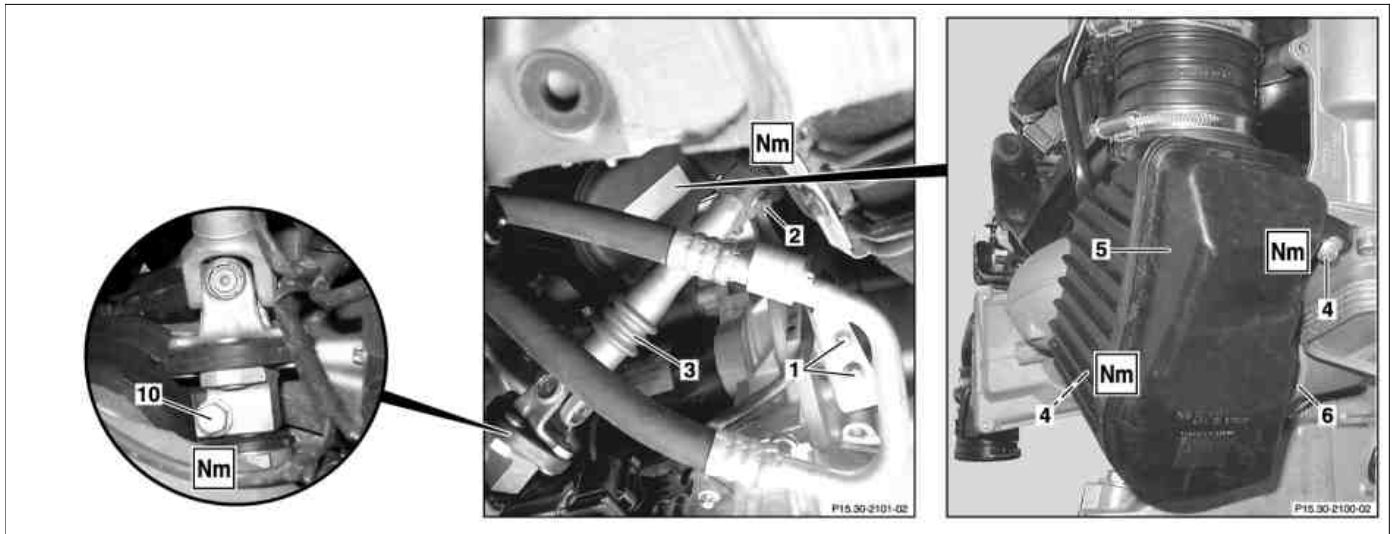


- ENGINE 271.940 in MODEL 203.042 /242 /742, 209.342 /442 with TRANSMISSION 716.6, 722.6
- ENGINE 271.942 in MODEL 203.043 /243 /743, 209.343 with TRANSMISSION 716.6, 722.6
- ENGINE 271.946 in MODEL 203.046 /246 /746 with TRANSMISSION 716.6, 722.6
- ENGINE 271.948 in MODEL 203.040 /240 /740 with TRANSMISSION 716.6, 722.6
- ENGINE 271.921 in MODEL 203.730 with TRANSMISSION 716.6, 722.6
- ENGINE 271.955 in MODEL 209.341 /441 with TRANSMISSION 716.6, 722.6
- ENGINE 271.957 in MODEL 203.741 with TRANSMISSION 716.6, 722.6



P15.30-2134-08

Shown on engine 271.940 in model 209.342

- 1 Bolts
- 2 Screw
- 3 Steering coupling

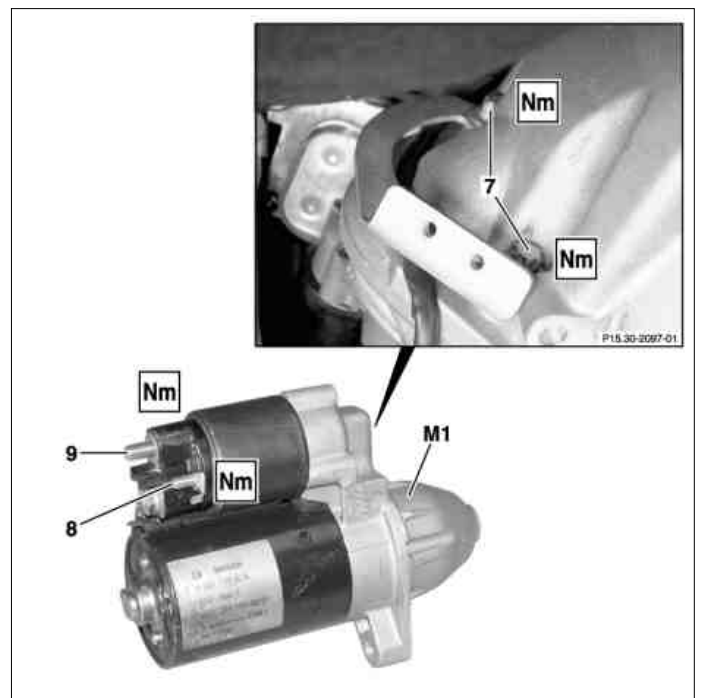
- 4 Bolts
- 5 Intake muffler

- 6 Compressor connection piece
- 10 Screw

Shown on engine 271.940 in model 209.342

- 7 Bolts
- 8 Electrical connection circuit 50
- 9 Electrical connection circuit 30

