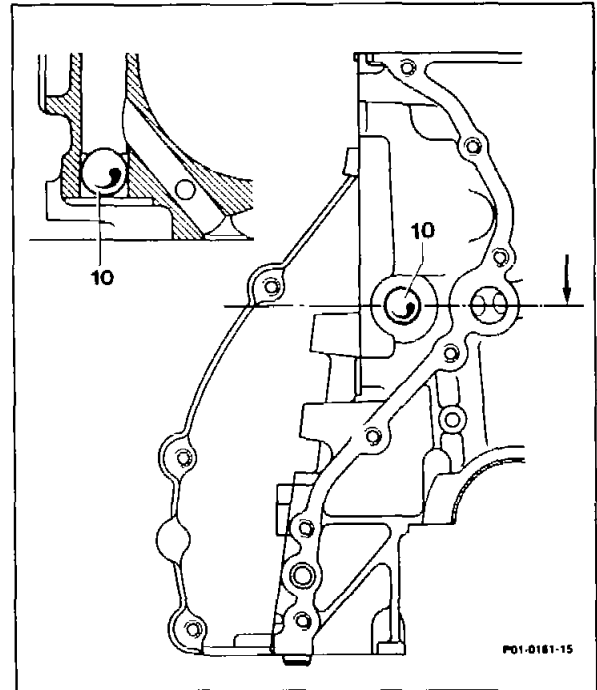
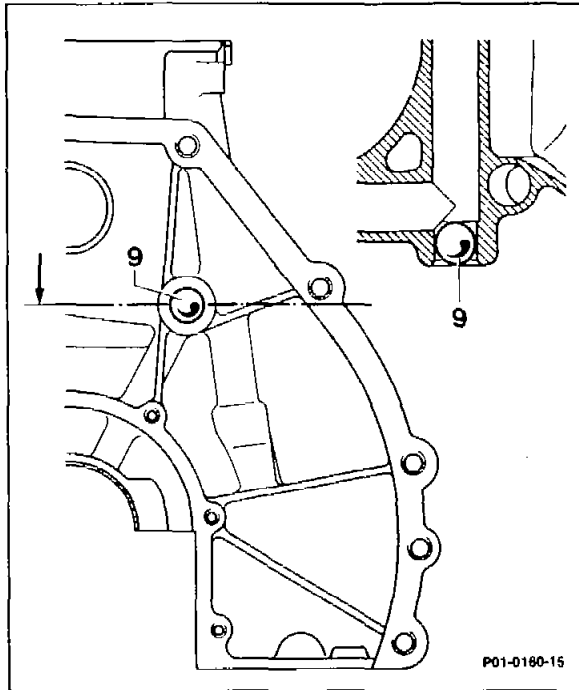


01-130 Knocking out and Inserting steel balls in main oil duct

Preceding work:
Coolant pump removed with housing (20-210).
Flywheel removed (03-410).

Operation no. of operation texts and work units or standard texts
and flat rates 01-8561



Steel ball, rear, 15 mm dia. (9)

Steel ball, front, 17 mm dia. (10)

Steel balls (9, 10) knock out, insert.
Punch 601 589 08 15 00 (steps 1 - 4).

Note
If not damaged the steel balls can be reinstalled a number of times. In the event of leakage reseal steel balls approx. 1 mm deeper (dimension marked on punch).
Leaky steel balls replace with plug, remedy measures (steps 6 - 8).
After reassembling engine warm up engine and check for leakage in area of steel balls.

Tightening torque	Nm
Plug as replacement for steel balls	50

Replacement parts for steel balls**Part no.**

Plug M 18 × 1.5 (front)

000 908 018 002

Plug M 16 × 1.5 (rear)

000 906 016 002

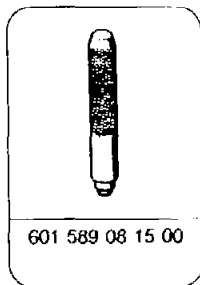
Gasket A 18

007 603 018 103

Sealant for replacement of rear steel ball

Loctite 241

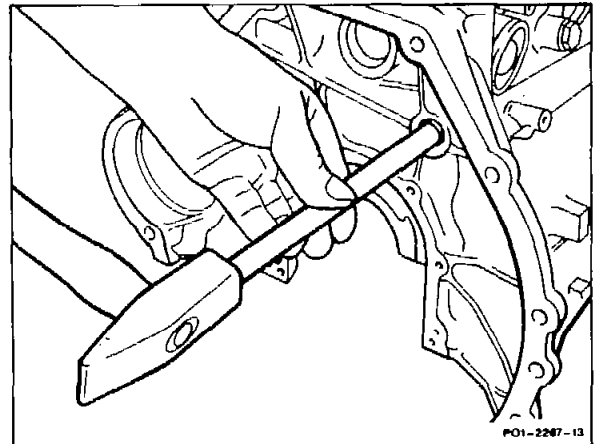
002 989 94 71

Special tool**Knocking out**

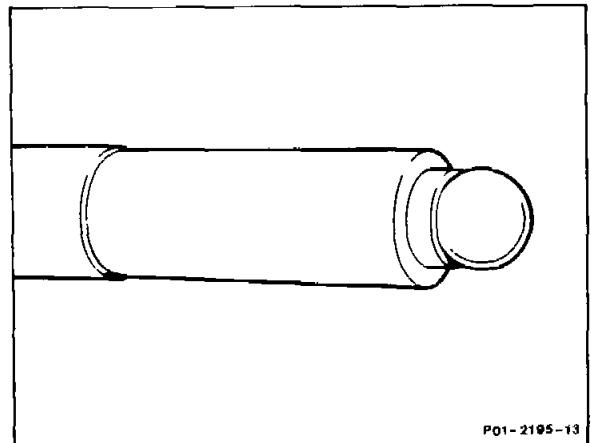
- 1 Knock out both steel balls from rear toward front with suitable steel rod.

Note

The steel balls can be reused a number of times. Replace damaged balls under all circumstances.

**Inserting**

- 2 Thoroughly clean seat for steel ball in engine block.
- 3 Insert steel ball with slight quantity of grease on punch 601 589 08 15 00.

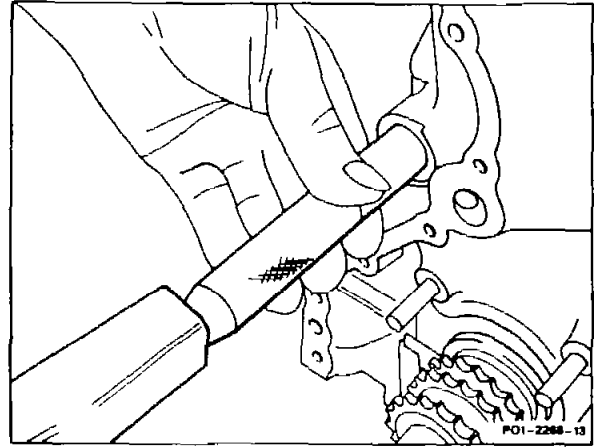


4 Position steel balls on hole and drive in to specified stop on punch.

5 After reassembling engine, warm up engine and check for leakage in area of steel balls.

Note

If one of the steel balls does not seal sufficiently after inserting or if leakage is present following leakage test, replace steel ball with plug.



Replacing steel ball with plug

6 Knock steel ball out again.

7 Cut thread in hole for leaky ball.

Note

Front bore M 18×1.5 10 mm deep

Rear bore M 16×1.5 14 mm deep

8 Thoroughly clean oil duct, screw in front plug with gasket and rear plug with sealant 002 989 94 71, tightening torque 50 Nm.