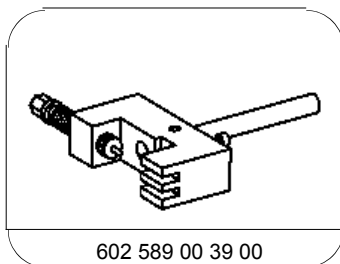
 **Timing chain, chain tensioner**

Number	Designation		Engine 271
BA05.10-P-1002-01F	Bolt for rivet element in timing chain (reference value)	Nm	32



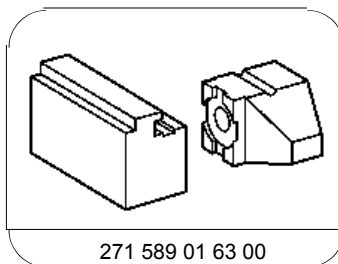
602 589 00 98 00

Case



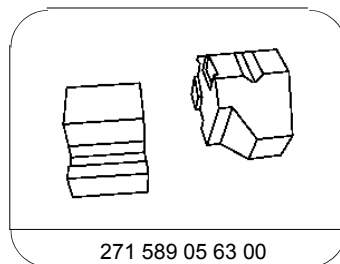
602 589 00 39 00

Riveting tool



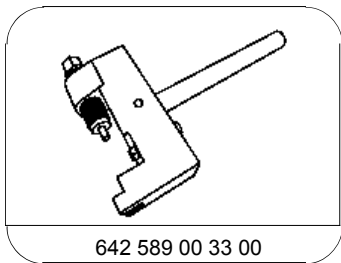
271 589 01 63 00

Assembly inserts




271 589 05 63 00

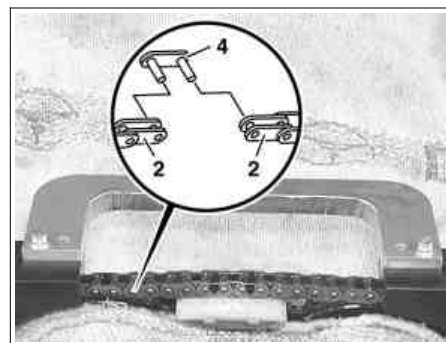
Assembly inserts



642 589 00 33 00

Holding device


- 1 Connect ends of the new timing chain (2) with a new riveted link (4).
 Insert riveted link (4) from the rear.

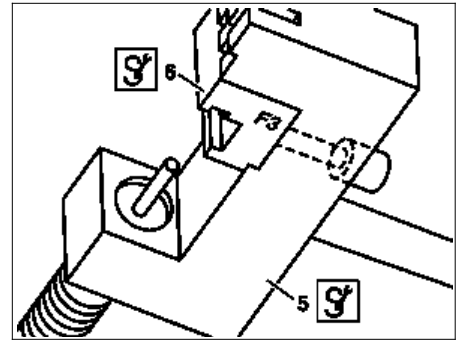


P05.10-2178-01

2 Lay assembly insert (6) into the rivet press tool (5) and attach.


 Use assembly insert F3 for engine 271.9.


 Use assembly insert F13 for engine 271.8.

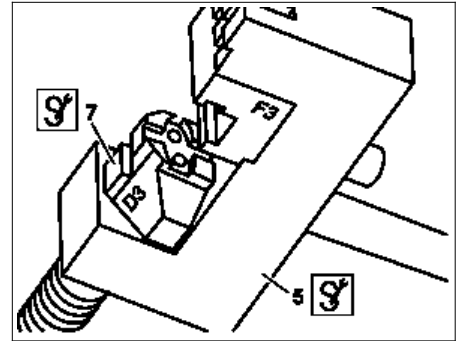


P05.10-2179-01

3 Insert assembly set (7) into riveting tool (5) as illustrated.


 Use assembly insert D3 for engine 271.9.

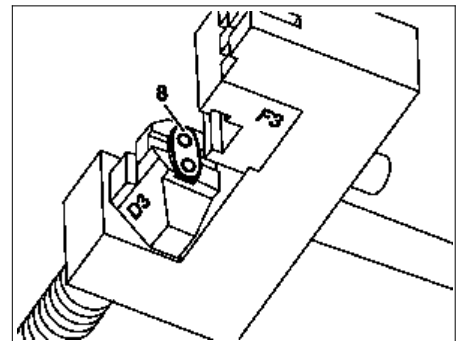
 Use assembly insert D16 for engine 271.8.



P05.10-2180-01


4 Place new outer plate (8) into the assembly insert (7).

 The outer plate (8) is held by a magnet.

