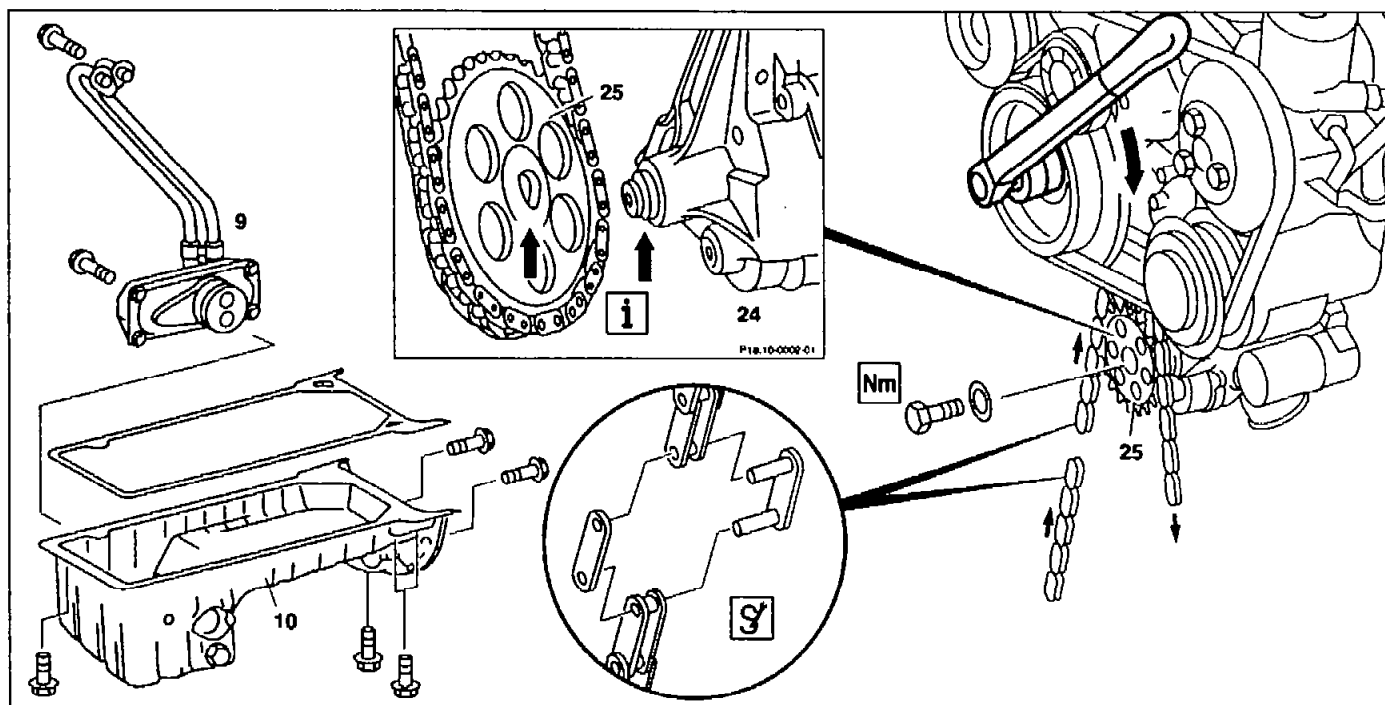


ENGINE 601, 602, 603 (except, 602.982)