M1 Starter
























P15.30-2098-12

Modification notes

3.9.03	Check ring gear - added	Steps 13.1 and 13.2
--------	-------------------------	---------------------

	Remove/install		
--	----------------	--	--

 Danger!	Risk of death 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
 Danger!	Risk of explosion caused by escaping oxyhydrogen gas. Risk of injury caused by caustic burns to eyes, skin and mucous membranes from battery electrolyte (contains diluted sulfuric acid) or metal spatter due to short circuit. Risk of burn injuries caused by short circuit. Risk of poisoning caused by swallowing battery electrolyte (contains diluted sulfuric acid) or absorption of lead over the skin or orifices	No fire, sparks, open flames or smoking. Wear acid-resistant gloves and clothing and safety glasses with side guards. Do not place any conductive objects on the battery and avoid any short circuit from battery positive to ground. Only fill liquid battery electrolyte (diluted sulfuric acid) into suitable and appropriately marked containers.	AS54.10-Z-0001-01A
	Notes on self-locking nuts and bolts		AH00.00-N-0001-01A
1	Deactivate easy entry/exit function for driver seat and steering wheel	In vehicles with driver seat, steering column and electrically adjustable outside mirror with memory code 275  When easy entry/exit for the driver seat and steering wheel is activated, the seat will move into the memory position when the ignition is switched on or the driver door is opened and closed; thus the top frame can be damaged when the holding device is installed.  Deactivation takes place via the instrument cluster. Select Individual Settings in the main menu and follow menu instructions.	
2.1	Move the electrically adjustable steering column all the way out	In vehicles with driver seat, steering column and electrically adjustable outside mirror with memory code 275	
2.2	Open lock of steering column and pull out steering column fully, close lock	In the case of a mechanically adjustable steering column	
3	Rotate the steering wheel to the center position	 The front wheels must be in the straight-ahead position.	
4	Lock steering wheel	 With a disengaged steering coupling (3) the steering wheel should not be twisted because the clock spring contact will be destroyed.  Holding device	*129589012100
5	Disconnect ground line from battery	Model 203 Model 209	AR54.10-P-0003P AR54.10-P-0003Q AH54.10-P-0001-01A
	Notes on battery		
6	Detach lower engine compartment paneling		AR61.20-P-1105P
7	Detach refrigerant line	 Remove two bolts (1) and place refrigerant line to the side.	
8	Remove steering coupling (3)	 Pull out bolt (2) and steering coupling (3) from steering shaft. Remove bolt (10) and remove. Pry off steering coupling (3) from rack-and-pinion steering.  Bolt, steering coupling to steering shaft  Self-locking nut, steering coupling to rack-and-pinion steering	*BA46.10-P-1001-01E *BA46.10-P-1002-01E
9	Remove intake muffler (5)	 Remove bolts (4) of intake muffler (5) and pry off intake muffler (5).  Intake muffler to supercharger	*BA09.50-P-1004-01C
10	Remove line at electrical connection circuit 50 (8) at starter (M1)	 Nut for connection circuit 50	*BA15.30-P-1002-01A
11	Detach lines on electrical connection for circuit 30 (9) on starter (M1)	 Nut for connection circuit 30	*BA15.30-P-1001-01A
12	Remove starter (M1)	 Remove bolts (7) and remove starter (M1) from bottom.  Bolt connecting starter to crankcase	*BA15.30-P-1003-01A
13.1	Check ring gear at flywheel for wear and damage	When replacing starter (M1) on vehicles fitted with manual transmission  Rotate engine at crankshaft in direction of rotation.	
13.2	Check ring gear at the drive plate for wear and damage	When replacing the starter (M1) on vehicles fitted with automatic transmission  Rotate engine at crankshaft in direction of rotation.	
14	Install in the reverse order		

15	⚠ Danger! Risk of accident caused by vehicle starting off by itself when engine is running. Risk of injury caused by contusions and burns during starting procedure or when working near the engine as it is running Carry out function check	Secure vehicle to prevent it from moving by itself. Wear closed and snug-fitting work clothes. Do not touch hot or rotating parts.	AS00.00-Z-0005-01A
16	Perform basic programming	Model 203 Model 209	AR00.19-P-0200P AR00.19-P-0200Q
17	Read out fault memory and erase AD Connect STAR DIAGNOSIS and read out fault memory	i Stored faults which may be caused by assembly work, test work, removed lines or a simulation, must be processed and erased in fault memories after completing the work.	AD00.00-P-2000-04A

Nm Supercharger

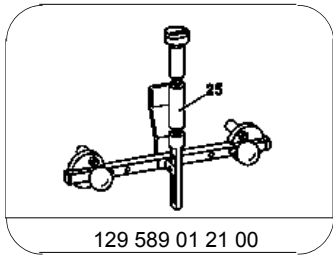
Number	Designation	Engine 271
BA09.50-P-1004-01C	Intake muffler to supercharger	M6 Nm 9

Nm Starter

Number	Designation	Engine 271
BA15.30-P-1001-01A	Nut, connection for circuit 30	Nm 14
BA15.30-P-1002-01A	Nut, connection for circuit 50	Nm 6
BA15.30-P-1003-01A	Bolt connecting starter to crankcase	Nm 40

Nm Steering shaft

Number	Designation	Model 203 except 203.081/ 084/087/ 092/281/ 284/287/ 292	Model 209	
BA46.10-P-1001-01E	Bolt, steering coupling to steering shaft	Stage 1	Nm 30	30
		Stage 2	4°	-
BA46.10-P-1002-01E	Locking screw and steering coupling locknut to rack-and-pinion steering	Nm	25	24



129 589 01 21 00

Holding device