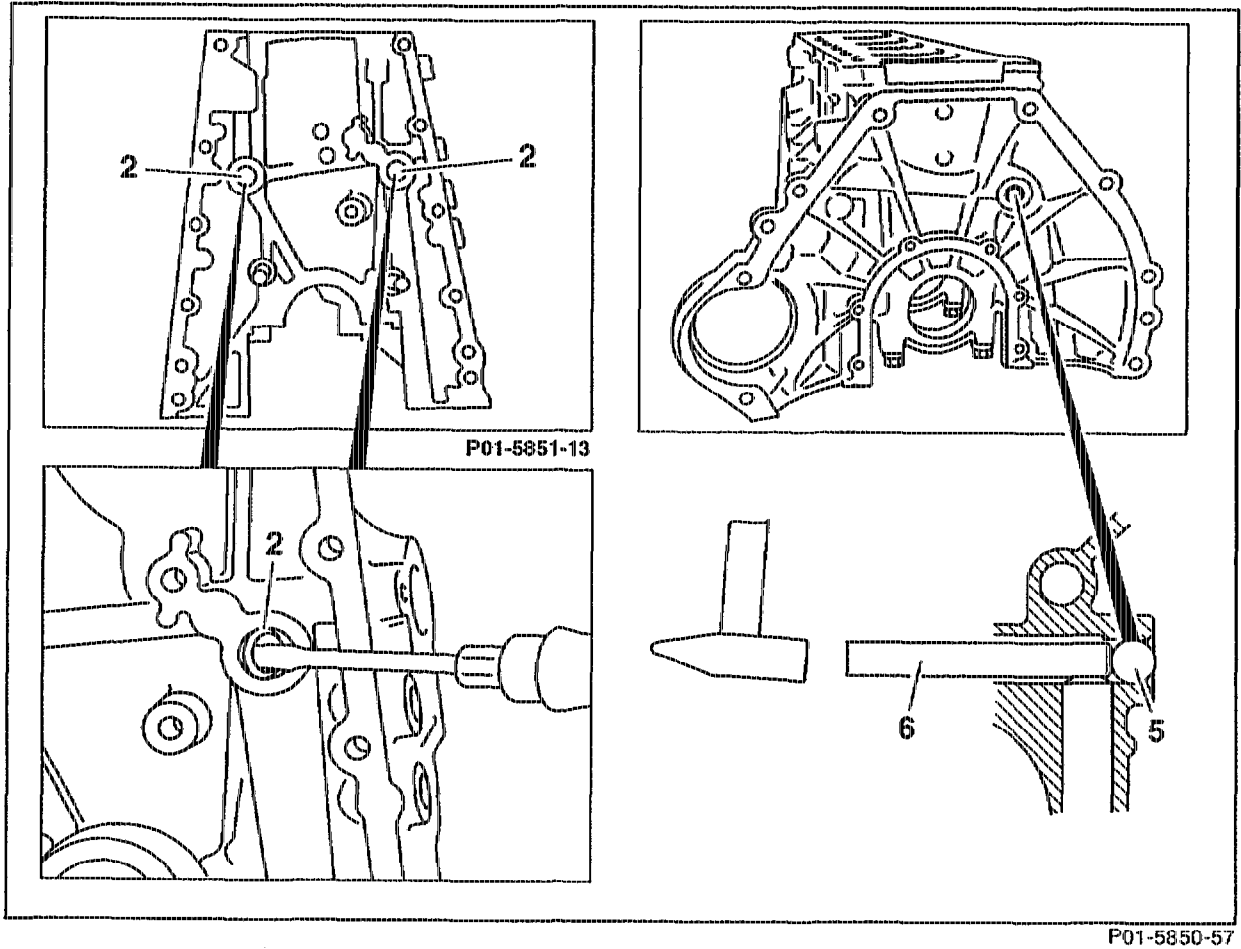


## 01-1300 Cleaning, sealing main oil galleries

Preceding work:  
 Crankshaft removed (03-1800).  
 Engines with piston crown cooling up to 12/93: Oil spray  
 nozzles (pistons) removed (18-1300).

