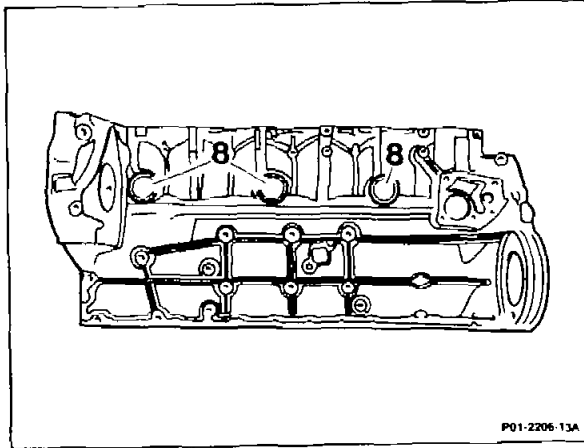


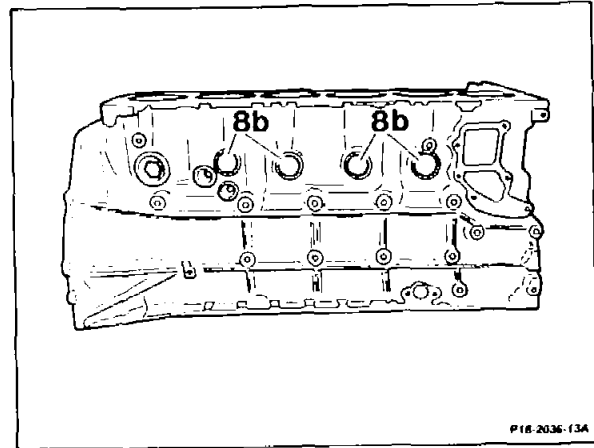
## 01-140 Replacement of core hole plug caps in crankcase

Preceding work:  
Coolant drained (20-010).  
Attachment parts in area of core hole plug cap removed.

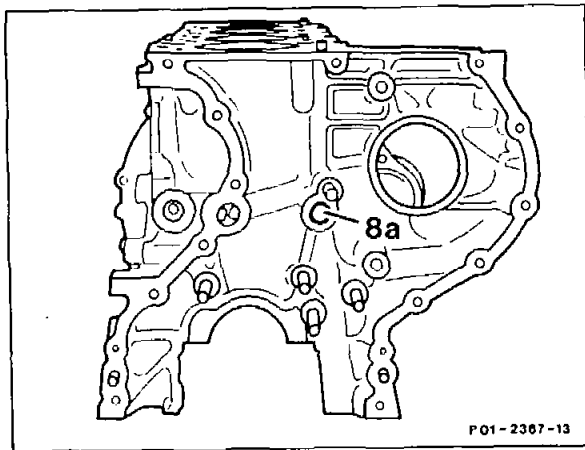
Operation no. of the operation texts and work units  
or standard texts and flat rates ..... 01-8501



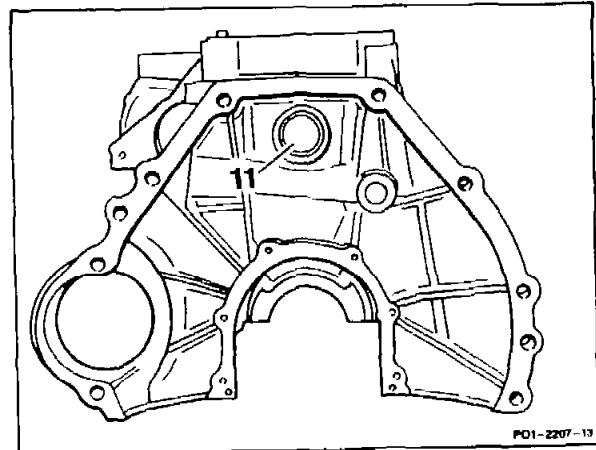
Core hole plug cap, left, 34 mm dia. (8)



Core hole plug cap, right, 34 mm dia. (8b)



Core hole plug cap, front, 17 mm dia. (8a)



Core hole plug cap, rear, 34 mm dia. (11)

Core hole plug caps (8, 8a, 8b, 11) .....

remove, knock in. Installation punch  
102 589 12 15 00, 17 mm dia. or punch  
102 589 00 15 00, 34 mm dia. (steps 1 - 6).

