



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 cooling system | 2 |
| 1.5 Safety precautions when working on the SCR system | 2 |
| 1.6 Safety precautions when working on exhaust system | 3 |
| 2 Identification | 4 |
| 2.1 Engine number/engine data | 4 |
| 3 Repair notes | 5 |
| 3.1 Rules for cleanliness | 5 |
| 3.2 Foreign objects in engine | 5 |
| 3.3 Contact corrosion | 5 |
| 3.4 Pipe/wire routing and attachment | 6 |
| 3.5 Checking vacuum system | 6 |
| 10 - Removing and installing engine | 7 |
| 1 Removing and installing motor | 7 |
| 1.1 Removing motor | 7 |
| 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 | 25 |
| 2.1 Assembly overview - assembly mountings | 25 |
| 2.2 Removing and installing engine mounting | 27 |
| 2.3 Removing and installing gearbox mountings | 28 |
| 2.4 Removing and installing pendulum support | 29 |
| 2.5 Supporting engine in installation position | 30 |
| 2.6 Adjusting assembly mountings | 36 |
| 2.7 Checking adjustment of assembly mountings (engine and gearbox mountings) | 37 |
| 3 Engine cover panel | 39 |
| 3.1 Removing and installing engine cover | 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, belt pulley end | 43 |
| 1.3 Removing and installing poly-V belt | 45 |
| 1.4 Removing and installing tensioner for poly V-belt | 45 |
| 1.5 Removing and installing vibration damper | 46 |
| 1.6 Removing and installing bracket for ancillaries | 47 |
| 1.7 Removing and installing engine support | 49 |
| 1.8 Removing and installing sealing flange on pulley end | 50 |
| 2 Cylinder block, gearbox end | 53 |
| 2.1 Assembly overview - cylinder block, gearbox end | 53 |
| 2.2 Removing and installing flywheel | 55 |
| 2.3 Removing and installing sealing flange on gearbox side | 56 |
| 2.4 Removing and installing adapter plate | 67 |
| 2.5 Removing and installing intermediate plate | 68 |
| 3 Crankshaft | 69 |
| 3.1 Assembly overview - crankshaft | 69 |



| | | |
|-----------|---|------------|
| 3.2 | Crankshaft dimensions | 71 |
| 3.3 | Renewing needle bearing in crankshaft | 71 |
| 3.4 | Measuring axial clearance of crankshaft | 73 |
| 3.5 | Measuring radial clearance of crankshaft | 74 |
| 4 | Pistons and conrods | 75 |
| 4.1 | Assembly overview - pistons and conrods | 75 |
| 4.2 | Removing and installing pistons | 78 |
| 4.3 | Measuring piston projection at TDC | 80 |
| 4.4 | Checking pistons and cylinder bores | 82 |
| 4.5 | Separating new conrod | 85 |
| 4.6 | Checking radial clearance of conrods | 85 |
| 4.7 | Removing and installing oil spray jets | 86 |
| 15 | Cylinder head, valve gear | 87 |
| 1 | Cylinder head | 87 |
| 1.1 | Assembly overview - cylinder head | 87 |
| 1.2 | Assembly overview - camshaft housing | 89 |
| 1.3 | Assembly overview - cylinder head cover | 91 |
| 1.4 | Removing and installing cylinder head | 93 |
| 1.5 | Removing and installing cylinder head cover | 99 |
| 1.6 | Removing and installing injector seals | 100 |
| 1.7 | Removing and installing camshaft housing | 101 |
| 1.8 | Checking compression | 106 |
| 2 | Toothed belt drive | 109 |
| 2.1 | Assembly overview - toothed belt cover | 109 |
| 2.2 | Assembly overview - toothed belt | 109 |
| 2.3 | Removing and installing toothed belt guard | 111 |
| 2.4 | Removing and installing toothed belt | 116 |
| 2.5 | Removing toothed belt from camshaft | 124 |
| 3 | Valve gear | 132 |
| 3.1 | Assembly overview - valve gear | 132 |
| 3.2 | Measuring axial play of camshaft | 134 |
| 3.3 | Removing and installing camshaft oil seal | 135 |
| 3.4 | Checking hydraulic compensation elements | 137 |
| 3.5 | Removing and installing valve stem seals | 138 |
| 3.6 | Removing and installing toothed belt pulley | 146 |
| 4 | Inlet and exhaust valves | 148 |
| 4.1 | Checking valve guides | 148 |
| 4.2 | Checking valves | 149 |
| 4.3 | Valve dimensions | 149 |
| 17 | Lubrication | 150 |
| 1 | Sump, oil pump | 150 |
| 1.1 | Assembly overview - sump/oil pump | 150 |
| 1.2 | Engine oil: | 153 |
| 1.3 | Removing and installing lower part of sump | 153 |
| 1.4 | Removing and installing upper part of sump | 156 |
| 1.5 | Removing and installing oil pump | 159 |
| 1.6 | Removing and installing oil level and oil temperature sender G266 | 159 |
| 1.7 | Removing and installing toothed belt for oil pump | 161 |
| 2 | Engine oil cooler | 162 |
| 3 | Oil filter, oil pressure switch | 163 |
| 3.1 | Assembly overview - oil filter housing, oil pressure switch | 163 |
| 3.2 | Assembly overview - oil pressure switches/oil pressure control | 165 |
| 3.3 | Checking oil pressure | 166 |



