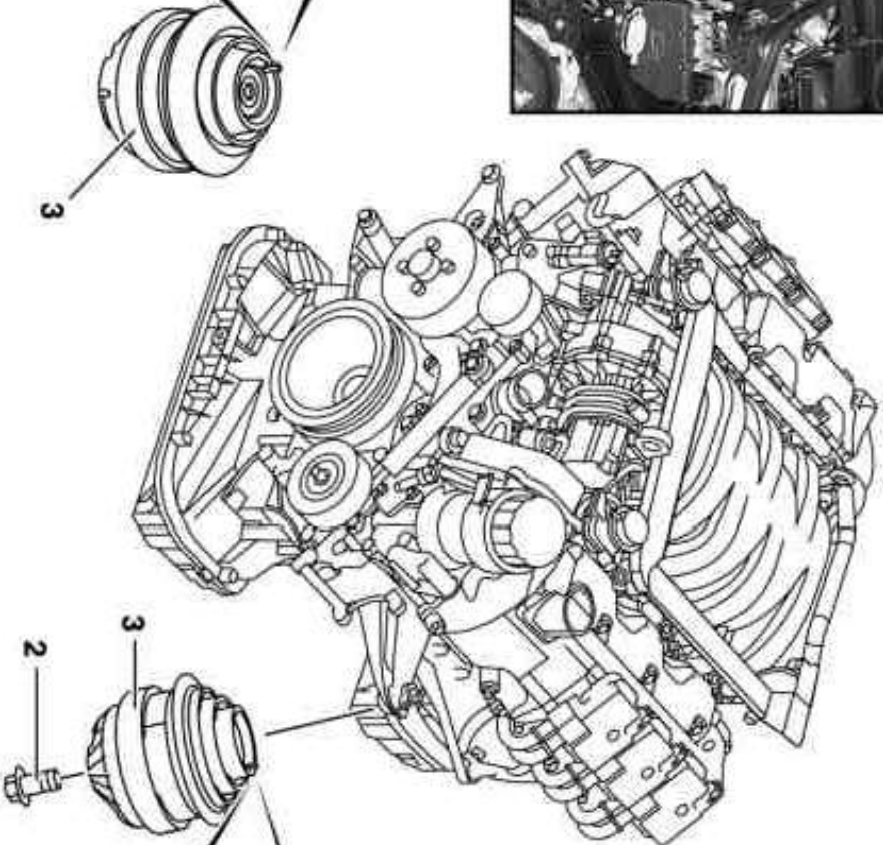
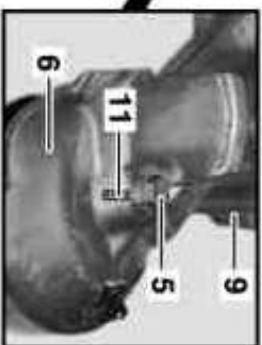
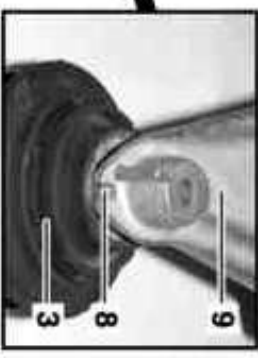
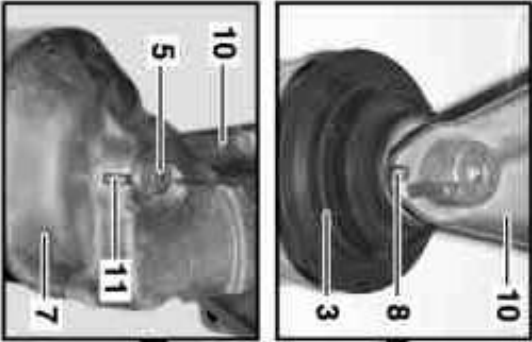
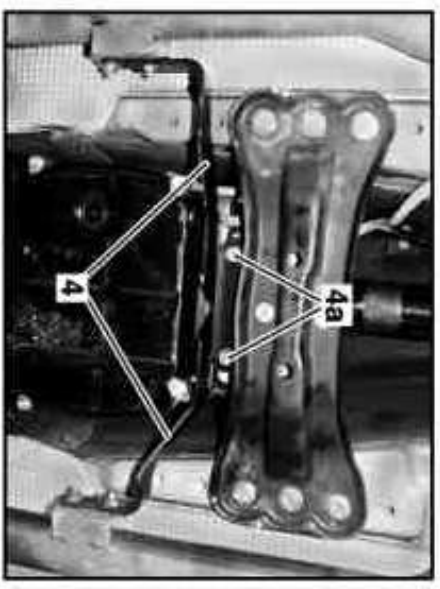


