



## Contents

<b>00 - Technical data</b>	<b>1</b>
<b>1 Safety information</b>	<b>1</b>
1.1 Safety precautions when working on the fuel supply system	1
1.2 Safety measures when working on vehicles with 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 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
<b>2 Identification</b>	<b>5</b>
2.1 Engine number/engine data	5
<b>3 Repair notes</b>	<b>7</b>
3.1 Rules for cleanliness	7
3.2 General information	7
3.3 General repair instructions	8
3.4 Foreign material in engine	8
3.5 Contact corrosion	8
3.6 Routing and attachment of lines	9
3.7 Fitting radiator and condensers	9
3.8 Checking vacuum system	9
3.9 Instructions for checking Delphi injection system for suspected damage to high-pressure pump	10
<b>10 - Removing and installing engine</b>	<b>15</b>
<b>1 Removing and installing engine</b>	<b>15</b>
1.1 Removing motor	15
1.2 Separating engine and gearbox	23
1.3 Securing engine on engine and gearbox support	25
1.4 Installing motor	26
<b>2 Assembly mountings</b>	<b>30</b>
2.1 Assembly overview – assembly mountings	30
2.2 Removing and installing engine mounting	40
2.3 Removing and installing engine mounting	45
2.4 Removing and installing gearbox mounting	46
2.5 Removing and installing damper weight	47
2.6 Supporting engine in installation position	47
<b>3 Engine cover panel</b>	<b>51</b>
3.1 Assembly overview – engine cover panel	51
3.2 Removing and installing engine cover	51
<b>13 - Crankshaft group</b>	<b>52</b>
<b>1 Cylinder block, pulley end</b>	<b>52</b>
1.1 Assembly overview – cylinder block, pulley end	52
1.2 Assembly overview – sealing flange, pulley end	57
1.3 Removing and installing poly-V belt	58
1.4 Removing and installing poly V-belt tensioner	61
1.5 Removing and installing vibration damper	62
1.6 Removing and installing bracket for ancillaries	64
1.7 Removing and installing engine support	67
1.8 Removing and installing sealing flange, pulley end	75
1.9 Renewing caps in cylinder block, pulley end	77
<b>2 Cylinder block, gearbox side</b>	<b>79</b>



2.1	Assembly overview – cylinder block, gearbox side	79
2.2	Removing and installing flywheel	80
2.3	Removing and installing sealing flange on gearbox side	81
2.4	Renewing caps in cylinder block (gearbox end)	96
<b>3</b>	<b>Crankshaft</b>	<b>98</b>
3.1	Assembly overview - crankshaft	98
3.2	Crankshaft dimensions	100
3.3	Renewing needle bearing in crankshaft	100
3.4	Measuring axial clearance of crankshaft	102
3.5	Measuring radial clearance of crankshaft	102
3.6	Removing and installing crankshaft	103
<b>4</b>	<b>Pistons and conrods</b>	<b>105</b>
4.1	Assembly overview – pistons and conrods	105
4.2	Removing and installing pistons	107
4.3	Measuring piston projection at TDC	108
4.4	Checking piston and cylinder bore	111
4.5	Separating new conrod	113
4.6	Checking radial clearance of conrods	113
4.7	Removing and installing oil spray jets	113
<b>15</b>	<b>Cylinder head, valve gear</b>	<b>115</b>
<b>1</b>	<b>Cylinder head</b>	<b>115</b>
1.1	Assembly overview – cylinder head	115
1.2	Assembly overview – camshaft housing	117
1.3	Assembly overview - cylinder head cover	119
1.4	Removing and installing cylinder head	122
1.5	Removing and installing cylinder head cover	129
1.6	Removing and installing injector seals	130
1.7	Removing and installing camshaft housing	131
1.8	Checking compression	136
<b>2</b>	<b>Toothed belt drive</b>	<b>138</b>
2.1	Assembly overview – toothed belt cover	138
2.2	Assembly overview – toothed belt	138
2.3	Removing and installing toothed belt guard	141
2.4	Removing and installing toothed belt	145
2.5	Removing toothed belt from camshaft	156
<b>3</b>	<b>Valve gear</b>	<b>161</b>
3.1	Assembly overview – valve gear	161
3.2	Measuring axial play of camshaft	163
3.3	Removing and installing camshaft oil seal	164
3.4	Checking hydraulic compensation elements	165
3.5	Removing and installing valve stem oil seals	166
3.6	Removing and installing roller rocker fingers and hydraulic compensation elements	177
<b>4</b>	<b>Inlet and exhaust valves</b>	<b>178</b>
4.1	Checking valve guides	178
4.2	Checking valves	179
4.3	Valve dimensions	179
<b>17</b>	<b>Lubrication</b>	<b>180</b>
<b>1</b>	<b>Sump, oil pump</b>	<b>180</b>
1.1	Assembly overview – sump/oil pump	180
1.2	Engine oil	186
1.3	Removing and installing sump	186
1.4	Removing and installing oil pump	191
1.5	Removing and installing oil level and oil temperature sender G266	192



