



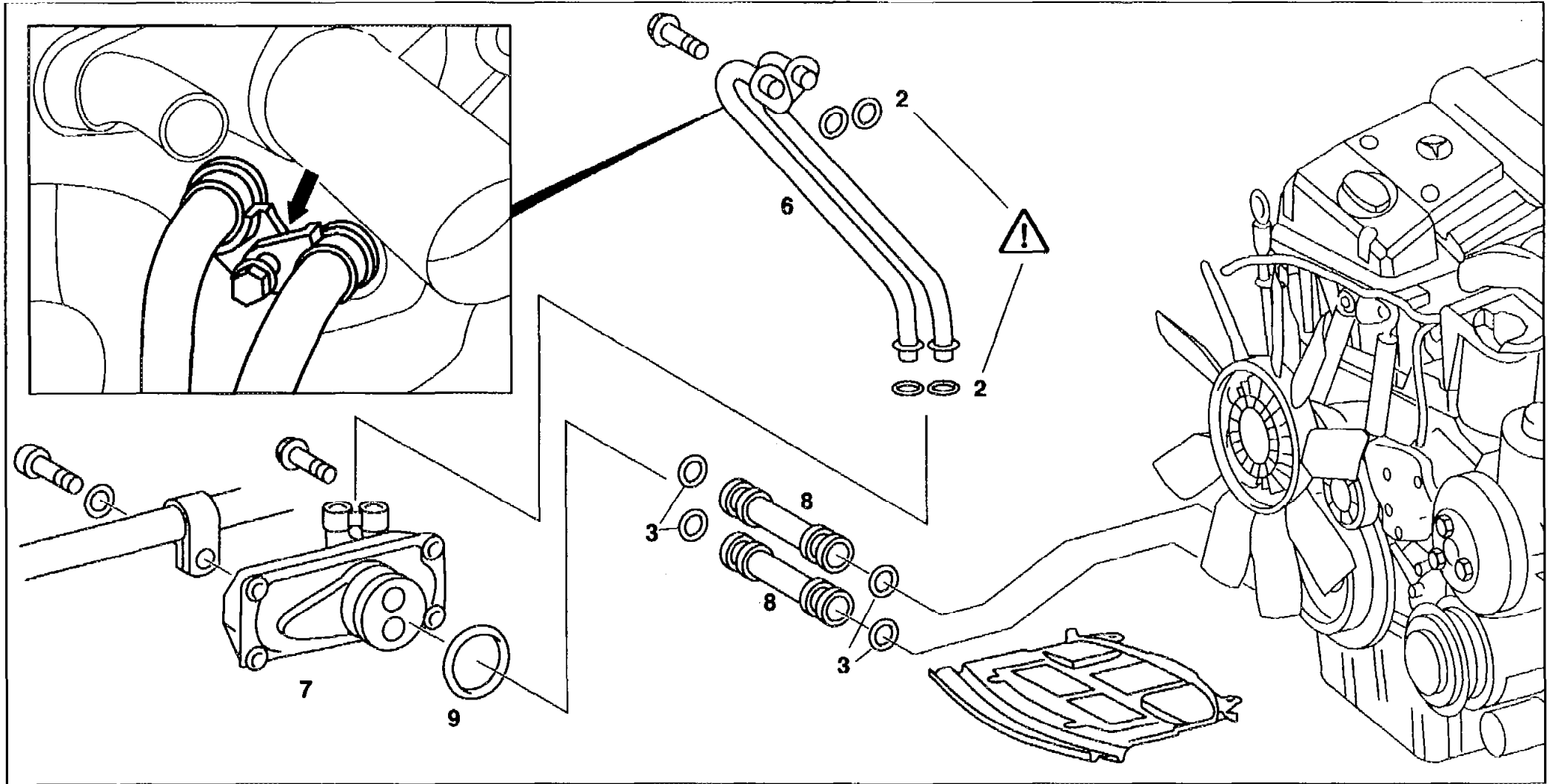
<b>M3</b>	AR18.30-P-3480HA	<b>Removing, installing oil-to-water heat exchanger at oil sump</b>	<b>2.4.93</b>
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**ENGINE 605, 606**

*in MODEL 124*

**ENGINE 604, 605**

*in MODEL 202 up to 30.6.94*



P18.30-0200-09



Removal, installation



<b>⚠ Danger!</b>	<b>Risk of injury</b> to skin and eyes from scalding from hot coolant which splashes out. <b>Risk of poisoning</b> from swallowing coolant.	Do not open the cooling system unless the coolant temperature is below 90 °C. Open cap slowly and allow the pressure to release. Do not pour coolant into containers for drinks. Wear protective gloves, protective clothes, and eye protection.	AS20.00-Z-0001-01A <b>J17</b>  AR20.00-P-1142HA
1	Drain coolant		AR20.00-P-1142HA
2	Drain engine oil		AP18.00-P-0101AA
3	Unbolt pipes of oil-to-water heat exchanger (6) at coolant pump housing, pull out	<b>i</b> Installation: Pay attention to installed position (arrow) of pipe brackets	
4	Unbolt oil-to-water heat exchanger (7) at oil sump	<b>i</b> Installation: Replace O-ring (9)	
5	Remove pipes of oil-to-water heat exchanger (6) and connecting pipes to oil pump (8)	<b>i</b> Installation: Replace O-rings (2, 3). Coat O-rings with coolant before installing; do not use engine oil	
6	Install in the reverse order		