



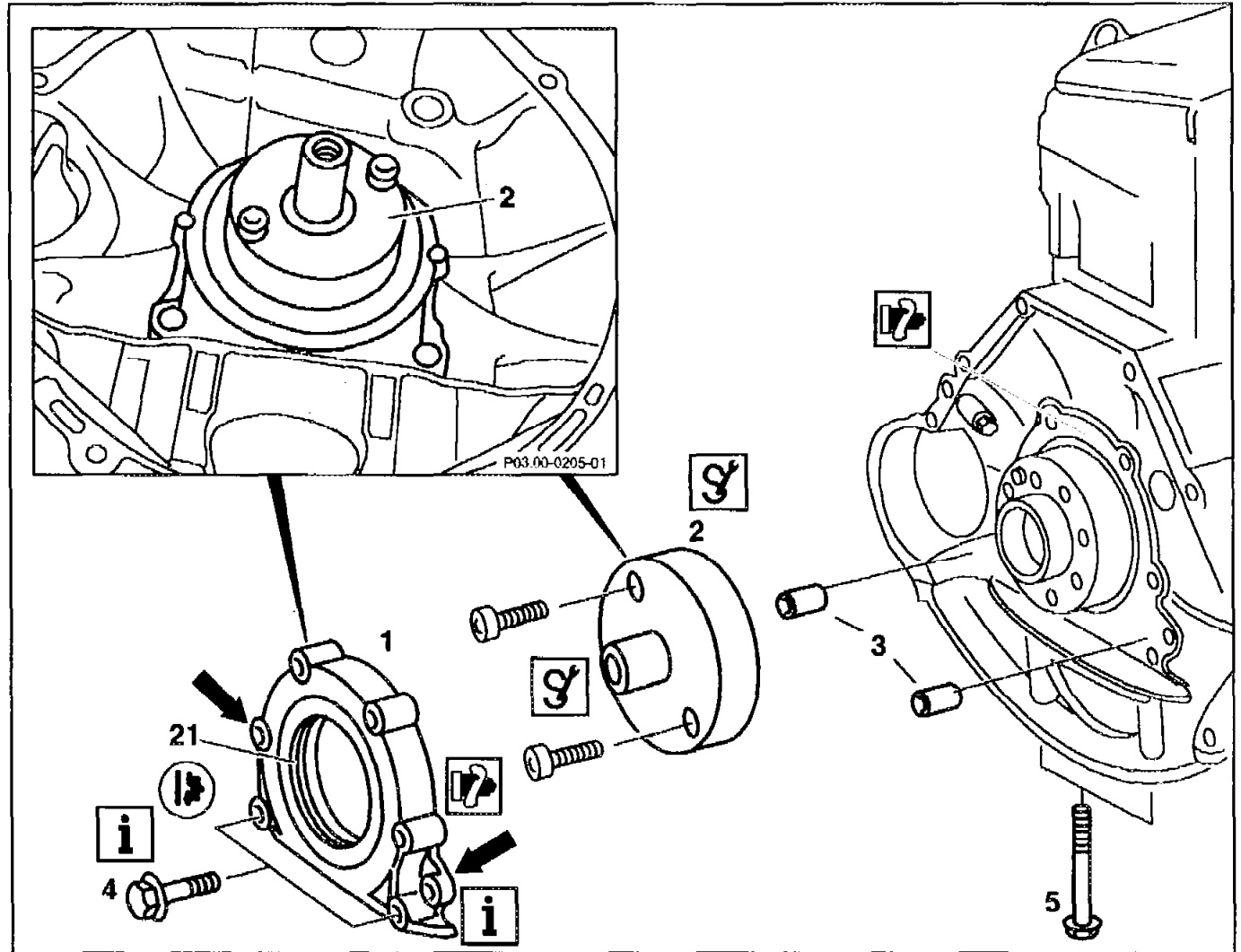
M8

AR01.40-P-8913HA

Removing, installing end cover




10.2.94

ENGINE 111, 602.982 /983 /, 604, 605, 606



**Modification notes**

1.6.95	Technical modification: Interference-fit seal is replaced by vulcanized seal in the end cover.	Operation 6	AR03.30-8913HA
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 	<b>Removing, installing</b>		
	The radial seal on standard production engines is vulcanized to the end cover. This end cover is not supplied as a replacement part. For repairs, install end cover with interference-fit radial seal.		
1.1	Remove manual transmission	Model 140, 202, 210 Model 163	AR26.10-P-0020A AR26.10-P-0020GH
1.2	Remove automatic transmission	Model 140, 202, 210 Model 461,463 with transmission 722.3 Model 463	AR27.10-P-0500A AR27.10-P-0500G AR27.10-P-0500BD
2.1	Remove clutch	Manual transmission	AR25.10-P-0050A
3	Remove flywheel, two-mass flywheel or driven plate, respectively	Engine 111 Engine 602.982/983, 604, 605, 606	AR03.30-P-8001A AR03.30-P-8001HA
4	Determine oil leakage	If leak present at radial seal ↓ Replace rear crankshaft radial seal	AR03.20-P-3063HA



