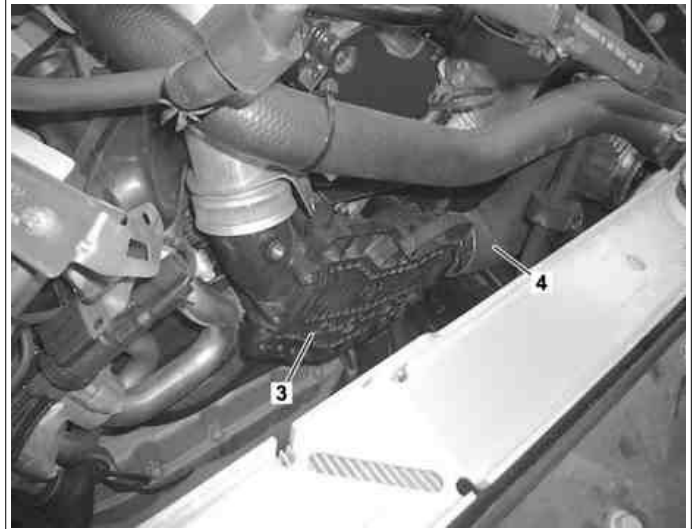


Model 463.306/336/346 with engine 642.886

Operation no. of the operation texts or standard texts and flat rates

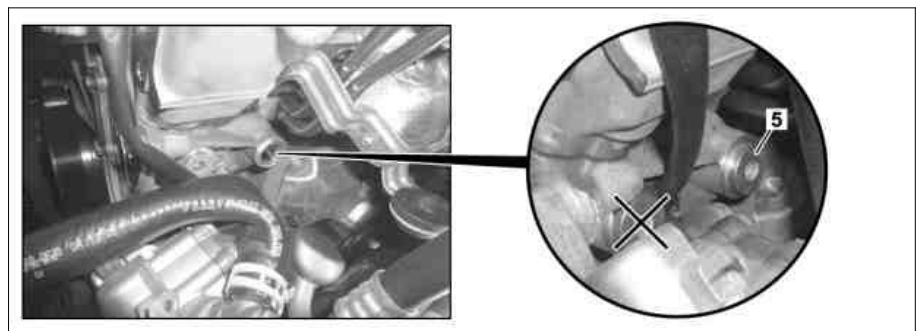
Category	Op. no.	Operation text	Time	Acc. no.	Code
P	02-8867	Retrofit engine oil cooler (after engine check)			