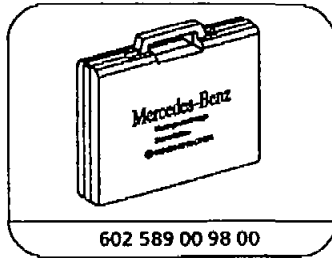


P18.10-0211-09

	Removing, installing		
1	Remove oil pan (10)	Engine 601, 602 in model 124, 201 Engine 603 in model 124 except 603.913/963 Engine 603 in model 126 Engine 603.913/963 in model 124 Engine 603.971 in model 140	AR01.45-P-7500HZ AR01.45-P-7500HX AR01.45-P-7500HY
2	Remove oil pump sprocket (25)	Installation: Install oil pump sprocket (25) with timing chain fitted on, with convex face (arrows) pointing toward oil pump (24).	
2	Separate oil pump chain	 	AR18.10-P-2140-01HA AR18.10-P-2140HW/2 602 589 00 98 00 602 589 05 63 00 602 589 02 33 00 602 589 05 63 01
4	Rivet oil pump chain	When replacing oil pump chain, also replace oil pump sprocket (25). 	AR18.10-P-2140-02HA AR18.10-P-2140HW/3 602 589 00 39 00 103 589 01 63 00 BA18.10-P-1001-01A
5	Install in the reverse order		

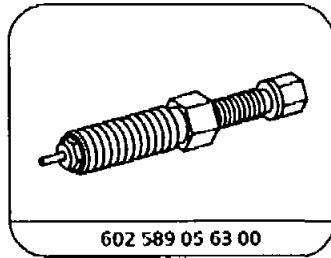
Nm Oil pump

Number	Designation	Engine 601, 602 except 602.98, 603
BA18.10-P-1001-01A	Bolt of chain sprocket to oil pump	Nm 25



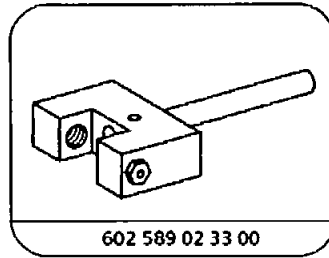
602 589 00 98 00

Case



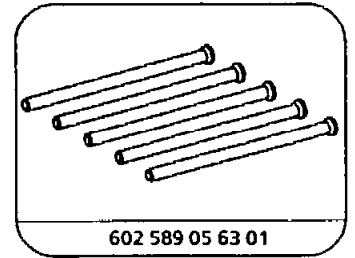
602 589 05 63 00

Thrust spindle



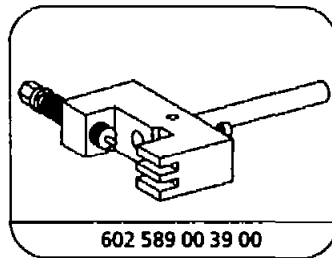
602 589 02 33 00

Chain separating tool



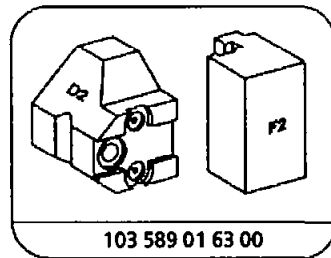
602 589 05 63 01

Thrust pins



602 589 00 39 00

Riveting tool



103 589 01 63 00

Assembly inserts

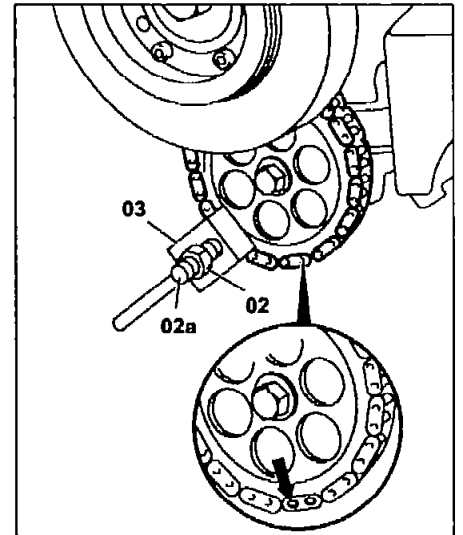
AR18.10-P-2140-01HA	Separating oil pump chain	<input checked="" type="checkbox"/> 602 589 02 33 00 Chain separating tool <input checked="" type="checkbox"/> 602 589 05 63 01 Thrust pins <input checked="" type="checkbox"/> 602 589 00 98 00 Case <input checked="" type="checkbox"/> 602 589 05 63 00 Pressing screw	
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Modification notes