| | | |
|-----------|--|------------|
| 3.4 | Removing and installing oil filter housing | 166 |
| 3.5 | Removing and installing oil pressure regulating valve N428 | 167 |
| 3.6 | Removing and installing oil pressure sender G10 | 168 |
| 3.7 | Removing and installing piston cooling jet control valve N522 | 170 |
| 4 | Oil circuit | 172 |
| 4.1 | Assembly overview - oil circuit | 172 |
| 4.2 | Removing and installing oil supply line | 172 |
| 4.3 | Removing and installing oil return line for turbocharger | 174 |
| 19 | Cooling | 176 |
| 1 | Cooling system/coolant | 176 |
| 1.1 | Checking cooling system for leaks | 176 |
| 1.2 | Draining and adding coolant | 178 |
| 1.3 | Checking filling quality | 192 |
| 2 | Coolant pump, regulation of cooling system | 195 |
| 2.1 | Assembly overview - coolant pump, thermostat | 195 |
| 2.2 | Assembly overview - electric coolant pump | 197 |
| 2.3 | Assembly overview - coolant temperature sender | 198 |
| 2.4 | Removing and installing coolant pump | 199 |
| 2.5 | Removing and installing thermostat | 200 |
| 2.6 | Removing and installing coolant temperature sender G62 | 202 |
| 2.7 | Removing and installing engine outlet coolant temperature sender G82 | 202 |
| 2.8 | Removing and installing coolant regulating valve N515 | 203 |
| 2.9 | Removing and installing auxiliary pump for heating V488 | 204 |
| 2.10 | Removing and installing charge air cooling pump V188 | 206 |
| 2.11 | Removing and installing coolant temperature sender for charge air cooler G1130 | 208 |
| 3 | Coolant pipes | 210 |
| 3.1 | Assembly overview - coolant pipes | 210 |
| 3.2 | Removing and installing coolant pipes | 210 |
| 4 | Radiator, radiator fan | 215 |
| 4.1 | Assembly overview - radiator/radiator fan | 215 |
| 4.2 | Assembly overview - radiator cowl and radiator fan | 217 |
| 4.3 | Removing and installing radiator | 217 |
| 4.4 | Removing and installing cooler for charge air cooling circuit | 219 |
| 4.5 | Removing and installing radiator cowl | 222 |
| 4.6 | Removing and installing radiator fan V7 | 223 |
| 21 | Turbocharging/supercharging | 225 |
| 1 | Turbocharger | 225 |
| 1.1 | Assembly overview - turbocharger | 225 |
| 1.2 | Removing and installing turbocharger | 228 |
| 1.3 | Removing and installing connection for turbocharger | 230 |
| 2 | Charge air system | 232 |
| 2.1 | Assembly overview - charge air system | 232 |
| 2.2 | Checking charge air cooler for leaks | 232 |
| 2.3 | Removing and installing charge air cooler | 237 |
| 2.4 | Removing and installing charge pressure sender GX26 | 237 |
| 2.5 | Checking charge air system for leaks | 238 |
| 2.6 | Removing and installing air pipe | 240 |
| 23 | Mixture preparation - injection | 242 |
| 1 | Injection system | 242 |
| 1.1 | Filling/bleeding fuel system | 242 |
| 1.2 | Checking fuel system for leaks | 243 |
| 2 | Injectors/high-pressure accumulator (rail) | 244 |