AR22.10-P-1100PV	Remove/install engine mount	9.11.09
ENGINE	112.912 in MODEL 209.361, 203.261, 209.461, 203.061 with TRANSMISSION 722.6, 716.6	
ENGINE	112.946 in MODEL 203.264 /064 with TRANSMISSION 722.6	
ENGINE	112.961 in MODEL 203.265 /065 with TRANSMISSION 722.6	
ENGINE	113.968 in MODEL 209.475 /375 with TRANSMISSION 722.633	
ENGINE	112.913 in MODEL 211.261 /061 with TRANSMISSIONS 722.6, 716.6	
ENGINE	112.949 in MODEL 211.265 /065 with TRANSMISSION 722.618	
ENGINE	113.967 in MODEL 211.270 /070 with TRANSMISSION 722.633	
ENGINE	113.987 in MODEL 209.376 /476 with TRANSMISSION 722.636	
ENGINE	112.955 in MODEL 209.365 /465 with TRANSMISSION 722.618	
ENGINE	113.990 in MODEL 211.276 /076 with TRANSMISSION 722.643	



Shown on engine 112

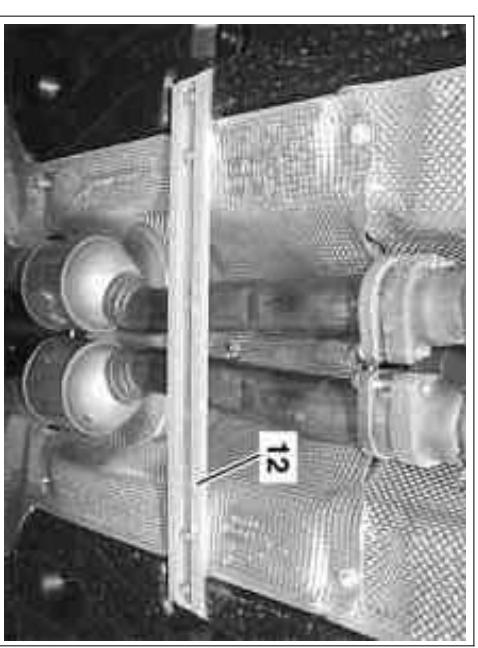
- 1 *Air cleaner housing*
- 2 *Bolt*
- 3 *Engine mount*
- 4 *Bracket*

- 4a *Bolts*
- 5 *Bolts*
- 6 *Left shield*
- 7 *Right shield*

- 8 *Anti-twist locks*
- 9 *Left engine support*
- 10 *Right engine support*
- 11 *Anti-twist locks*

P22.10-2071-09






12 Cross strut



P22.10-2091-01

Modification notes

16.5.06	"Disconnect/connect battery ground line" removed	
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 	Remove/install		
	Danger! Risk of death caused by vehicle slipping or toppling off 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
	Notes on self-locking nuts and bolts		AH00.00-N-0001-01A
1.1	Remove air filter housing (1).	Engine 112.912 /946 /961 in model 203 Engine 112.912 /955 in model 209 Engine 112.913 /949, 113.990 in model 211 Engine 113.987 in model 209.376 /476 as of 24.4.04	AR09.10-P-1150SVK AR09.10-P-1150AC
1.2	Unclip cover on front side of engine	Model 209, 211 with engine 113 except AMG	
2	Detach lower engine compartment paneling	Model 203, 209 Model 211	AR61.20-P-1105P AR61.20-P-1105T
3	Remove bolt (2)	 Model 209	*BA22.10-P-1001-01L

		Model 211 Model 203	<p>*BA22.10-P-1002-03A</p> <p>*BA22.10-P-1001-01R</p>
4.1	Remove complete exhaust system	<p> Model 211 in model 203</p> <p> Engine 112 in model 209</p> <p> Engine 113.987 in model 209.376 up to 23.4.04, 209.476</p> <p> Engine 113.968 in model 209.375 /475</p> <p> Engine 113.987 in model 209.376 as of 24.4.04</p>	<p>AR49.10-P-7000PV</p>
4.2	Remove front exhaust system from right and left exhaust manifold	<p> Model 211</p> <p> Installation: Replace bolts and check rivet nuts in the exhaust manifold, replace if required: ↓</p> <p>Replace rivet nuts in exhaust manifold.</p> <p></p> <p></p>	<p>AR49.10-P-7000TB</p> <p>AR49.10-P-5531-01DA</p> <p>*BA14.10-P-1002-01B</p> <p>*103589013900</p>
5	Remove bolts (4a)	<p> Model 211</p> <p></p>	<p>*BA49.10-P-1011-01A</p>
6	Detach bracket (4) for exhaust system from transmission	<p> Model 211</p>	
7	Remove cross strut (12)	<p> Model 211</p>	
8	Mount bracket on supercharger	<p> Engine 112.961, 113.990</p> <p> For engine lifting device.</p>	
9	Mount engine lifting device	<p> Model 203, 209</p> <p> Model 211</p> <p> Model 211</p>	<p>AR33.10-P-0100-01P</p> <p>AR33.10-P-0100-01T</p> <p>*240589006100</p>
10	Raise engine	<p> When lifting engine ensure that components are neither pinched or overstretched to avoid causing damage.</p>	
11	Remove bolts (5)	<p> Model 209</p> <p> Model 211</p> <p> Model 203</p>	<p>*BA22.10-P-1004-01L</p> <p>*BA22.10-P-1001-03A</p> <p>*BA22.10-P-1004-01R</p>

