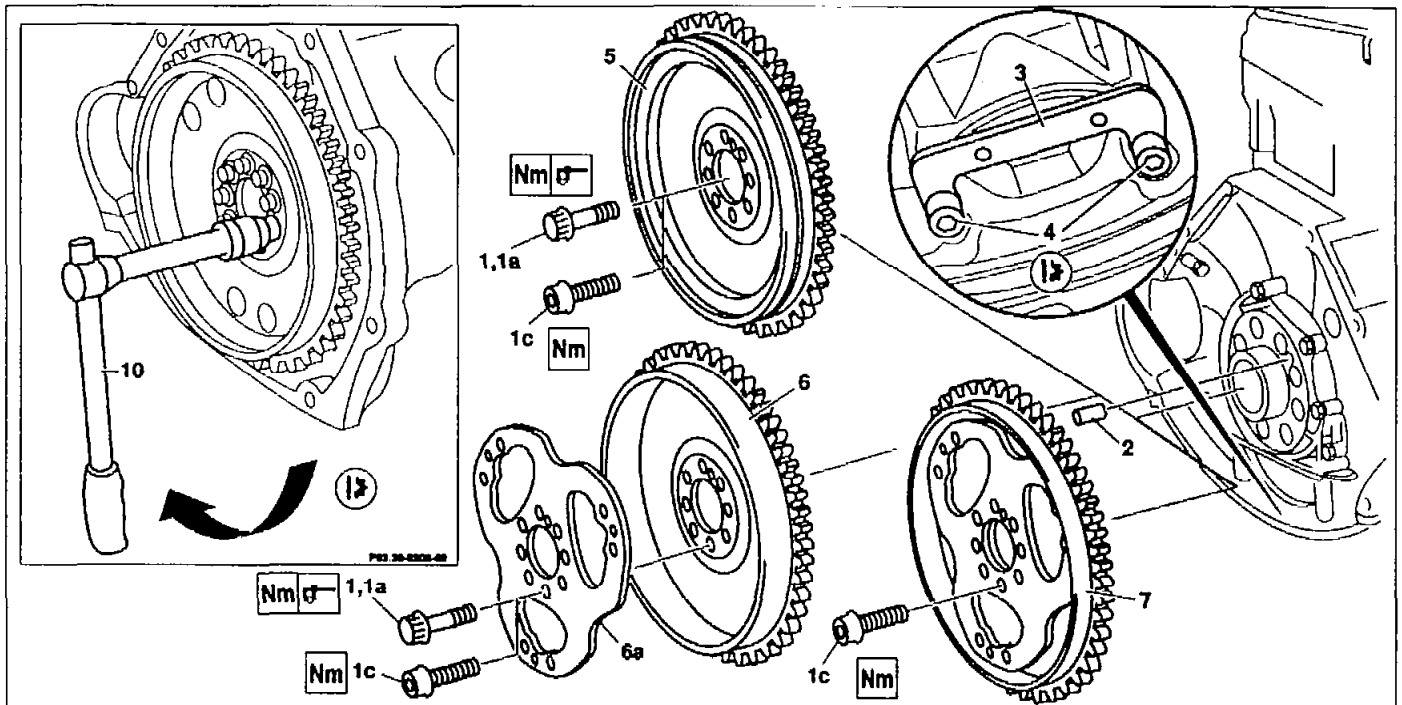


ENGINE 601, 602, 603 (except, 602.982)



P03.30-2007-09

| | Removing, installing | | |
|-----|---|---|--|
| 1.1 | Remove manual transmission | | |
| 1.2 | Remove automatic transmission | | |
| 2.1 | Remove clutch | manual transmission | AR25.10-P-0050A |
| 3 | Install retaining lock (3,4) for crankshaft/ring gear | Use M6×90 bolts, otherwise the threads in the rear end cover will be damaged. | 03-500 |
| 4 | Unscrew bolts (1, 1a, 1c) | Stretch shank bolts (1) Straight stretch shank bolts (1a) Torx bolts (1c) Replace Torx bolts and straight stretch shank bolts. Installation: If no torquing angle wrench is available, the bolts can be tightened further by the specified angle using a socket wrench and T arm (10) in a single step. Flexi-rod torquing wrench must not be used for tightening to angle degrees in order to eliminate any risk of angle errors. | 000 589 01 10 00 BA03.30-P-1004-01A BA03.30-P-1005-01A BA03.30-P-1007-01A |
| 5.1 | Inspect bolts (stretch shank bolts) (1) for flywheel/driven plate | If the minimum stretch shank \varnothing is reached, replace stretch shank bolts. | BE03.30-P-1001-01C |
| 6 | Take off flywheel (5), two-mass flywheel or flywheel (6) with driven plate (6a), or starter ring gear (7) | Straight pin (2) centers flywheel and driven plate. Flywheels do not need to be balanced and must not be interchanged. | |



| | | | |
|---|------------------------------|--|--|
| 7 | Install in the reverse order | | |
|---|------------------------------|--|--|

Test data of bolts for flywheel/driven plate

| Number | Designation | Engine 601,602 except 602.98, 603 with two-mass flywheel | Engine 601, 602 except 602.98, 603 manual and automatic transmission driven plate 1st version | | |
|--------------------|---|--|---|---------------|---------------|
| BE03.30-P-1001-01C | Flywheel or driven plate bolt (1st version) | Thread Ø (D) | M 10×1 | 10×1 | |
| | | Stretch shank Ø (d) | when new | mm 8.3–8.5 | 8.3–8.5 |
| | | | min. | mm 8.1 | 8.0 |
| | | Shank length (L) | when new | mm 56.8–57.2 | 21.8–22.2 |
| | | | max. | mm – | 22.5 |
| | | Part no. | | 103 032 00 71 | 102 032 00 71 |

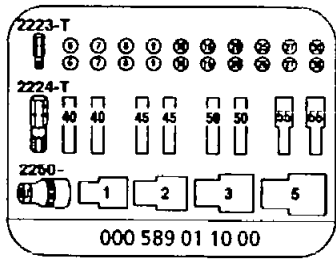
Test data of bolts for flywheel/driven plate

| Number | Designation | Engine 601, 602 except 602.98, 603 automatic transmission driven plate 2nd version | | |
|--------------------|---|--|----------|---------------|
| BE03.30-P-1001-01C | Flywheel or driven plate bolt (1st version) | Thread Ø (D) | M 10×1 | |
| | | Stretch shank Ø (d) | when new | mm 8.3–8.5 |
| | | | min. | mm 8.0 |
| | | Shank length (L) | when new | mm 25.8–26.2 |
| | | | max. | mm 26.5 |
| | | Part no. | | 601 032 01 71 |

Flywheel, driven plate, vibration damper, starter ring gear

| Number | Designation | Engine 601, 602, 603 with/without automatic transmission |
|--------------------|---|--|
| BA03.30-P-1004-01A | Stretch shank bolt for flywheel to crankshaft | 1st stage Nm 35 |
| | | 2nd stage ∠° 90 |
| BA03.30-P-1005-01A | Torx or 12-point straight stretch shank bolt for flywheel/two-mass flywheel to crankshaft | 1st stage Nm 45 |
| | | 2nd stage ∠° 90 |
| BA03.30-P-1007-01A | Stretch shank bolt for two-mass flywheel to crankshaft | 1st stage Nm 40 |
| | | 2nd stage ∠° 90 |





Torx bit set