



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 SCR system	2
1.6 Safety precautions when working on the exhaust system	4
2 Identification	5
2.1 Engine number/engine data	5
3 Repair instructions	9
3.1 Rules for cleanliness	9
3.2 Foreign material in engine	9
3.3 Contact corrosion	9
3.4 Routing and attachment of lines	10
3.5 Fitting radiator and condensers	10
10 - Removing and installing engine	11
1 Removing and installing engine	11
1.1 Removing motor	11
1.2 Separating engine and gearbox	21
1.3 Securing engine on engine and gearbox support	26
1.4 Installing motor	27
2 Assembly mountings	32
2.1 Assembly overview – assembly mountings	32
2.2 Removing and installing engine mounting	36
2.3 Removing and installing gearbox mounting	36
2.4 Removing and installing pendulum support	38
2.5 Supporting engine in installation position	40
2.6 Adjusting assembly mountings	52
2.7 Checking adjustment of assembly mountings	55
3 Engine cover panel	56
3.1 Removing and installing engine cover	56
13 - Crankshaft group	57
1 Cylinder block, pulley end	57
1.1 Assembly overview – cylinder block, pulley end	57
1.2 Assembly overview – sealing flange, pulley end	59
1.3 Removing and installing poly-V belt	61
1.4 Removing and installing poly V-belt tensioner	62
1.5 Removing and installing vibration damper	63
1.6 Removing and installing bracket for ancillaries	63
1.7 Removing and installing engine support	64
1.8 Removing and installing sealing flange, pulley end	65
1.9 Renewing caps in cylinder block, pulley end	68
2 Cylinder block, gearbox side	70
2.1 Assembly overview – cylinder block, gearbox side	70
2.2 Removing and installing flywheel	71
2.3 Removing and installing sealing flange on gearbox side	73
2.4 Renewing caps in cylinder block (gearbox end)	87
3 Crankshaft	89
3.1 Assembly overview - crankshaft	89



3.2	Crankshaft dimensions	90
3.3	Measuring axial clearance of crankshaft	91
3.4	Renewing needle bearing in crankshaft	91
4	Pistons and conrods	94
4.1	Assembly overview – pistons and conrods	94
4.2	Removing and installing pistons	98
4.3	Measuring piston projection at TDC	99
4.4	Checking piston and cylinder bore	102
4.5	Checking radial clearance of conrods	103
15	- Cylinder head, valve gear	104
1	Cylinder head	104
1.1	Assembly overview – cylinder head	104
1.2	Assembly overview - cylinder head cover	107
1.3	Removing and installing cylinder head	109
1.4	Removing and installing cylinder head cover	118
1.5	Removing and installing injector seals	118
1.6	Removing and installing camshaft housing	119
1.7	Checking compression	125
2	Toothed belt drive	128
2.1	Assembly overview – toothed belt cover	128
2.2	Assembly overview – toothed belt	128
2.3	Removing and installing toothed belt guard	130
2.4	Removing and installing toothed belt	134
2.5	Removing toothed belt from camshaft	144
3	Valve gear	149
3.1	Assembly overview – valve gear	149
3.2	Measuring axial play of camshaft	152
3.3	Removing and installing camshaft oil seal	153
3.4	Removing and installing camshaft adjuster	155
3.5	Removing and installing camshaft control valve 1 N205	160
3.6	Checking hydraulic compensation elements	161
3.7	Removing and installing valve stem oil seals	161
4	Inlet and exhaust valves	170
4.1	Checking valve guides	170
4.2	Checking valves	171
4.3	Valve dimensions	171
17	- Lubrication	172
1	Sump, oil pump	172
1.1	Assembly overview – sump/oil pump	172
1.2	Engine oil	178
1.3	Removing and installing sump	178
1.4	Removing and installing lower part of sump	181
1.5	Removing and installing upper part of sump	185
1.6	Removing and installing oil pump	189
1.7	Removing and installing oil level and oil temperature sender G266	190
2	Engine oil cooler	192
3	Oil filter, oil pressure switch	193
3.1	Assembly overview - oil filter housing, oil pressure switch	193
3.2	Removing and installing oil pressure switch F1	195
3.3	Removing and installing oil pressure switch for reduced oil pressure F378	196
3.4	Checking oil pressure	198
3.5	Removing and installing oil filter housing	198
3.6	Removing and installing valve for oil pressure control N428	200