6.5.96	Special tool modified and added Procedure modified	Operations 1–6	AR18.10-2140-01HA
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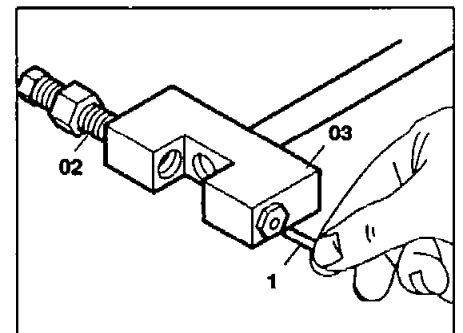


- 1 Screw thrust spindle (02) together with thrust pin (02a) into chain separating tool (03).
- 2 Fit chain separating tool (03) onto oil pump chain.
- i** Position chain separating tool (03) onto pins of oil pump chain.
- 3 Screw in thrust spindle (02) sufficiently until thrust pin (02a) makes contact with pin of oil pump chain.
- 4 Screw in thrust pin (02a) and press out pin of oil pump chain (arrow).



P18.10-0222-02

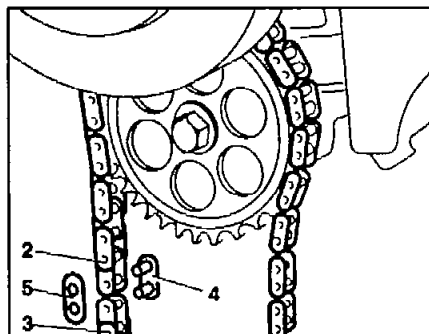
- 5 Unscrew thrust spindle (02) and take off chain separating tool (03).
- 6 Remove pressed-out oil pump chain pin (1) from chain separating tool (03).



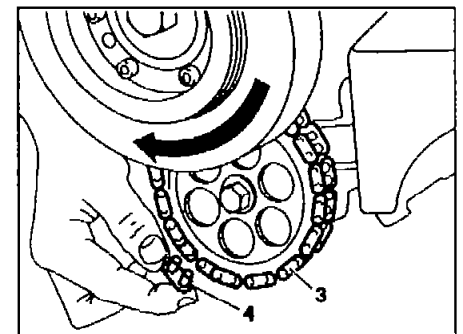
P05.10-0271-01

AR18.10-P-2140-02HA	Riveting oil pump chain	<input checked="" type="checkbox"/> 103 589 01 63 00 Assembly inserts <input checked="" type="checkbox"/> 602 589 00 98 00 Case <input checked="" type="checkbox"/> 602 589 00 39 00 Rivet opener	
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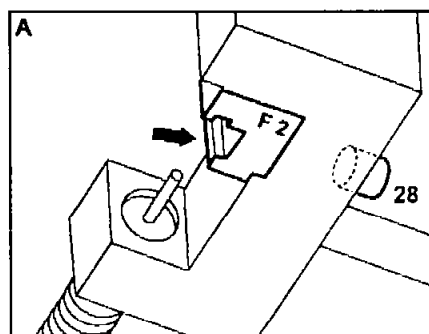
- 1 Connect new oil pump chain (3) to old oil pump chain (2) with the riveted link (4) and the outer plate (5).
- 2 Slowly rotate crankshaft in direction of rotation of the engine until the ends of the new oil pump chain (3) can be connected.
- 3 Detach old oil pump chain (2) and connect the ends of the new oil pump chain (3) with the riveted link (4).
- 4 Insert riveted link (4) from behind.
- 5 Insert guide piece with the number F2 into the riveting tool (arrow) and screw on with the screw (28) (Fig. A).
- 6 Place moving thrust piece with the figure 2 (arrow) into the riveting tool (Fig. B).