1.6	Removing and installing oil pump drive pulley	193
<b>2</b>	<b>Engine oil cooler</b>	<b>198</b>
<b>3</b>	<b>Oil filter, oil pressure switch</b>	<b>199</b>
3.1	Assembly overview - oil filter housing, oil pressure switch	199
3.2	Removing and installing oil pressure switch F1	201
3.3	Removing and installing oil pressure switch for reduced oil pressure F378	202
3.4	Checking oil pressure	203
3.5	Removing and installing oil filter housing	204
3.6	Removing and installing valve for oil pressure control N428	205
<b>4</b>	<b>Oil circuit</b>	<b>207</b>
4.1	Assembly overview - oil circuit	207
4.2	Removing and installing oil supply line	210
4.3	Removing and installing oil return line for turbocharger	213
<b>19</b>	<b>Cooling</b>	<b>217</b>
<b>1</b>	<b>Cooling system/coolant</b>	<b>217</b>
1.1	Connection diagram – coolant hoses	217
1.2	Draining and filling cooling system	241
1.3	Checking coolant level and topping up if necessary	247
1.4	Checking cooling system for leaks	248
1.5	Removing and installing coolant expansion tank	249
1.6	Assembly overview - coolant expansion tank	253
<b>2</b>	<b>Coolant pump, regulation of cooling system</b>	<b>255</b>
2.1	Assembly overview – coolant pump/thermostat	255
2.2	Assembly overview – electric coolant pump	257
2.3	Assembly overview – coolant temperature sender	264
2.4	Assembly overview – coolant valves, 3/2-way valve	267
2.5	Removing and installing electric coolant pump	268
2.6	Removing and installing coolant pump	274
2.7	Removing and installing thermostat housing	275
2.8	Checking thermostat	278
2.9	Removing and installing coolant valve for cylinder head N489	278
2.10	Removing and installing coolant temperature sender G62	279
2.11	Removing and installing radiator outlet coolant temperature sender G83	280
2.12	Removing and installing coolant temperature sender 3 G812	282
2.13	Removing and installing 3/2-way valve	285
<b>3</b>	<b>Coolant pipes</b>	<b>290</b>
3.1	Assembly overview – coolant pipes	290
3.2	Removing and installing coolant pipes	297
<b>4</b>	<b>Radiator, radiator fan</b>	<b>299</b>
4.1	Assembly overview - radiator/radiator fan	299
4.2	Assembly overview - radiator cowl and radiator fans	302
4.3	Removing and installing radiator	303
4.4	Removing and installing radiator cowl with radiator fans	316
4.5	Removing and installing radiator fan V7	317
<b>21</b>	<b>Turbocharging/supercharging</b>	<b>318</b>
<b>1</b>	<b>Turbocharger</b>	<b>318</b>
1.1	Assembly overview – turbocharger	318
1.2	Removing and installing turbocharger	327
1.3	Renewing vacuum unit for turbocharger	337
1.4	Removing and installing connecting pipes	350
1.5	Removing and installing compressor housing and turbine housing, biturbo	355
<b>2</b>	<b>Charge air system</b>	<b>356</b>
2.1	Assembly overview – charge air system	356



2.2	Removing and installing charge air cooler	362
2.3	Removing and installing charge pressure sender G31	370
2.4	Removing and installing charge pressure sender 2 G447	371
2.5	Checking charge air system for leaks	372
2.6	Removing and installing air intake pipe	374
2.7	Detaching and securing charge air cooler	374
2.8	Removing and installing bracket for charge air cooler	380
2.9	Checking charge air cooler for leaks	383
<b>23</b>	<b>Mixture preparation - injection</b>	<b>386</b>
<b>1</b>	<b>Injection system</b>	<b>386</b>
1.1	Overview of fitting locations - injection system	386
1.2	Filling/bleeding fuel system	401
1.3	Checking fuel system for leaks	402
<b>2</b>	<b>Vacuum system</b>	<b>403</b>
2.1	Connection diagram - vacuum system	403
2.2	Assembly overview - vacuum system	407
2.3	Removing and installing solenoid valve	416
<b>3</b>	<b>Injectors/high-pressure reservoir (rail)</b>	<b>419</b>
3.1	Assembly overview – injectors	419
3.2	Assembly overview - fuel rail	421
3.3	Adapting correction values for injectors	423
3.4	Testing injectors	423
3.5	Checking open injectors	424
3.6	Checking return flow rate of injectors with engine running	425
3.7	Checking return flow rate of injectors at starter speed	429
3.8	Removing and installing injectors	432
3.9	Removing and installing high-pressure lines	436
3.10	Removing and installing fuel rail	442
<b>4</b>	<b>Air filter</b>	<b>444</b>
4.1	Assembly overview – air filter housing	444
4.2	Removing and installing air filter housing	448
<b>5</b>	<b>Intake manifold</b>	<b>451</b>
5.1	Assembly overview – intake manifold	451
5.2	Removing and installing intake manifold	455
5.3	Removing and installing throttle valve module GX3	460
<b>6</b>	<b>Senders and sensors</b>	<b>462</b>
6.1	Removing and installing fuel pressure regulating valve N276	462
6.2	Checking fuel pressure regulating valve N276	464
6.3	Removing and installing fuel pressure sender G247	466
6.4	Removing and installing air mass meter G70	468
6.5	Removing and installing pressure differential sender G505	470
6.6	Removing and installing charge air temperature sender before charge air cooler G810	472
6.7	Removing and installing charge air temperature sender after charge air cooler G811	472
6.8	Removing and installing fuel temperature sender G81	473
6.9	Removing and installing temperature and pressure sender for low-pressure fuel system GX20 , vehicles as of model year 2020	476
6.10	Removing and installing intake manifold sender GX9	477
6.11	Removing and installing control unit for sensor electronics J849 / particulate sensor G784	477
6.12	Removing and installing control unit for NOx sender 2 J881 / NOx sender 2 G687	479
6.13	Removing and installing control unit for NOx sender J583 / NOx sender G295	483
6.14	Overview of fitting locations - exhaust gas sensors	490
<b>7</b>	<b>Engine control unit</b>	<b>493</b>
7.1	Removing and installing motor control unit J623	493