4	Oil circuit	202
4.1	Removing and installing oil supply line	202
4.2	Removing and installing oil return line for turbocharger	203
19	Cooling	205
1	Cooling system/coolant	205
1.1	Connection diagram – coolant hoses	205
1.2	Checking cooling system for leaks	209
1.3	Draining coolant	212
1.4	Filling with coolant	214
1.5	Checking filling quality of cooling system	228
1.6	Flushing cooling system	230
2	Coolant pump, regulation of cooling system	252
2.1	Assembly overview – coolant pump/thermostat	252
2.2	Assembly overview – electric coolant pump	256
2.3	Assembly overview – coolant temperature sender	262
2.4	Removing and installing electric coolant pump	265
2.5	Removing and installing coolant pump	281
2.6	Removing and installing thermostat	281
2.7	Checking thermostat	284
2.8	Removing and installing coolant valve for cylinder head N489	285
2.9	Removing and installing coolant temperature sender G62	285
2.10	Removing and installing radiator outlet coolant temperature sender G83	286
3	Coolant pipes	288
3.1	Assembly overview – coolant pipes	288
3.2	Removing and installing coolant pipes	290
4	Radiator, radiator fan	305
4.1	Assembly overview - radiator/radiator fan	305
4.2	Assembly overview - radiator cowl and radiator fans	311
4.3	Removing and installing radiator	312
4.4	Removing and installing water radiator for charge air cooling circuit	322
4.5	Removing and installing radiator cowl	326
4.6	Removing and installing radiator fan	331
21	Turbocharging/supercharging	333
1	Turbocharger	333
1.1	Assembly overview – turbocharger	333
1.2	Removing and installing turbocharger	340
1.3	Renewing vacuum unit for turbocharger	355
1.4	Removing and installing connection for turbocharger	364
2	Charge air system	366
2.1	Assembly overview – charge air system	366
2.2	Removing and installing charge pressure sender G31	369
2.3	Checking charge air system for leaks	369
2.4	Removing and installing air intake pipe	372
2.5	Checking charge air cooler for leaks	373
23	Mixture preparation - injection	379
1	Injection system	379
1.1	Schematic overview - fuel system	379
1.2	Overview of fitting locations - injection system	381
1.3	Filling/bleeding fuel system	390
1.4	Checking fuel system for leaks	390
2	Vacuum system	392
2.1	Connection diagram - vacuum system	392