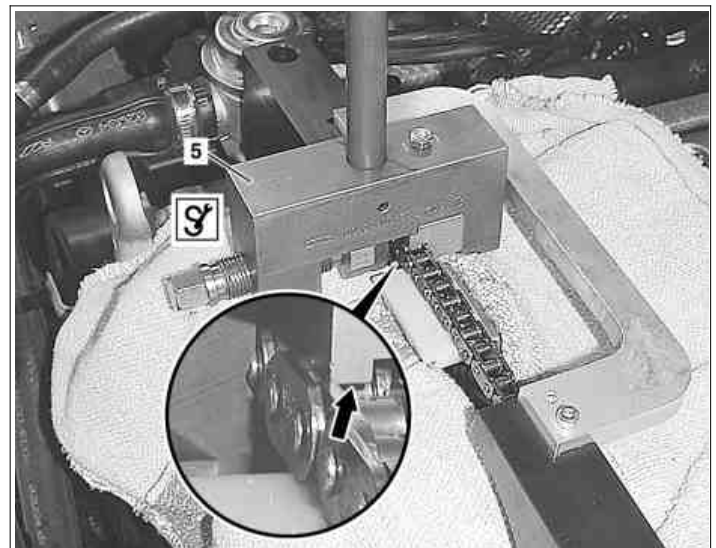


P05.10-2181-01

5 Put on rivet press tool (5) in such a way, that the spacer bushing (arrow) lies on the rolls of the riveted link (4). Screw in pressure screw at rivet press tool (5) until solid resistance is present.

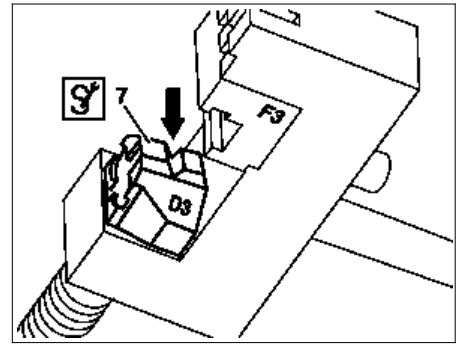
 When turning the spindle, ensure that the pins of the riveted link (4) move into the holes of the outer plate (8).

6 Take off riveting tool (5).



P05.10-2182-11


- 7 Turn assembly insert (7) on the illustrated rivet profile (arrow).



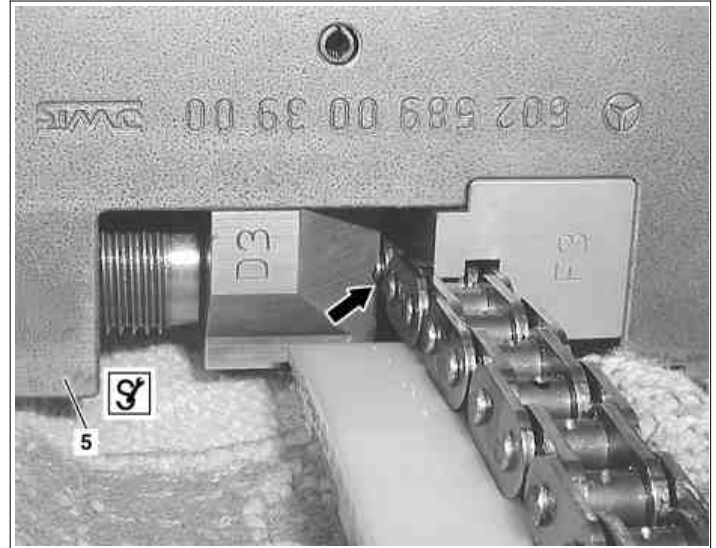
P05.10-2183-01

- 8 Fit on rivet press tool (5) exactly above the center of the pin (arrow).


 Rivet bolts for riveted link (4) individually.

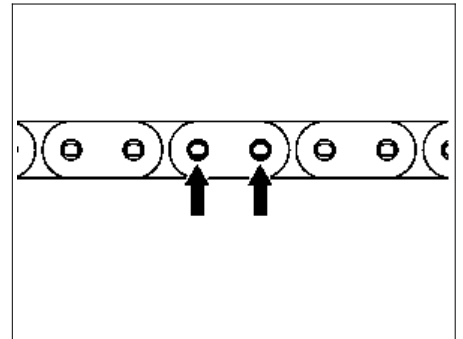
- 9 Tighten thrust spindle at riveting tool (5) 

- 10 Take off riveting tool (5).



P05.10-2184-11

- 11  Inspect riveting (arrows), re-rivet if necessary.



P05.10-2185-01