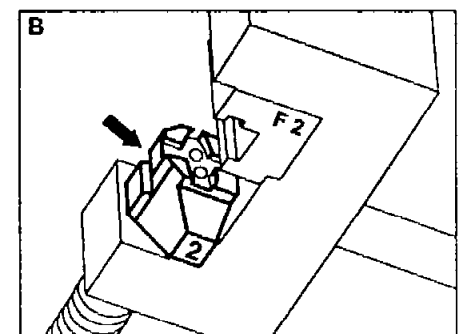
P18.10-0214-01



P18.10-0215-01

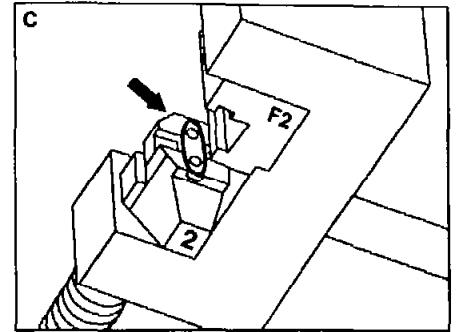


P18.10-0223-01



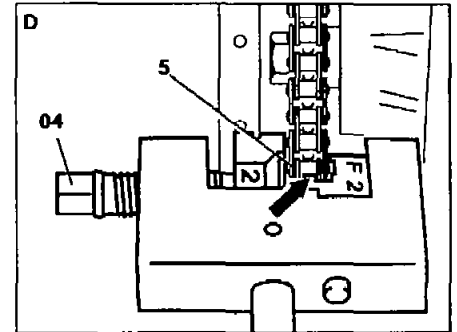
P18.10-0224-01

7 Insert outer plate (5) into the thrust piece with the figure 2 (arrow), (Fig. C).




P18.10-0225-01

8 Position riveting tool so that the spacer webs (arrow) are resting on the rollers of the riveted link (Fig. D).



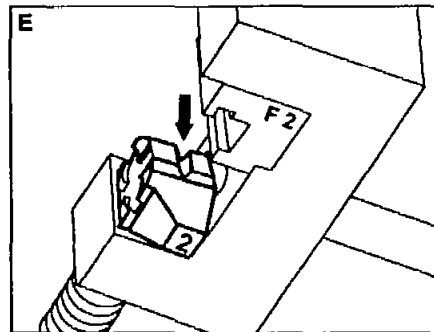
P18.10-0227-01

9 Tighten spindle (04) until firm resistance is felt.

 When turning the spindle (04), ensure that the pins of the riveted link move into the holes of the outer plate (5).

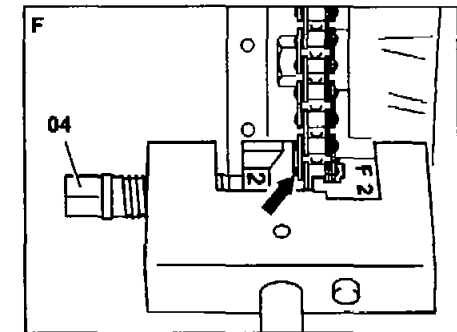
10 Take off riveting tool.

11 Turn over thrust piece with the figure 2 to the riveting profile (arrow), (Fig. E).




P18.10-0226-01

12 Position riveting tool exactly over the middle of the pin (arrow), (Fig. F).




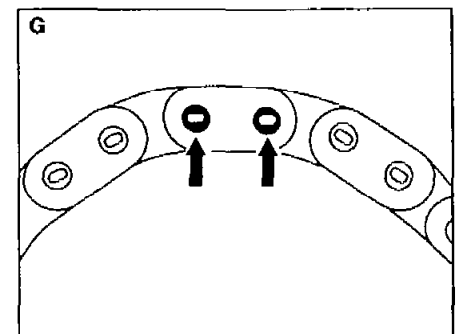
P18.10-0228-01

13 Tighten spindle (04).

 Torque at spindle (04) 30 – 35 Nm (reference value).

14 Rivet the pins of the riveted link individually.

15  Inspect riveting (arrows) and re-rivet if necessary (Fig. G).



P05.10-0213-01