- 3 Noise damper  
4 Charge air hose



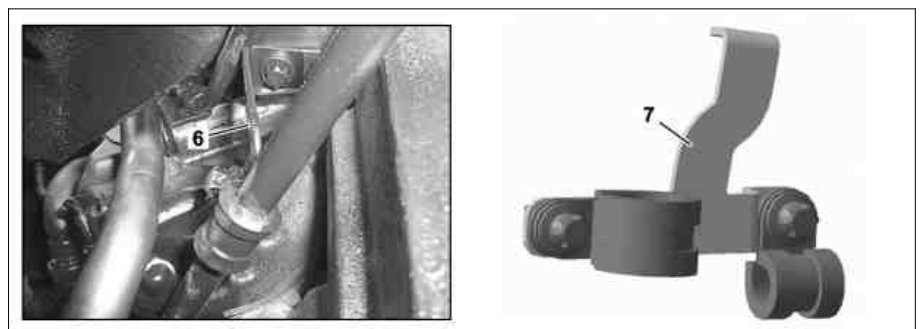
P01.10-3302-11

- 5 Screw plug



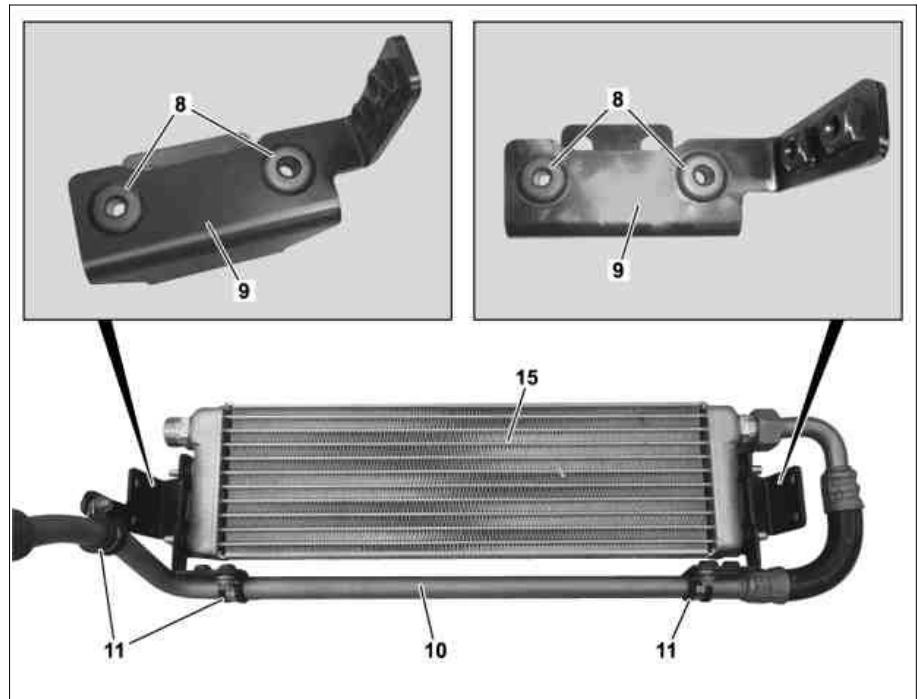
P01.10-3303-04

- 6 Bracket  
7 Bracket



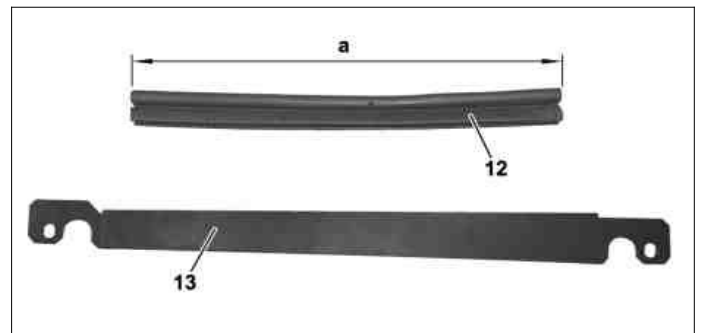
P01.10-3304-04

- 15 Oil cooler
- 8 Elastomer bearing
- 9 Oil cooler bracket
- 10 Oil line
- 11 Clamps



