377
6.1	Removing and installing fuel pressure regulating valve N276	377
6.2	Checking fuel pressure regulating valve N276	379
6.3	Removing and installing fuel pressure sender G247	381
6.4	Removing and installing air mass meter G70	383
6.5	Removing and installing pressure differential sender G505	384
6.6	Removing and installing charge air temperature sender before charge air cooler G810	385
6.7	Removing and installing charge air temperature sender after charge air cooler G811	386
6.8	Removing and installing temperature and pressure sender for low-pressure fuel system GX20	386
6.9	Removing and installing control unit for sensor electronics J849 / particulate sensor G784	387
6.10	Removing and installing NOx sender G295	388
6.11	Removing and installing NOx sender 2 G687	389
6.12	Removing and installing NOx sender 3 G932	391
6.13	Assembly overview – emission senders	392



7	Engine/motor control unit	394
7.1	Removing and installing motor control unit J623	394
7.2	Removing and installing engine control unit J623 (with protective housing)	395
8	High-pressure pump	400
8.1	Assembly overview – high-pressure pump	400
8.2	Removing and installing high-pressure pump	402
9	Lambda probe	409
9.1	Assembly overview – lambda probe	409
9.2	Removing and installing Lambda probe GX10	411
26	Exhaust system	412
1	Exhaust pipes and silencers	412
1.1	Assembly overview – silencers	412
1.2	Assembly overview - front exhaust pipe	413
1.3	Removing and installing front exhaust pipe	415
1.4	Separating exhaust pipes from silencers	416
1.5	Removing and installing front silencer	417
1.6	Removing and installing rear silencer	418
1.7	Aligning exhaust system free of stress	419
1.8	Checking exhaust system for leaks	420
1.9	Installation position of clamp	420
2	Emission control	421
2.1	Assembly overview – emission control	421
2.2	Removing and installing emission control module	428
2.3	Removing and installing exhaust flap control unit J883	431
3	SCR system (selective catalytic reduction)	433
3.1	Assembly overview – reducing agent tank	433
3.2	Assembly overview - delivery module for reducing agent	435
3.3	Assembly overview – filler tube for reducing agent tank	436
3.4	Assembly overview - injector for reducing agent N474	437
3.5	Assembly overview – injector 2 for reducing agent N758	438
3.6	Removing and installing reducing agent tank VX85	439
3.7	Removing and installing reducing agent supply line	441
3.8	Removing and installing delivery unit for reducing agent metering system GX19	444
3.9	Removing and installing injector for reducing agent N474	447
3.10	Removing and installing injector 2 for reducing agent N758	450
3.11	Removing and installing control unit for reducing agent heater J891	451
3.12	Draining reducing agent tank VX85	451
3.13	Removing and installing filler pipe for tank for reducing agent	453
4	Exhaust gas temperature regulation	455
4.1	Assembly overview – exhaust gas temperature regulation	455
4.2	Removing and installing exhaust gas temperature sender 1 G235	458
4.3	Removing and installing exhaust gas temperature sender 2 G448	462
4.4	Removing and installing exhaust gas temperature sender 3 G495	465
4.5	Removing and installing exhaust gas temperature sender 4 G648	467
5	Exhaust gas recirculation	468
5.1	Assembly overview – exhaust gas recirculation	468
5.2	Removing and installing exhaust gas recirculation cooler	473
5.3	Removing and installing exhaust gas recirculation pipes	477
5.4	Removing and installing temperature sensor 2 for exhaust gas recirculation G690	481
5.5	Removing and installing exhaust gas recirculation temperature sensor G98	482
5.6	Removing and installing exhaust gas recirculation valve	482
5.7	Flushing exhaust gas recirculation cooler and exhaust gas recirculation valves GX5 / GX48	486
6	Heat insulation mats	490



6.1	Assembly overview – heat insulation mats	490
6.2	Heat insulation mat, emission control module	490
28	- Glow plug system	496
1	Glow plug system	496
1.1	Assembly overview – glow plug system	496
1.2	Removing and installing glow plug	498
1.3	Checking glow plug	503
1.4	Removing and installing automatic glow period control unit J179	504
1.5	Removing and installing inlet camshaft position sender G1002	504
1.6	Removing and installing engine speed sender G28	504