2.2	Checking vacuum system	393
3	Injectors/high-pressure reservoir (rail)	394
3.1	Assembly overview – injectors	394
3.2	Assembly overview - fuel rail	396
3.3	Adapting correction values for injectors	398
3.4	Testing injectors	398
3.5	Checking return flow rate of injectors with engine running	399
3.6	Checking return flow rate of injectors at starter speed	403
3.7	Checking open injectors	407
3.8	Removing and installing injectors	409
3.9	Removing and installing high-pressure lines	413
3.10	Removing and installing fuel rail	416
4	Air filter	420
4.1	Assembly overview – air filter housing	420
4.2	Removing and installing air filter housing	422
4.3	Removing and installing air duct on lock carrier	424
5	Intake manifold	427
5.1	Assembly overview – intake manifold	427
5.2	Removing and installing intake manifold	430
5.3	Removing and installing throttle valve module J338	434
6	Senders and sensors	437
6.1	Removing and installing fuel pressure regulating valve N276	437
6.2	Checking fuel pressure regulating valve N276	443
6.3	Removing and installing fuel pressure sender G247	444
6.4	Removing and installing air mass meter G70 / intake air temperature sender G42	445
6.5	Removing and installing pressure differential sender G505	447
6.6	Removing and installing exhaust gas pressure sensor 1 G450	450
6.7	Removing and installing NOx sender 2 G687	451
6.8	Removing and installing charge air temperature sender before charge air cooler G810	453
6.9	Removing and installing charge air temperature sender after charge air cooler G811	453
6.10	Removing and installing fuel temperature sender G81	454
6.11	Removing and installing control unit for NOx sender GX30	456
6.12	Removing and installing temperature and pressure sender for low-pressure fuel system GX20	462
7	Engine (motor) control unit	464
7.1	Removing and installing motor control unit J623	464
7.2	Removing and installing engine control unit J623 (with protective housing)	465
8	High-pressure pump	470
8.1	Assembly overview – high-pressure pump	470
8.2	Removing and installing high-pressure pump	470
9	Lambda probe	475
9.1	Assembly overview – lambda probe	475
9.2	Removing and installing lambda probe	477
26	- Exhaust system	481
1	Exhaust pipes and silencers	481
1.1	Assembly overview – silencers	481
1.2	Assembly overview - front exhaust pipe	485
1.3	Removing and installing front exhaust pipe	489
1.4	Separating exhaust pipes from silencers	490
1.5	Removing and installing silencer	491
1.6	Aligning exhaust system free of stress	496
1.7	Checking exhaust system for leaks	497
1.8	Installation position of clamp	497
1.9	Aligning tailpipes	498



1.10	Removing and installing bracket for front exhaust pipe	498
2	Emission control	500
2.1	Assembly overview – emission control	500
2.2	Removing and installing catalytic converter	506
2.3	Removing and installing particulate filter	507
2.4	Removing and installing emission control module	508
2.5	Removing and installing exhaust flap control unit J883	516
3	SCR system (selective catalytic reduction)	518
3.1	Assembly overview – reducing agent tank	518
3.2	Assembly overview - reducing agent supply line	526
3.3	Assembly overview - delivery module for reducing agent	530
3.4	Assembly overview – filler tube for reducing agent tank	530
3.5	Removing and installing reducing agent tank	532
3.6	Removing and installing front section of reducing agent supply line	543
3.7	Removing and installing delivery module for reducing agent	562
3.8	Removing and installing injector for reducing agent N474	564
3.9	Removing and installing control unit for reducing agent heater J891	567
3.10	Assembly overview - injector for reducing agent	572
3.11	Draining reducing agent tank	574
3.12	Removing and installing rear section of reducing agent supply line	576
3.13	Removing and installing filler pipe for reducing agent tank	582
3.14	Disconnecting reducing agent supply line	589
3.15	SCR - resetting learnt values	593
4	Exhaust gas temperature regulation	594
4.1	Assembly overview – exhaust gas temperature regulation	594
4.2	Removing and installing exhaust gas temperature sender 1 G235	596
4.3	Removing and installing exhaust gas temperature sender 2 G448	599
4.4	Removing and installing exhaust gas temperature sender 3 G495	601
4.5	Removing and installing exhaust gas temperature sender 4 G648	602
5	Exhaust gas recirculation	604
5.1	Assembly overview – exhaust gas recirculation	604
5.2	Removing and installing exhaust gas recirculation cooler	609
5.3	Removing and installing exhaust gas recirculation valve 1 GX5	615
5.4	Removing and installing exhaust gas recirculation valve 2 GX6	616
5.5	Removing and installing exhaust gas recirculation temperature sensor G98	617
5.6	Checking exhaust gas recirculation cooler for leaks	620
28	Glow plug system	621
1	Glow plug system	621
1.1	Assembly overview – glow plug system	621
1.2	Removing and installing glow plug	623
1.3	Removing and installing automatic glow period control unit J179	625
1.4	Removing and installing Hall sender G40	626
1.5	Removing and installing engine speed sender G28	626