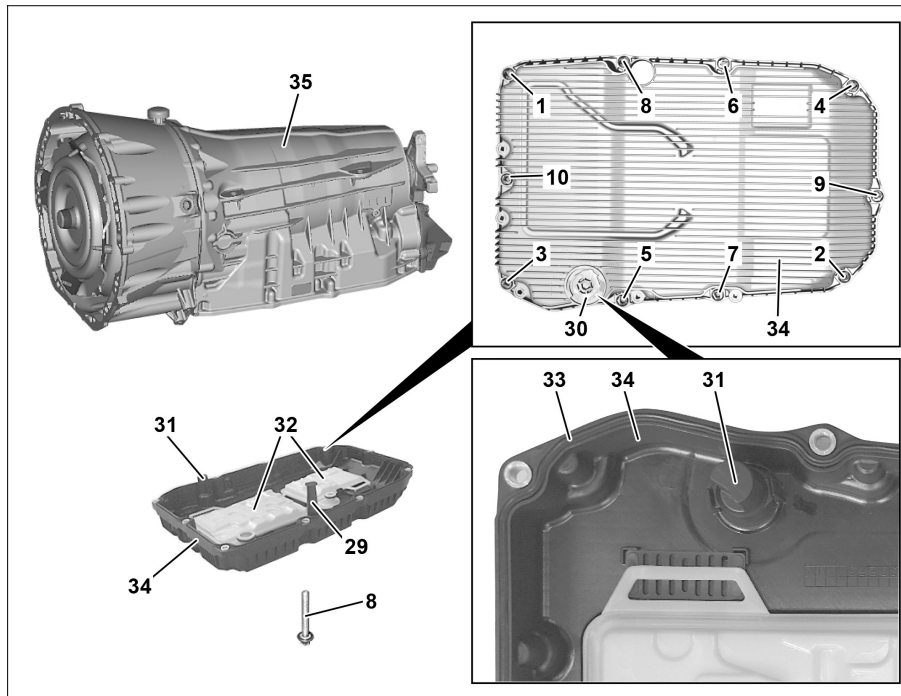


Transmission 725.0 in model 172, 207, 231

Modification notes

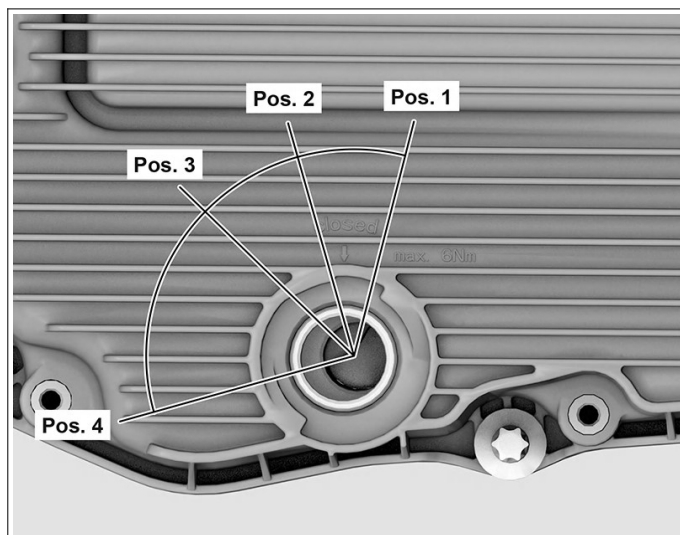
09.08.2019	Document completely revised.		
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- 1 Screw
- 2 Screw
- 3 Screw
- 4 Screw
- 5 Screw
- 6 Screw
- 7 Screw
- 8 Screw
- 9 Screw
- 10 Screw
- 29 Swirl pipe for ultrasound measurement
- 30 Quick-release coupling
- 31 Overflow pipe
- 32 Oil filter
- 33 Seal
- 34 Oil pan
- 35 Transmission






















P27.10-2680-06


Pos. 4 "Draining large oil filling capacities" position



P27.00-2450-11

Danger	Risk of death caused by vehicle slipping or toppling off of the lifting platform.	Align vehicle between vehicle lift columns and position the four support plates at the vehicle lift support points specified by the vehicle manufacturer.	AS00.00-Z-0010-01A
Warning	Risk of injury. 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
Caution	Risk of injury to skin and eyes due to handling of transmission oil. Health risk caused by swallowing transmission oil	Wear protective gloves, protective clothing and safety glasses. Do not pour transmission oil into beverage bottles.	AS00.40-Z-0001-01A