12	Remove engine mounts (3)	<p>i Remove engine mount (3) from left engine carrier (9) and right engine carrier (10). Remove engine mount (3) with left head shield (6) and right heat shield (7).</p> <p>i Installation: Anti-twist locks (8) on engine mounts (3) must latch into retaining grooves in the left engine support (9) and right engine support (10). Anti-twist locks (11) on the right engine support (10) and the left engine support (9) must sit in the cutouts on the left shield (6) and the right shield (7).</p> <p>i Pay attention to environmental protection regulations for disposal of engine mounts (3). Dispose engine mounts (3) into mixed scrap.</p>	
13	Install in the reverse order		
14	Connect STAR DIAGNOSIS and delete fault memory		

Nm Exhaust manifold

Number	Designation	Engine	Engine	Engine
		112 except 112.951 / 976	113.940/941/ 942/943/944/ 945/946/948/ 960/961/962/ 963/964/965/ 966/967/968/ 969/971/980/ 981/982/984/ 986/992/993/ 995	113.987/ 988/990/ 991

BA14: 10-P-1002-01B	Flange connection, exhaust manifold/front exhaust pipes	Nm	20	20	20
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Nm Engine mounts, engine supports

Number	Designation		Engine 112.912 in model 209	Engine 112.955 in model 209
BA22: 10-P-1001-01L	Bolt, front engine mount to front axle carrier	Nm	35	35
BA22: 10-P-1004-01L	Bolt connecting front engine mount to engine support	Nm	55	55

Nm Engine mounts, engine supports

Number	Designation		Engine 113.968 in model 209	Engine 113.987 in model 209
BA22: 10-P-1001-01L	Bolt, front engine mount to front axle carrier	Nm	35	35
BA22: 10-P-1004-01L	Bolt connecting front engine mount to engine support	Nm	55	55

Nm Engine mount, engine support (engine side)

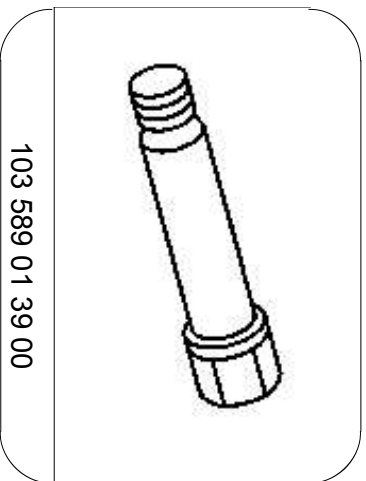
Number	Designation	Model
		Model 211 except 4 MATIC
BA22.10-P-1001-03A	Front engine support on engine mount	Nm 50
BA22.10-P-1002-03A	Front engine mount on front axle carrier	Nm 35

Nm Engine mounts, engine supports

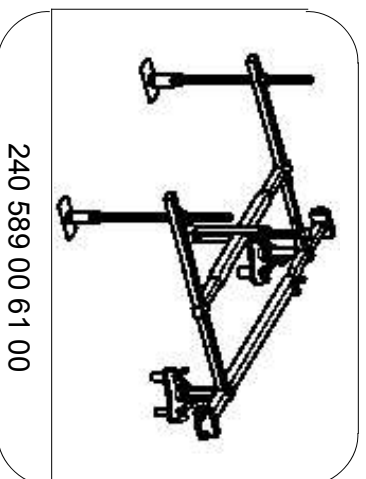
Number	Designation	Engine 112.912/ 946 in model 203	Engine 112.961 in model 203
BA22.10-P-1001-01R	Bolt, front engine mount to front axle carrier	Nm 35	35
BA22.10-P-1004-01R	Bolt, engine mount to engine support	Nm 55	-

Nm Exhaust system

Number	Designation	Engine 112, 113 in model 211
BA49.10-P-1011-01A	Bolt, three way catalytic converter bracket to transmission housing	Nm 20



Caulking bolt



Engine lifting fixture