| | | |
|-----------|---|------------|
| 2.1 | Assembly overview - injectors | 244 |
| 2.2 | Assembly overview - fuel rail | 245 |
| 2.3 | Adapting correction values for injectors | 247 |
| 2.4 | Testing injectors | 248 |
| 2.5 | Checking return flow rate of injectors with engine running | 248 |
| 2.6 | Checking return flow rate of injectors at starter speed | 251 |
| 2.7 | Testing jammed-open injectors | 254 |
| 2.8 | Removing and installing injectors | 255 |
| 2.9 | Removing and installing high-pressure lines | 258 |
| 2.10 | Removing and installing fuel rail | 263 |
| 3 | Air filter | 266 |
| 3.1 | Assembly overview - air filter housing | 266 |
| 3.2 | Removing and installing air filter housing | 268 |
| 3.3 | Removing and installing air guide on lock carrier | 268 |
| 4 | Intake manifold | 270 |
| 4.1 | Assembly overview - intake manifold | 270 |
| 4.2 | Removing and installing intake manifold | 274 |
| 4.3 | Removing and installing throttle valve module GX3 | 277 |
| 5 | Senders and sensors | 280 |
| 5.1 | Removing and installing fuel pressure regulating valve N276 | 280 |
| 5.2 | Checking fuel pressure regulating valve N276 | 282 |
| 5.3 | Removing and installing fuel pressure sender G247 | 284 |
| 5.4 | Removing and installing pressure differential sender G505 | 285 |
| 5.5 | Removing and installing charge air temperature sender ahead of charge air cooler G810 | 287 |
| 5.6 | Removing and installing charge air temperature sender after charge air cooler G811 | 287 |
| 5.7 | Removing and installing control unit for NOx sender GX30 | 288 |
| 5.8 | Removing and installing air mass measurement module GX35 | 289 |
| 5.9 | Removing and installing control unit 2 for NOx sender GX46 | 291 |
| 5.10 | Removing and installing control unit 3 for NOx sender GX50 | 293 |
| 5.11 | Removing and installing control unit 1 for particulate sensor GX52 | 294 |
| 5.12 | Removing and installing temperature and pressure sender for low-pressure fuel system GX20 | 295 |
| 6 | Engine control unit | 297 |
| 6.1 | Removing and installing engine control unit J623 | 297 |
| 7 | High-pressure pump | 299 |
| 7.1 | Assembly overview - high-pressure pump | 299 |
| 7.2 | Removing and installing high-pressure pump | 299 |
| 8 | Lambda probe | 305 |
| 8.1 | Assembly overview - Lambda probe | 305 |
| 8.2 | Removing and installing Lambda probe 1 before catalytic converter GX10 | 307 |
| 26 | Exhaust system | 309 |
| 1 | Exhaust pipes and silencers | 309 |
| 1.1 | Assembly overview - silencers | 309 |
| 1.2 | Assembly overview - front exhaust pipe | 310 |
| 1.3 | Removing and installing front exhaust pipe | 312 |
| 1.4 | Removing and installing silencer | 314 |
| 1.5 | Aligning exhaust system free of stress | 315 |
| 1.6 | Checking exhaust system for leaks | 316 |
| 1.7 | Installation position of clamp | 317 |
| 2 | Emission control | 318 |
| 2.1 | Assembly overview - emission control | 318 |
| 2.2 | Removing and installing emission control module | 320 |
| 2.3 | Removing and installing exhaust flap control unit J883 | 326 |
| 3 | SCR system (selective catalytic reduction) | 328 |



| | | |
|-----------|---|------------|
| 3.1 | Assembly overview - tank for reducing agent | 328 |
| 3.2 | Assembly overview - reducing agent supply line | 329 |
| 3.3 | Assembly overview - delivery module for reducing agent | 330 |
| 3.4 | Removing and installing reducing agent tank | 331 |
| 3.5 | Removing and installing filler pipe for reducing agent tank | 333 |
| 3.6 | Removing and installing front section of reducing agent supply line | 335 |
| 3.7 | Removing and installing rear section of reducing agent supply line | 339 |
| 3.8 | Removing and installing injector for reduction agent N474 | 341 |
| 3.9 | Removing and installing control unit for reducing-agent heater J891 | 344 |
| 3.10 | Draining reducing agent tank | 344 |
| 3.11 | SCR - resetting learnt values | 346 |
| 3.12 | Removing and installing delivery unit for reducing agent metering system GX19 | 346 |
| 3.13 | Removing and installing injector 2 for reducing agent N758 | 348 |
| 3.14 | Removing and installing middle section of reducing agent supply line | 350 |
| 4 | Exhaust gas temperature regulation | 352 |
| 4.1 | Assembly overview - exhaust gas temperature regulation | 352 |
| 4.2 | Removing and installing exhaust gas temperature sender 1 G235 | 353 |
| 4.3 | Removing and installing exhaust gas temperature sender 2 G448 | 355 |
| 4.4 | Removing and installing exhaust gas temperature sender 3 G495 | 356 |
| 4.5 | Removing and installing exhaust gas temperature sender 4 G648 | 358 |
| 5 | Exhaust gas recirculation | 361 |
| 5.1 | Assembly overview - exhaust gas recirculation | 361 |
| 5.2 | Removing and installing exhaust gas recirculation cooler | 362 |
| 5.3 | Checking exhaust gas recirculation cooler for leaks | 364 |
| 5.4 | Removing and installing exhaust gas recirculation temperature sensor G98 | 368 |
| 5.5 | Removing and installing exhaust gas recirculation valve 1 GX5 | 369 |
| 5.6 | Removing and installing exhaust gas recirculation valve 2 GX6 | 370 |
| 28 | Glow plug system | 372 |
| 1 | Glow plug system | 372 |
| 1.1 | Assembly overview - glow plug system | 372 |
| 1.2 | Removing and installing glow plug | 373 |
| 1.3 | Removing and installing automatic glow period control unit J179 | 376 |
| 1.4 | Removing and installing Hall sender G40 | 376 |
| 1.5 | Removing and installing engine speed sender G28 | 377 |