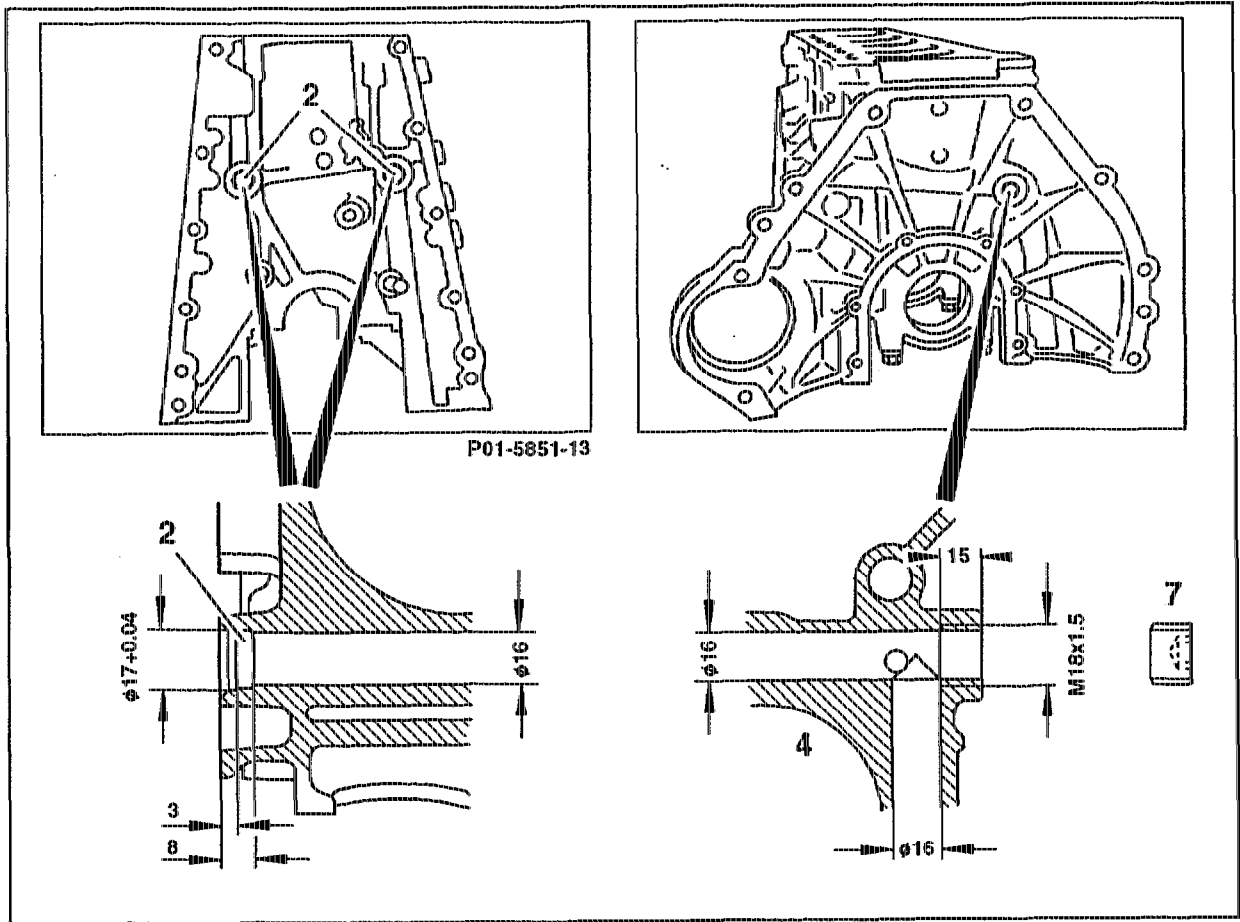
Operation no. of operation texts and work units or standard texts  
 and flat rates:

### Cleaning



Front plug (2) .....	knock in on one side with the screwdriver, press out.
Rear steel ball (5) .....	knock out with round bar (6) (approx. 11 mm dia., length 750 mm)
Oil galleries .....	clean.

# Sealing



P01-5851-13

P01-5852-57

## A. Front main oil gallery

- Main oil galleries .....
- New plugs (2) .....
- New plugs (2) .....

clean.  
 coat around circumference with Loctite 270 high strength 002 989 93 71 10.  
 knock in with drift 102 589 12 15 00 until tool makes contact.

**B. Sealing rear main oil gallery with steel ball**

Steel ball .....

knock in 2 mm deeper than originally with drift 102 589 07 15 00 so that steel ball is provided with a new seat in the  $\varnothing$  14.75 bore.

**Note**

This method is only successful if no leak existed beforehand as a result of porosity in crankcase oil gallery (ball seat).

The steel ball must be free of damage and rust.

**C. Sealing rear main oil gallery with screw plug**

Rear main oil gallery (4) .....

widen by drilling ( $\varnothing$  16 mm, depth about 15 mm).

M18 x 1.5 thread .....

tap in end of main oil gallery (4).

Swarf .....

thoroughly blow out of oil galleries.

Thread and screw plug (7) .....

remove grease.

M18 x 1.5 screw plug (7)

000 906 018 00 .....

coat with sealing adhesive 000 906 01 40 00, screw in, tighten.

**Special tool**

