



Contents

| | |
|----------------------------------------------------------------------------------------|-----------|
| 00 - Technical data | 1 |
| 1 Safety information | 1 |
| 1.1 Safety regulations for working on fuel supply | 1 |
| 1.2 Safety measures when working on vehicles with a start/stop system | 1 |
| 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 ignition system | 2 |
| 1.6 Safety precautions when working on exhaust system | 3 |
| 2 Identification | 4 |
| 2.1 Engine number/engine data | 4 |
| 3 Repair instructions | 5 |
| 3.1 Rules for cleanliness | 5 |
| 3.2 General information | 6 |
| 3.3 Foreign objects in engine | 6 |
| 3.4 Contact corrosion | 7 |
| 3.5 Routing and attachment of lines | 7 |
| 3.6 Fitting radiator and condensers | 7 |
| 3.7 Checking vacuum system | 7 |
| 10 - Removing and installing engine | 9 |
| 1 Removing and installing engine | 9 |
| 1.1 Removing engine | 9 |
| 1.2 Separating engine and gearbox | 16 |
| 1.3 Securing engine on engine and gearbox support | 20 |
| 1.4 Installing engine | 21 |
| 2 Assembly mountings | 27 |
| 2.1 Assembly overview - assembly mountings | 27 |
| 2.2 Removing and installing engine mounting | 28 |
| 2.3 Removing and installing gearbox mounting | 30 |
| 2.4 Removing and installing pendulum support | 31 |
| 2.5 Supporting engine in installation position | 32 |
| 2.6 Adjusting assembly mountings | 34 |
| 2.7 Checking adjustment of assembly mountings (engine and gearbox mountings) | 36 |
| 13 - Crankshaft group | 37 |
| 1 Cylinder block (pulley end) | 37 |
| 1.1 Assembly overview - poly V-belt drive | 37 |
| 1.2 Assembly overview - sealing flange, belt pulley end | 41 |
| 1.3 Removing and installing poly-V belt | 42 |
| 1.4 Removing and installing tensioner for poly V-belt | 45 |
| 1.5 Removing and installing vibration damper | 46 |
| 1.6 Removing and installing engine support | 46 |
| 1.7 Renewing crankshaft oil seal - belt pulley end | 49 |
| 1.8 Removing and installing sealing flange on pulley end | 51 |
| 2 Cylinder block, gearbox end | 55 |
| 2.1 Assembly overview - cylinder block, gearbox end | 55 |
| 2.2 Removing and installing flywheel | 56 |
| 2.3 Removing and installing sealing flange on gearbox side | 57 |
| 3 Crankshaft | 65 |
| 3.1 Crankshaft dimensions | 65 |
| 3.2 Renewing needle bearing in crankshaft | 65 |
| 3.3 Measuring axial clearance of crankshaft | 67 |



| | | |
|---------------------------------------|---------------------------------------------------------------------------|------------|
| 4 | Pistons and conrods | 69 |
| 4.1 | Assembly overview - pistons and conrods | 69 |
| 4.2 | Removing and installing pistons | 71 |
| 4.3 | Checking pistons and cylinder bores | 72 |
| 4.4 | Separating new conrod | 73 |
| 4.5 | Checking radial clearance of conrods | 74 |
| 4.6 | Removing and installing oil spray jets | 74 |
| 15 - Cylinder head, valve gear | | 76 |
| 1 | Cylinder head | 76 |
| 1.1 | Assembly overview - cylinder head | 76 |
| 1.2 | Assembly overview - camshaft housing | 78 |
| 1.3 | Removing and installing cylinder head | 79 |
| 1.4 | Removing and installing camshaft housing | 83 |
| 1.5 | Checking compression | 87 |
| 2 | Toothed belt drive | 90 |
| 2.1 | Assembly overview - toothed belt cover | 90 |
| 2.2 | Assembly overview - toothed belt | 91 |
| 2.3 | Removing and installing toothed belt | 92 |
| 2.4 | Checking valve timing | 98 |
| 2.5 | Removing toothed belt from camshaft | 102 |
| 3 | Valve gear | 108 |
| 3.1 | Assembly overview - valve gear | 108 |
| 3.2 | Measuring axial play of camshaft | 109 |
| 3.3 | Removing and installing camshaft oil seal | 110 |
| 3.4 | Removing and installing camshaft adjuster | 115 |
| 3.5 | Removing and installing camshaft control valve 1 N205 | 117 |
| 3.6 | Removing and installing valve stem seals | 118 |
| 4 | Inlet and exhaust valves | 126 |
| 4.1 | Reworking valve seats | 126 |
| 4.2 | Checking valve guides | 127 |
| 4.3 | Checking valves | 128 |
| 4.4 | Valve dimensions | 129 |
| 17 - Lubrication | | 130 |
| 1 | Sump, oil pump | 130 |
| 1.1 | Assembly overview - sump/oil pump | 130 |
| 1.2 | Engine oil: | 134 |
| 1.3 | Removing and installing sump | 134 |
| 1.4 | Removing and installing oil pump | 140 |
| 1.5 | Removing and installing oil level and oil temperature sender G266 | 141 |
| 2 | Engine oil cooler | 143 |
| 2.1 | Assembly overview - engine oil cooler | 143 |
| 2.2 | Removing and installing engine oil cooler | 143 |
| 3 | Crankcase ventilation | 145 |
| 3.1 | Assembly overview - crankcase breather system | 145 |
| 3.2 | Removing and installing oil separator | 146 |
| 4 | Oil filter, oil pressure switch | 148 |
| 4.1 | Assembly overview - oil filter/oil pressure switch | 148 |
| 4.2 | Removing and installing oil pressure switch for reduced oil pressure F378 | 148 |
| 4.3 | Checking oil pressure and oil pressure switch | 149 |
| 19 - Cooling | | 152 |
| 1 | Cooling system/coolant | 152 |
| 1.1 | Connection diagram - coolant hoses | 152 |



