

## ENGINE 271 in MODEL 171, 203, 209, 211
















- 1 Grooves
- 2 Drive gear
- 3 Drive gear
- 4 Pulley
- 5 Screw
- 6 Slide rail
- 7 Timing chain



P03.30-2059-06

## Modification notes

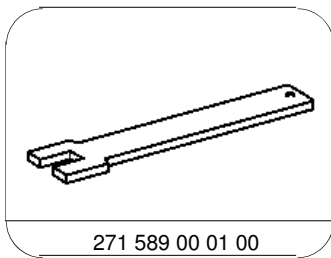
13.1.10	Value modified: Bolt, drive gear to Lanchester balance shaft, M14		*BA03.20-P-1001-02C
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	Removing		
 <b>Danger!</b>	<b>Risk of death</b> caused by vehicle slipping or toppling off the lifting platform.	Align vehicle between the columns of the lifting platform and position the four support plates at the lifting platform support points specified by the vehicle manufacturer.	AS00.00-Z-0010-01A
1	Raise vehicle		
2	Remove oil pan	Model 171 Model 203, 209 Model 211	AR01.45-P-7500V AR01.45-P-7500QK AR01.45-P-7500TK
3	Crank engine at crankshaft in direction of rotation until piston on first cylinder is positioned at TDC	 The grooves (1) at the drive gears (2, 3) for Lanchester-balance shaft are horizontal and point in direction of the guide pulley (4).	
4	Counterhold Lanchester-balance shaft with open wrench and unscrew bolt (5) of drive gear (3)	 Open-end wrench	*271589000100
5	Press slide rail (6) at chain tensioner to the inside and remove timing chain (7)		
6	Remove drive gear (3)		
7	Disconnect timing chain (7) for Lanchester balancer	 Case  Chain separating tool  Thrust spindle  Pressure pins	AR03.20-P-1200-01Q *602589009800 *602589023300 *602589046300 *602589046301
	Install		
8	Pull in timing chain of Lanchester balancer	 Case  Assembly links	AR03.20-P-1200-03Q *602589009800 *602589024000
9	Rivet timing chain of Lanchester balancer	 Case  Assembly inserts  Riveting tool	AR03.20-P-1200-02Q *602589009800 *271589026300 *602589003900
10	Slide drive gear (3) onto Lanchester-balance shaft and fasten with bolt (5)		*BA03.20-P-1001-02C

11	Rotate engine at crankshaft in direction of rotation until piston in the first cylinder is positioned at TDC	ⓘ Grooves (1) on drive wheels (2, 3) of the Lanchester balance shafts must be horizontal and must point in the direction of the guide pulley (4). Otherwise this can lead to a rough running of the engine.	
12	Installing oil pan	Model 171 Model 203, 209 Model 211	AR01.45-P-7500V <b>AR01.45-P-7500QK</b> AR01.45-P-7500TK
<b>⚠ Danger!</b>	<b>Risk of accident</b> caused by vehicle starting off by itself when engine is running. <b>Risk of injury</b> caused by contusions and burns during starting procedure or when working near the engine as it is running	Secure vehicle to prevent it from moving by itself. Wear closed and snug-fitting work clothes. Do not touch hot or rotating parts.	<b>AS00.00-Z-0005-01A</b>
13	Check for leaks with engine running		

**Nm** Balance shaft

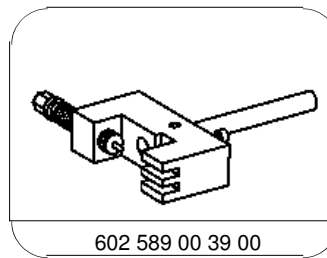
Number	Designation	Engine 271	
BA03.20-P-1001-02C	Bolt, drive gear to Lanchester balance shaft	M8	Nm 22
		M14	Nm 100



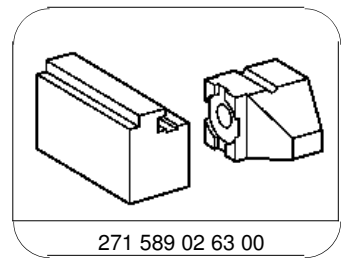
Open end wrench



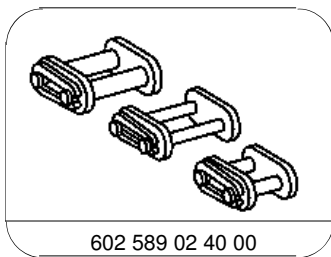
Case



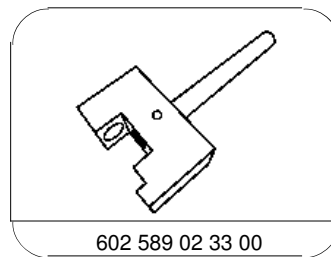
Riveting tool



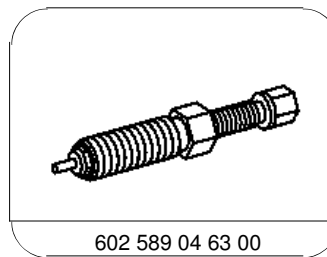
Assembly inserts



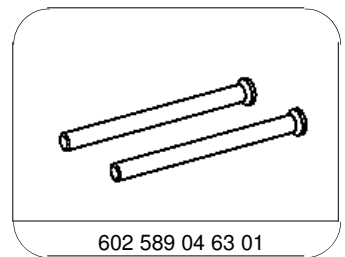
Assembly links



Chain separating tool



Thrust spindle



Thrust pins