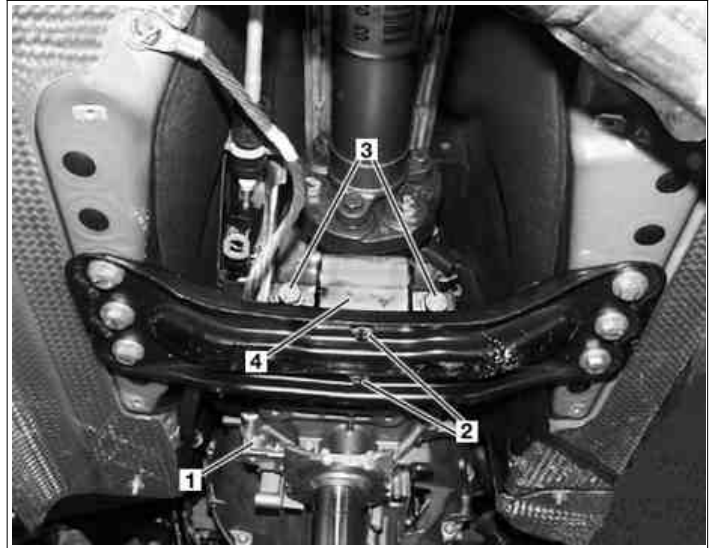


**ENGINE 112, 113, 271, 646 in MODEL 209**  
**ENGINE 111, 112, 113, 271, 646 (except , 112.916 /953) in MODEL 203**

Shown on model 203.035 with transmission 716.6

- 1 Transmission
- 2 Bolts
- 3 Bolts
- 4 Rear engine mount



P22.10-2063-11

**Modification notes**

12.2.08	Basic data for engine 646 replaced	Operation step 3, 4	
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☒ ☒	<b>Remove/install</b>								
<b>⚠ Danger!</b>	<b>Risk of death</b> caused by vehicle slipping or toppling off of the lifting platform.	Align vehicle between columns of vehicle lift and position four support plates at vehicle lift support points specified by vehicle manufacturer.	AS00.00-Z-0010-01A						
1	Raise vehicle		AR00.60-P-1000P						
2	Support transmission (1)								
3	Remove bolts (2)	<table style="width:100%; border-collapse: collapse;"> <tr><td style="text-align: center;">Nm</td></tr> <tr><td style="text-align: center;">Nm</td></tr> <tr><td style="text-align: center;">Nm</td></tr> <tr><td style="text-align: center;">Nm</td></tr> <tr><td style="text-align: center;">Nm</td></tr> <tr><td style="text-align: center;">Nm</td></tr> </table>	Nm	Nm	Nm	Nm	Nm	Nm	*BA22.10-P-1002-01A *BA22.10-P-1002-01L *BA22.10-P-1002-01R *BA22.10-P-1001-01O *BA22.10-P-1004-03B *BA22.10-P-1002-01D
Nm									
Nm									
Nm									
Nm									
Nm									
Nm									
4	Remove bolts (3)	<table style="width:100%; border-collapse: collapse;"> <tr><td style="text-align: center;">Nm</td></tr> <tr><td style="text-align: center;">Nm</td></tr> <tr><td style="text-align: center;">Nm</td></tr> <tr><td style="text-align: center;">Nm</td></tr> <tr><td style="text-align: center;">Nm</td></tr> <tr><td style="text-align: center;">Nm</td></tr> </table>	Nm	Nm	Nm	Nm	Nm	Nm	*BA22.10-P-1006-01A *BA22.10-P-1006-01L *BA22.10-P-1006-01R *BA22.10-P-1002-01O *BA22.10-P-1003-03B *BA22.10-P-1006-01D
Nm									
Nm									
Nm									
Nm									
Nm									
Nm									
5	Remove rear engine mounts (4)	<b>i</b> Support transmission (1) and secure to prevent it from falling down.							
6	Install in the reverse order								

**Nm Engine suspension, engine mounts, engine supports**

Number	Designation	Engine 111 in model 203

BA22.10-P-1002-01A	Bolt, rear engine mount to rear engine crossmember	Nm	30
BA22.10-P-1006-01A	Bolt or nut, rear engine mount to transmission	Nm	50

**Nm** Engine mounts, engine supports

Number	Designation		Engine 113.988 in model 203.076/276
BA22.10-P-1002-01L	Bolt, rear engine mount to rear engine crossmember	Nm	30
BA22.10-P-1006-01L	Bolt or nut, rear engine mount to transmission	M8	Nm -
		M10	Nm 50

**Nm** Engine mounts, engine supports

Number	Designation		Engine 112.912/946 in model 203	Engine 112.961 in model 203
BA22.10-P-1002-01R	Bolt, rear engine mount to rear engine crossmember	Nm	30	28
BA22.10-P-1006-01R	Bolt or nut, rear engine mount to transmission	M8	Nm -	-
		M10	Nm 50	50

**Nm** Engine suspension, engine mounts, engine supports

Number	Designation		Engine 271 in model 203
BA22.10-P-1001-01O	Bolt, rear engine mount to rear engine crossmember	Nm	30
BA22.10-P-1002-01O	Bolt or nut, rear engine mount to rear bracket	Nm	50

**Nm** Engine mount, engine support (engine side)

<b>Number</b>	<b>Designation</b>	<b>Model</b> <b>209</b>
BA22.10-P-1003-03B	Bolt/nut, rear engine mount to bracket or transmission	Nm 50
BA22.10-P-1004-03B	Rear engine mount on engine support	Nm 28

**Nm** Engine suspension, engine mounts, engine supports

<b>Number</b>	<b>Designation</b>	<b>Engine</b> <b>646 in model</b> <b>203</b>
BA22.10-P-1002-01D	Bolt, rear engine mount to rear engine crossmember	Nm 30
BA22.10-P-1006-01D	Bolt or nut, rear engine mount to transmission	Nm 40