



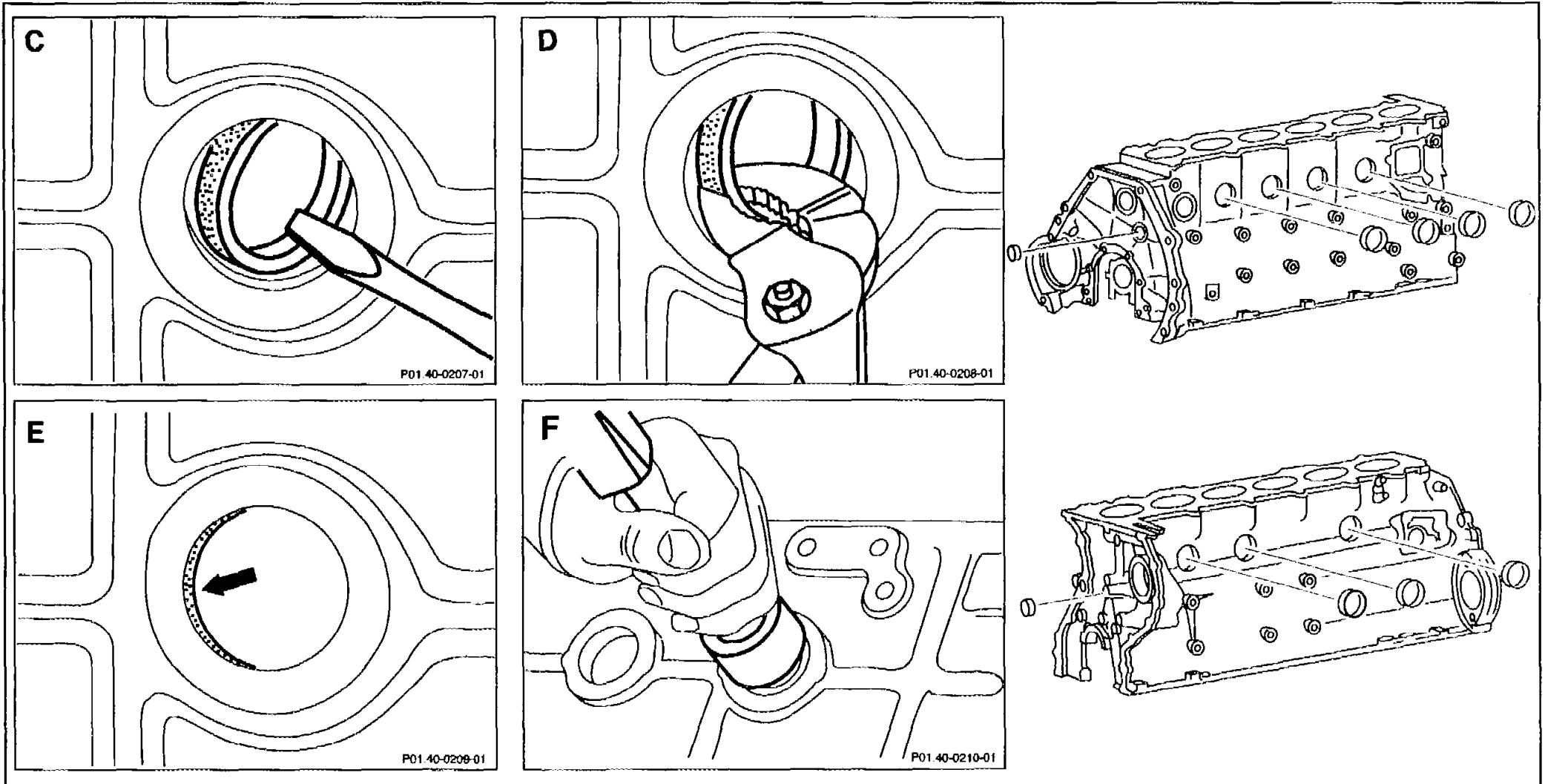
H8





AR01.40-P-8499HA




Replacing core hole plugs in crankcase

10.2.94

ENGINE 111 / , 602.982 /983 / , 604, 605, 606 (except 111.920 /921)

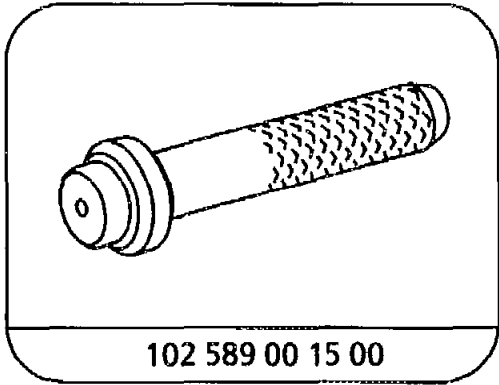


	Removing		
1	Drain coolant	Engine 111 Engine 602, 604, 605, 606 except 606 in model 463	AR20.00-P-1142HG AR20.00-P-1142HW
		Engine 606 in model 463	AR20.00-P-1142GG
		Engine 602 in model 461	AR20.00-P-1142HA
2	Remove attached parts in the area of the leaking core hole plug	Engine 111 ↓ Arrangement of core hole plug	AR01.40-P-8499-01A D16
3	Use e.g. a screwdriver to knock in core hole plug sufficiently on one side until it has turned	see Fig. C	
4	Pull out core hole plug at the collar	see Fig. D	
	Installing		
5	Thoroughly clean core hole	 The adhesive surfaces should be free of oil, water and rust, see (fig. E, arrow). Pay attention to manufacturer's instructions!	
6	Spray sealing surface with activator		BR00.45-Z-1001-02A
7	Coat core hole with sealant		BR00.45-Z-1001-02A
8	Use an insertion drift to knock in new core hole plug flush (Fig. F)		102 589 00 15 00

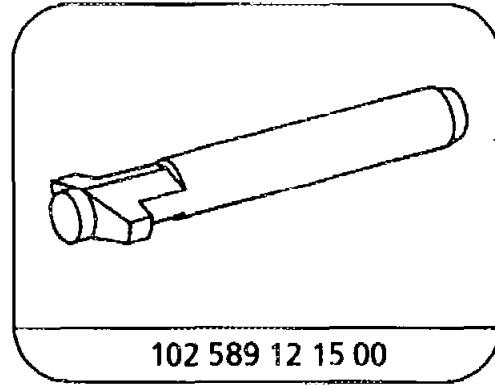
		  The sealant should harden for about 45 minutes before pouring in coolant	102 589 12 15 00
9	Install attached parts		
10	Pour in coolant	Engine 111 Engine 602, 604, 605, 606 except 606 in model 463 Model 463 Model 461	AR20.00-P-1142HG AR20.00-P-1142HW AR20.00-P-1142GG AR20.00-P-1142HA
	Notes on coolant	All models	AH20.00-N-2080-01A E17
11	Run engine and inspect cooling system for leaks		AR20.00-P-1010HA

Repair product

Number	Designation	Order number
BR00.45-Z-1001-02A	Loctite 241 adhesive compound	002 989 94 71



Drift



Drift