		<p>If cause of oil leakage cannot be clearly determined ↓</p> <p>inspect rear of engine for external oil leaks, determine.</p>	<p>AR01.40-P-8913-01HA</p> <p><b>P15</b></p>
5	Unscrew bolts (4, 5)	<p> Engine 602.982/983</p> <p> Engine 604, 605, 606</p> <p> <b>Installation:</b> first of all tighten bolts (4) at end cover.</p> <p> Engine 111</p>	<p>BA01.40-N-1003-01B</p> <p>BA01.40-P-1005-01A</p> <p>BA01.40-P-1004-01G</p>
6	<p>Press off end cover (1)</p> <p> <b>BT</b></p> <p>End cover with vulcanized radial seal</p>	<p>Press end cover with radial seal off the crankcase at the shoulders (arrows). Do not damage the oil pan gasket when pressing off end cover!</p> <p> <b>Installation:</b> if vulcanized radial seal fitted: When carrying out repairs, press new radial seal (21) into new cover at rear, install.</p> <p> <b>Installation:</b> attach inner part of the  insertion tool (2) to the crankshaft.</p> <p>Clean contact surfaces of end cover (1), coat with sealant.</p> <p> Sealant alternatively</p>	<p>BT01.40-P-0001-01A</p> <p><b>A18</b></p> <p>111 589 08 43 00</p> <p>BR00.45-Z-1010-01A</p> <p>BR00.45-Z-1014-01A</p>

		<p>Oil the sealing lip of the radial seal (21) and the mating contact surface.</p> <p>ⓘ Do not use grease! Grease prevents the sealing lip of the radial seal transporting back the engine oil.</p> <p>ⓘ Pay attention to the oil pan gasket when pressing on the end cover! Pay attention to dowel sleeves (3).</p>	
7	Inspect crankshaft radial seal (21)	<p>If necessary, after inspecting ↓ replace rear crankshaft radial seal.</p> <p>ⓘ If necessary, install radial seal after fitting on end cover.</p>	AR03.20-P-3063HA
8	Install in the reverse order	<p>ⓘ Before installing the transmission, inspect for oil leaks ↓</p> <p>ⓘ Inspecting rear of the engine for external oil leaks, determining.</p>	AR01.40-P-8913-01HA <b>P15</b>

**Nm** Crankcase, timing case cover, end cover

Number	Designation	Engine 602.982/98 3
BA01.40-N-1003-01B	Bolts of end cover to crankcase	Nm 10

**Nm** Crankcase, timing case cover, end cover

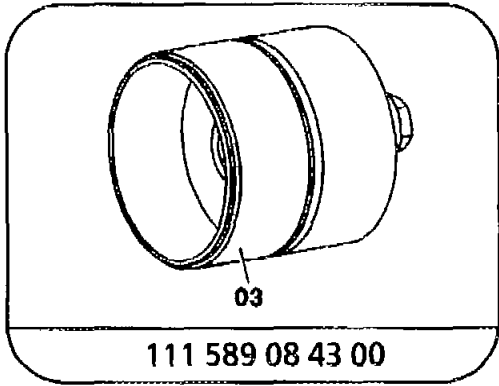
Number	Designation	Engine 111
BA01.40-P-1004-01G	Bolt of end cover	Nm 10

**Nm** Crankcase, timing case cover, end cover

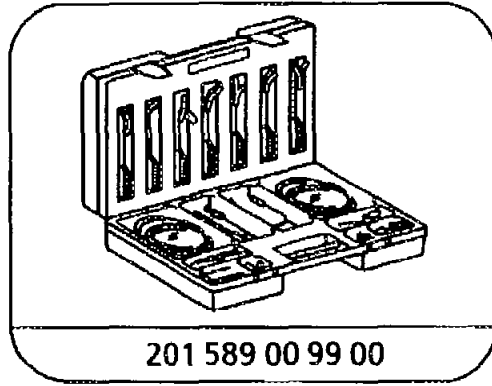
Number	Designation	Engine 604, 605, 606
BA01.40-P-1005-01A	End cover to rear of crankcase	Nm 10

**Repair products**

Number	Designation	Order number
BR00.45-Z-1010-01A	Loctite 574 sealant (50 ml)	001 989 89 20 10
BR00.45-Z-1014-01A	Omnifit FD 3041 sealant (50 ml)	002 989 47 20 10
BR00.45-Z-1001-03A	MB contrast spray	000 989 03 59



Insertion tool



Electrical connection set