 Caution	Risk of injury caused by scraping or cutting body parts on sharp vehicle parts	Always wear protective gloves when working on or near sharp and non-deburred vehicle parts. Deburr repair panels.	AS00.00-Z-0017-01A
Topical note	Notes on threaded connections fastened using a tightening angle-based tightening process		AH00.00-P-0020-01A
	Notes on automatic transmission		AH27.19-P-0001-01NKB
	Remove/install		
1.1	Remove center and rear lower engine compartment lining.	Transmission 725.0 in model 172 with engine 276 Transmission 725.0 in model 172.4 with engine 274 Transmission 725.0 in model 231 Transmission 725.0 in model 231 Transmission 725.0 in model 172 with engine 274 Transmission 725.0 in model 172 with engine 276  Installation: Only install center and rear lower rear engine compartment paneling again after leak test.	AR61.20-P-1105RK AR61.20-P-1105W
1.2	Remove center and rear bottom section of soundproofing.	Transmission 725.0 in model 172.4 with engine 651 Transmission 725.0 in model 207 with engine 642 Transmission 725.0 in model 207 with engine 651 Transmission 725.0 in model 207 with engine 642 Transmission 725.0 in model 207 with engine 651 Transmission 725.0 in model 172.4 with engine 651  Installation: Install center and rear bottom section of soundproofing only after leak test.	AR94.30-P-5300EW AR94.30-P-5300W
2	Thoroughly clean oil pan (34) and surrounding area.	Assembly cleaner	*BR00.45-Z-1028-04A
3	Remove quick-release fastener (30).	 Open quick-release fastener (30)  using socket wrench.  Installation: Replace quick-release fastener (30).  Socket wrench	*724589010900
4	Drain fluid from transmission.	 Set overflow pipe (31) to "draining large oil filling capacities" position (Pos. 4) using  socket wrench.  Socket wrench	*725589000900
5	Remove heat shield from transmission.	Transmission 725.0 in model 172, 231 Transmission 725.0 in model 207  Screw/bolt, heat shield to oil pan	AR27.40-P-0700-01LF AR27.40-P-0700-01EW *BA27.10-P-1009-04H
6	Remove holders that are installed on oil pan (34) from oil pan (34).	If holders are present.  The number of holders can vary depending on the equipment variant.  M6 × 1	*BA00.10-P-1002-04A
7	Unscrew screws (1 to 10).	 Commercially available devices/tools Flexible head wrench insert E10 ¼", comparable to Snap-on Article no.:TSE100 www.snapon.com  Installation: Replace bolts (1 to 10). Screw in bolts (1 to 10) of oil pan (34) in numerical sequence.  Screw/bolt, oil pan to transmission housing	*BA27.10-P-1010-04H
8	Remove oil pan (34) from transmission(35). Notes on oil pan versions	 Installation: An old variant of the oil pan (34) must not be installed. Otherwise, the ultrasound measurement method must not be used.  Replace oil pan (34) when replacing oil filter (32). Oil filters (32) cannot be obtained individually.	AH27.10-P-0002-01EWN

9	Take overflow pipe (31) and swirl pipe for ultrasound measurement (29) out of oil pan (34).	<p>i Installation: When replacing the oil pan (34), replace overflow pipe (31) and swirl pipe for ultrasound measurement (29). When reusing the oil pan (34), check overflow pipe (31) and swirl pipe for ultrasound measurement (29) for tight seating on base and damage, and replace if necessary.</p> <p>i Installation: Press overflow pipe (31) and swirl pipe for ultrasound measurement (29) firmly onto base of oil pan (34).</p>	
10	Remove seal (33).	<p>Only when reusing the oil pan (34).</p> <p>i Installation: Do not apply any sealant or sealing compound to oil pan (34) and transmission (35). Otherwise leaks may occur.</p> <p>i Installation: Replace seal (33).</p>	
	Clean		
11	Clean sealing surfaces of oil pan (34) and magnets.	<p>Only when reusing the oil pan (34).</p> <p>i Installation: Sealing surfaces must be absolutely free of oil and grease. Otherwise leaks may occur.</p> <p>i Installation: Let assembly cleaner flash off completely. Assembly cleaner</p>	*BR00.45-Z-1028-04A
12	Clean sealing surface at transmission (35).	<p>i Installation: Let assembly cleaner flash off completely. Assembly cleaner</p>	*BR00.45-Z-1028-04A
13	Install in the reverse order.		
14	Fill transmission(35) with oil.	<p>Transmission 725.0 in model 172, 207, 231</p> <p>i Installation: Always follow the work procedure and observe the Specifications for Operating Fluids. Otherwise the transmission(35) will be damaged.</p>	AR27.00-P-0270EWN

Nm Metric screws/bolts and nuts as per MBN 10 105, 10 143

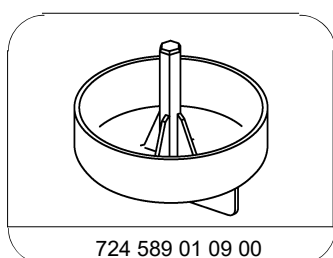
Number	Designation		8.8	10.9
BA00.10-P-1002-04A	M6 x 1	Nm	9	13

Nm Automatic transmission complete

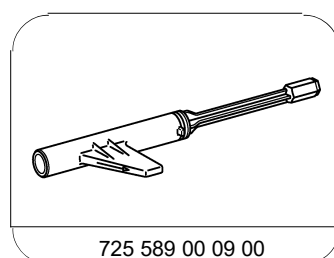
Number	Designation		Transmission 725.0
BA27.10-P-1009-04H	Screw/bolt, heat shield to oil pan	Nm	9

Nm Automatic transmission complete

Number	Designation		Transmission 725.0
BA27.10-P-1010-04H	Screw/bolt, oil pan to transmission housing	Stage 1	Nm 4
		Stage 2	4° 90



Socket wrench



Socket wrench

Repair materials

Number	Designation	Order number
BR00.45-Z-1028-04A	Assembly cleaner	A 000 986 56 01