### Note

Seal core hole plug caps with sealant  
002 989 94 71. Allow sealant to harden  
for approx. 45 minutes.

After reassembling engine ..... allow engine to warm up and check for leakage at new core hole plug cap installed.

**Note**

The number of core hole plug caps differs on the individual engine models. The figure shows engine model 603 as an example.

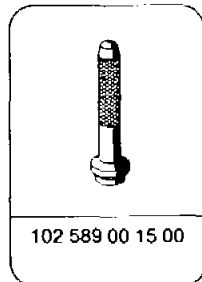
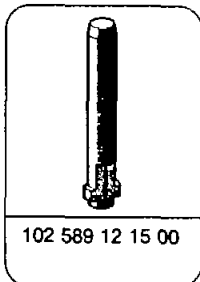
Engine	left, 34 mm dia.	right, 34 mm dia.	front, 17 mm dia.	rear, 34 mm dia.
601	2	2	1	1
602	3	3	1	1
603	3	4	1	1

**Sealant**

Loctite 241

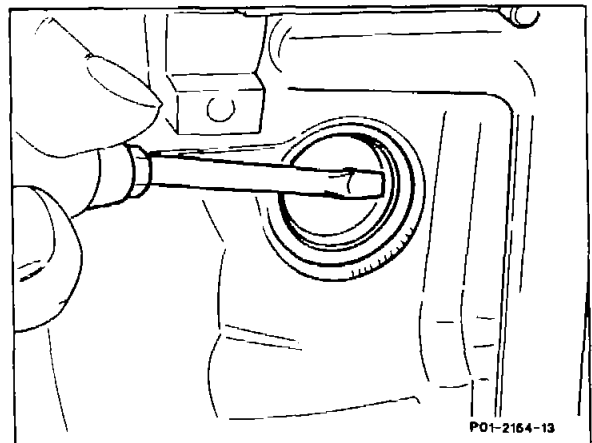
002 989 94 71

**Special tools**



**Removal**

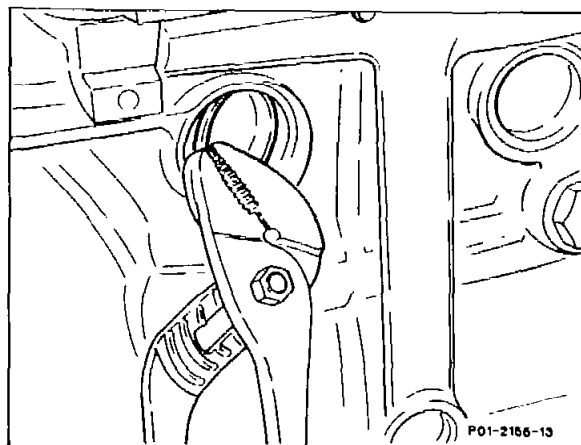
- 1 Position chisel with small blade or screw-driver in deep-drawn edge of core hole plug cap.



2 Carefully knock in core hole plug cap at one side until it rotates around its own longitudinal axis and can be gripped with a pair of pliers.

3 Pull out core hole plug cap.

4 Clean sealing surface; surface must be free of grease.



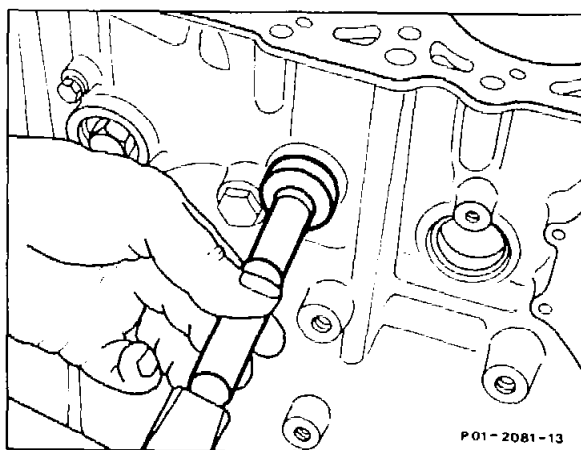
### Installation

5 Coat sealing surface with sealant 002 989 94 71.

6 Knock in new core hole plug cap with installation punch 102 589 12 15 00 (17 mm dia.) or 102 589 00 15 00 (34 mm dia.).



Allow sealant to harden for approx. 45 minutes before filling coolant.



7 After reassembling engine, allow engine to warm up and check for leakage at new core hole plug cap installed.