



Contents

00 - Technical data	1
1 Safety instructions	1
1.1 Safety precautions during work on fuel system	1
1.2 Safety precautions when working on vehicles with a gas system	1
1.3 Safety precautions during road tests in which test and measuring equipment is used	4
1.4 Safety precautions when working on cooling system	4
1.5 Safety precautions when working on ignition system	5
2 Identification	6
2.1 Engine number, engine data	6
3 Repair instructions	7
3.1 Rules for cleanliness	7
3.2 Foreign objects in engine	7
3.3 Contact corrosion	7
3.4 Routing and securing lines	7
3.5 Installing coolers, condensers and radiators	8
10 - Removing and installing engine	9
1 Removing and installing engine	9
1.1 Removing engine	10
1.2 Securing engine on engine and gearbox support	14
1.3 Installing engine	15
2 Assembly mountings	19
2.1 Assembly overview - assembly mountings	19
2.2 Supporting engine in installation position	19
13 - Crankshaft group	22
1 Cylinder block (pulley end)	22
1.1 Assembly overview - poly V-belt drive	22
1.2 Removing and installing poly V-belt	23
2 Sealing flanges and flywheel	25
2.1 Assembly overview - sealing flanges	25
2.2 Removing and installing crankshaft sealing flange on gearbox side	26
2.3 Renewing crankshaft oil seal - belt pulley end	27
2.4 Removing and installing sealing flange on pulley end	31
3 Cylinder block and add-on parts	36
3.1 Assembly overview - cylinder block	36
4 Crankshaft	38
4.1 Assembly overview - crankshaft	38
4.2 Crankshaft dimensions	40
5 Pistons and conrods	41
5.1 Assembly overview - pistons and conrods	41
5.2 Checking pistons, piston rings and cylinder bores	43
5.3 Piston and cylinder dimensions	45
15 - Cylinder head, valve gear	46
1 Cylinder head	46
1.1 Assembly overview - cylinder head	46
1.2 Removing and installing cylinder head	47
1.3 Checking compression	55
2 Toothed belt drive	57
2.1 Assembly overview - toothed belt	57
2.2 Removing, installing and tensioning toothed belt	58



2.3	Checking semi-automatic toothed belt tensioner	65
3	Valve gear	66
3.1	Assembly overview - valve gear	66
3.2	Renewing camshaft oil seal	68
3.3	Removing and installing camshaft	71
3.4	Removing and installing valve stem seals	73
4	Inlet and exhaust valves	77
4.1	Checking valve guides	77
4.2	Renewing valve guides	77
4.3	Reworking valve seats	78
4.4	Valve dimensions	80
17	- Lubrication	81
1	Sump, oil pump	81
1.1	Assembly overview - sump and oil pump	81
1.2	Engine oil	82
1.3	Removing and installing oil sump	83
1.4	Removing and installing oil pump	85
2	Oil filter, oil pressure switch	87
2.1	Assembly overview - oil filter housing, oil pressure switch	87
2.2	Checking oil pressure and oil pressure switch	88
19	- Cooling	91
1	Cooling system, coolant	91
1.1	Coolant hose schematic diagram	91
1.2	Checking cooling system for leaks	92
1.3	Draining and filling coolant	94
2	Coolant pump, regulation of cooling system	98
2.1	Assembly overview - coolant pump, thermostat	98
2.2	Removing and installing coolant pump	99
2.3	Removing and installing thermostat	101
3	Radiator and radiator fan	105
3.1	Assembly overview - radiator and radiator fan	105
3.2	Removing and installing radiator	106
3.3	Removing and installing radiator fan V7 and radiator fan 2 V177	108
24	- Mixture preparation - injection	110
1	Injection system	110
1.1	Installation location overview - injection system	110
1.2	Bleeding fuel system	113
2	Injectors	117
2.1	Assembly overview - fuel rail with injectors	117
2.2	Checking injectors for leaks and quantity injected	118
2.3	Checking fuel pressure regulator and holding pressure	122
2.4	Removing and installing injectors	126
3	Checking natural gas supply system for leaks	128
3.1	Different pressure sections of natural gas supply system	128
3.2	Determining pressure in gas system	131
3.3	Determining operating mode of natural gas vehicles	131
3.4	Activating/deactivating natural gas mode	132
3.5	Checking gas system for leaks	133
4	Gas injectors	139
4.1	Assembly overview - gas rail with gas injectors	139
4.2	Removing and installing gas rail with gas injectors	140



5	Gas pressure regulator	142
5.1	Removing and installing high-pressure valve for gas mode N372	142
5.2	Removing and installing tank pressure sensor G400	144
6	Air filter	147
6.1	Assembly overview - air filter housing	147
7	Intake manifold	148
7.1	Assembly overview - intake manifold	148
7.2	Removing and installing upper part of intake manifold	149
7.3	Removing, installing and dismantling lower part of intake manifold	152
8	Engine control unit	154
8.1	Removing and installing engine control unit J623	154
8.2	Removing and installing engine control unit J623 with protective housing	155
26	- Exhaust system	158
1	Exhaust pipes, silencers	158
1.1	Assembly overview - silencers	158
2	Emission control	159
2.1	Assembly overview - emission control	159
2.2	Removing and installing catalytic converter	160
28	- Ignition system	162
1	Ignition system	162
1.1	General notes on ignition system	162
1.2	Assembly overview - ignition system	162
1.3	Test data, spark plugs	164