<b>8</b>	<b>High-pressure pump</b>	<b>494</b>
8.1	Assembly overview – high-pressure pump	494
8.2	Removing and installing high-pressure pump	497
<b>9</b>	<b>Lambda probe</b>	<b>504</b>
9.1	Assembly overview – lambda probe	504
9.2	Removing and installing Lambda probe 1 before catalytic converter GX10	506
<b>26</b>	<b>- Exhaust system</b>	<b>510</b>
<b>1</b>	<b>Exhaust pipes and silencers</b>	<b>510</b>
1.1	Assembly overview – silencers	510
1.2	Separating exhaust pipes from silencers	512
1.3	Removing and installing front silencer	513
1.4	Removing and installing rear silencer	514
1.5	Aligning exhaust system free of stress	516
1.6	Checking exhaust system for leaks	517
1.7	Installation position of clamp	517
<b>2</b>	<b>Emission control</b>	<b>518</b>
2.1	Assembly overview – emission control	518
2.2	Removing and installing catalytic converter	539
2.3	Removing and installing particulate filter	547
<b>3</b>	<b>SCR system (selective catalytic reduction)</b>	<b>552</b>
3.1	Assembly overview – reducing agent tank	552
3.2	Assembly overview - delivery module for reducing agent	553
3.3	Assembly overview – filler tube for reducing agent tank	554
3.4	Assembly overview - injector for reducing agent N474	555
3.5	Removing and installing reducing agent tank VX85	556
3.6	Removing and installing reducing agent supply line	558
3.7	Removing and installing delivery unit for reducing agent metering system GX19	560
3.8	Removing and installing injector for reducing agent N474	562
3.9	Removing and installing control unit for reducing agent heater J891	565
3.10	Draining reducing agent tank VX85	565
3.11	Removing and installing filler pipe for tank for reducing agent	567
<b>4</b>	<b>Exhaust gas temperature regulation</b>	<b>569</b>
4.1	Assembly overview – exhaust gas temperature regulation	569
4.2	Removing and installing exhaust gas temperature sender 1 G235	572
4.3	Removing and installing exhaust gas temperature sender 2 G448	580
4.4	Removing and installing exhaust gas temperature sender 3 G495	583
4.5	Removing and installing exhaust gas temperature sender 4 G648	587
<b>5</b>	<b>Exhaust gas recirculation</b>	<b>589</b>
5.1	Assembly overview – exhaust gas recirculation	589
5.2	Removing and installing exhaust gas recirculation cooler	591
5.3	Removing and installing exhaust gas recirculation pipes	600
5.4	Removing and installing temperature sensor 2 for exhaust gas recirculation G690	603
5.5	Checking exhaust gas recirculation cooler for leaks	604
5.6	Removing and installing temperature sensor 3 for exhaust gas recirculation G949	607
5.7	Flushing exhaust gas recirculation cooler and exhaust gas recirculation valve 1 GX5	609
<b>28</b>	<b>- Glow plug system</b>	<b>614</b>
<b>1</b>	<b>Glow plug system</b>	<b>614</b>
1.1	Assembly overview – glow plug system	614
1.2	Removing and installing glow plug	616
1.3	Checking glow plug	621
1.4	Removing and installing automatic glow period control unit J179	621
1.5	Removing and installing knock sensor 1 G61	622
1.6	Removing and installing knock sensor 2 G66	623



1.7	Removing and installing Hall sender G40 .....	623
1.8	Removing and installing engine speed sender G28 .....	624