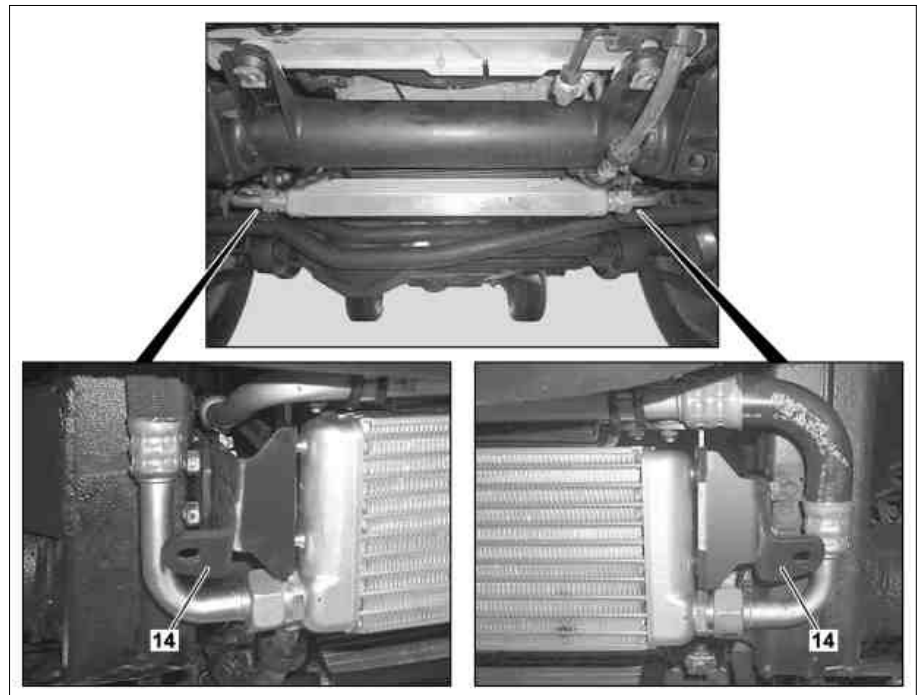
P01.10-3305-06

- 12 Antisqueak
- 13 Air baffle
- Maß a 320 mm



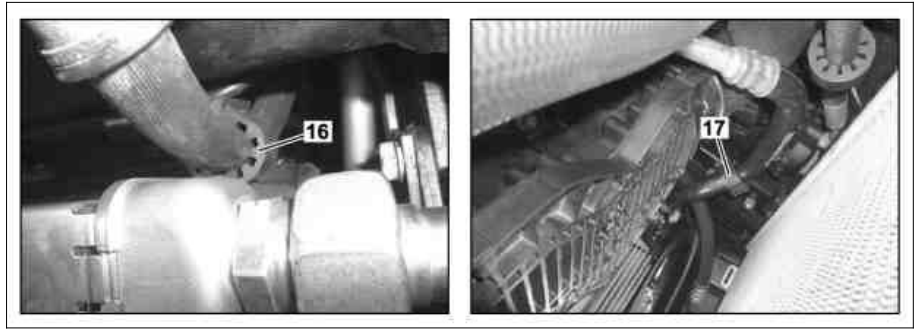
P01.10-3306-10

- 14 Bracket of underride guard



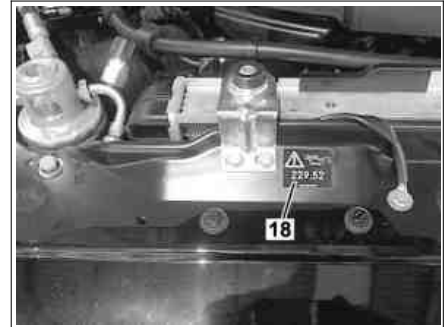
P01.10-3307-06

- 16 Serrated ring
- 17 Serrated ring



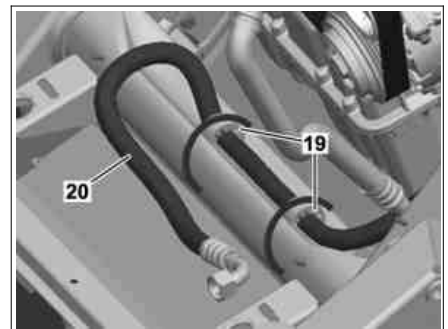
P01.10-3308-04

- 18 Oil specification adhesive label














P01.10-3309-01


- 19 Serrated ring
- 20 Suction pipe



P01.10-3310-01

	<b>Warning</b>	<b>Risk of injury.</b> Skin or eye injuries may result when handling hot or glowing objects.	Wear protective gloves, protective clothing and safety glasses, if necessary.	AS00.00-Z-0002-01A
		Notes on avoiding damage through contamination and foreign objects		AH00.00-P-5000-01A
	<b>Remove</b>			
1	Remove left air filter housing with air intake hose		Code MK0 has to be entered into VeDoc to do so!	AR09.10-P-1150GY
	2	Remove poly-V belt tensioning device		AR13.25-P-3200GY
	3	Remove oil filter housing		AR18.20-P-3471GY
	4	Remove power steering pump	Place power steering pump with connected lines to one side.	AR46.30-P-0500GY
	5	Unscrew right screw plug (5) from crankcase		
	<b>Install</b>			
6	Screw double union with sealing ring into crankcase	<b>Installation: 60 Nm</b>		
7	Route oil feed line	Oil line runs from double union downwards behind and along the A/C compressor.		
8	Remove bracket (6) for left oil line on automatic transmission and replace with bracket (7)	Mount bracket (7) first with clamp onto automatic transmission oil line and then turn bracket (7) upwards. Fasten oil feed line using new clamp lined with rubber and new bolt.		