| | | |
|---------------------------------------------------|--------------------------------------------------------------------------------------------------|------------|
| 1.2 | Checking cooling system for leaks | 153 |
| 1.3 | Draining and adding coolant | 155 |
| 2 | Coolant pump, regulation of cooling system | 162 |
| 2.1 | Assembly overview - coolant pump, thermostat | 162 |
| 2.2 | Assembly overview - electric coolant pump | 164 |
| 2.3 | Assembly overview - coolant temperature sender | 166 |
| 2.4 | Removing and installing electric coolant pump | 166 |
| 2.5 | Removing and installing coolant pump | 168 |
| 2.6 | Removing and installing thermostat | 172 |
| 2.7 | Removing and installing toothed belt pulley for coolant pump | 175 |
| 2.8 | Removing and installing coolant temperature sender G62 | 176 |
| 2.9 | Removing and installing radiator outlet coolant temperature sender G83 | 177 |
| 3 | Coolant pipes | 180 |
| 3.1 | Assembly overview - coolant pipes | 180 |
| 3.2 | Removing and installing coolant pipes | 180 |
| 4 | Radiator, radiator fan | 184 |
| 4.1 | Assembly overview - radiator/radiator fan | 184 |
| 4.2 | Assembly overview - radiator cowl and radiator fan | 186 |
| 4.3 | Removing and installing radiator | 186 |
| 4.4 | Removing and installing radiator cowl with radiator fan | 189 |
| 4.5 | Removing and installing radiator fan | 190 |
| 21 - Turbocharging/supercharging | 192 | |
| 1 | Turbocharger | 192 |
| 1.1 | Assembly overview - turbocharger | 192 |
| 1.2 | Removing and installing turbocharger | 193 |
| 1.3 | Removing and installing charge pressure positioner V465 | 196 |
| 2 | Charge air system | 198 |
| 2.1 | Assembly overview - charge air system | 198 |
| 2.2 | Removing and installing charge air cooler | 200 |
| 2.3 | Removing and installing charge air pressure sender G31 / intake air temperature sender G42 | 202 |
| 2.4 | Checking charge air system for leaks | 203 |
| 2.5 | Removing and installing air pipe | 205 |
| 24 - Mixture preparation - injection | 208 | |
| 1 | Injection system | 208 |
| 1.1 | Overview of fitting locations - injection system | 208 |
| 2 | Injectors | 212 |
| 2.1 | Assembly overview - fuel rail with injectors | 212 |
| 2.2 | Removing and installing fuel rail | 213 |
| 2.3 | Removing and installing injectors | 213 |
| 2.4 | Renewing seals on injectors | 217 |
| 2.5 | Cleaning injectors | 220 |
| 3 | Air filter | 222 |
| 3.1 | Assembly overview - air filter housing | 222 |
| 3.2 | Removing and installing air filter housing | 223 |
| 4 | Intake manifold | 224 |
| 4.1 | Assembly overview - intake manifold | 224 |
| 4.2 | Removing and installing intake manifold | 225 |
| 4.3 | Removing and installing throttle valve module GX3 | 227 |
| 4.4 | Cleaning throttle valve module | 227 |
| 5 | Senders and sensors | 229 |
| 5.1 | Removing and installing fuel pressure sender G247 | 229 |
| 5.2 | Checking fuel pressure sender G247 | 230 |



| | | |
|-----------|----------------------------------------------------------------------------------|------------|
| 6 | Engine control unit | 232 |
| 6.1 | Removing and installing engine (motor) control unit J623 with protective housing | 232 |
| 7 | High-pressure pump | 234 |
| 7.1 | Assembly overview - high-pressure pump | 234 |
| 7.2 | Removing and installing high-pressure pump | 235 |
| 7.3 | Removing and installing high-pressure pipe | 236 |
| 8 | Lambda probe | 238 |
| 8.1 | Assembly overview - Lambda probe | 238 |
| 8.2 | Removing and installing Lambda probe | 239 |
| 26 | - Exhaust system | 241 |
| 1 | Exhaust pipes and silencers | 241 |
| 1.1 | Assembly overview - silencers | 241 |
| 1.2 | Separating exhaust pipes from silencers | 242 |
| 1.3 | Aligning exhaust system free of stress | 243 |
| 1.4 | Checking exhaust system for leaks | 244 |
| 1.5 | Installation position of clamp | 244 |
| 2 | Emission control | 247 |
| 2.1 | Assembly overview - emission control | 247 |
| 2.2 | Removing and installing catalytic converter | 248 |
| 28 | - Ignition system | 252 |
| 1 | Ignition system | 252 |
| 1.1 | Assembly overview - ignition system | 252 |
| 1.2 | Test data, spark plugs | 253 |
| 1.3 | Removing and installing ignition coils with output stage | 253 |
| 1.4 | Removing and installing knock sensor 1 G61 | 255 |
| 1.5 | Removing and installing Hall sender G40 | 256 |
| 1.6 | Removing and installing engine speed sender G28 | 256 |