9	Assemble engine oil cooler (15) in removed condition	 Insert elastomer bearing (8) into bracket (9). Slide bracket (9) at left and right onto engine oil cooler (15). Fasten oil line with clamps (11) to bracket (9) free of tension.	
10	Mount antisqueak (12) onto air deflector shield (13)	 Cut antisqueak (12) to size (a).	
11	Fasten air deflector shield (13) to engine oil cooler (15).		
12	Unscrew bracket for underride guard (14) from frame		
13	Mount engine oil cooler (15) from below and bolt with brackets of underride guard (14) onto frame	 When mounting the engine oil cooler (15) route the return oil line to the filter housing between the frame and the automatic transmission oil line.  Oil line to engine oil cooler: <b>30Nm</b>	
14	Mount additional serrated ring (16) between engine oil cooler(15) and automatic transmission oil line		
15	Tighten oil feed line on crankcase	 <b>30 Nm</b> Counterhold double union in crankcase and secure against twisting.	
16	Bolt on power steering pup with connected lines		AR46.30-P-0500GY
17	Install new oil filter housing with connection for return oil line	 Return oil line to oil filter housing: <b>7Nm</b>	AR18.20-P-3471GY
18	Install clamping device for poly-V belt		AR13.25-P-3200GY
19	Install noise damper with charge air hose upstream of charge air cooler		AR09.41-P-8623GY
20	Connect return oil line to oil filter housing	 Oil line to oil filter housing: <b>7Nm</b>	
21	Retrofit additional serrated ring (17) onto return oil line		
22	Install left and right air filter housing		AR09.10-P-1150GY AR09.10-P-1150GYA
23	Install fan shroud		AR20.40-P-6800GY
 Warning	<b>Risk of accident</b> from vehicle starting off by itself when engine running. <b>Risk of injury</b> (bruises and burns) resulting from working on the engine while it is being started or when it is running.	Secure vehicle to prevent it from starting off by itself. Wear closed and snug-fitting work clothes. Do not touch hot or rotating parts.	AS00.00-Z-0005-01A
24	Correct oil level and perform leak test	 Oil filling capacity: 12.5l	
25	Reinstall engine cover		AR01.10-P-2405GY
26	Install underride guard		
27	Place supplementary booklet into vehicle document wallet		
28	Attach adhesive label (18) for oil specification onto radiator cross member	 Remove old adhesive label if present.	
	<b>Programming</b>		
29	Connect diagnostic unit	Use XENTRY Diagnostics version 03/2015 or higher with all available add-ons. The operation steps must be performed exactly as per XENTRY Diagnostics! Make sure that the vehicle's on-board electrical system battery has sufficient voltage supply (more than 12.5 V) by using a battery charger. If XENTRY Diagnostics is already connected to the vehicle, continue with operation step 3. Model 463.306/336/346 with engine 642.886 up to model year 2019	AD00.00-P-2000-04A
30	Perform SCN coding in CDI control unit (N3/9)	 To do so, select menu item Control units view → Drive type → CDI → Control unit adaptations → SCN coding.	
31	Disconnect diagnostic equipment	Model 463.306/336/346 with engine 642.886 up to model year 2019	AD00.00-P-2000-04A

	Additional operations for right-hand drive vehicle		
32	<p><b>Risk of explosion</b> caused by welding or soldering work on closed air conditioning system. <b>Risk of poisoning</b> caused by inhaling overheated refrigerant vapors. <b>Risk of injury</b> to skin and eyes caused by contact with liquid refrigerant.</p> <p>Suction off refrigerant Notes on handling refrigerant R134a</p>	Never perform welding work on or near a closed air conditioning system. No smoking or open flames. Wear safety glasses and protective gloves. Work only in well ventilated areas. Carry out repair work on the air conditioning system circuit only after the system has been drained.	<p>AS83.00-Z-0001-01A</p> <p>AH83.30-N-0003-01A</p>
33	Disconnect refrigerant line from condenser		
34	Fasten refrigerant line in place with serrated ring and cable tie	 Suction line must be routed above cross member.	
35	Charge air conditioning system	<p>Model 463.306/336/346 with engine 642.886 up to model year 2013 with code H02 (Air conditioning, manual)</p> <p>Model 463.306/336/346 with engine 642.886 as of model year 2013 up to model year 2019</p>	<p>AR83.30-P-1760A</p> <p>AR83.30-P-1760GW</p>