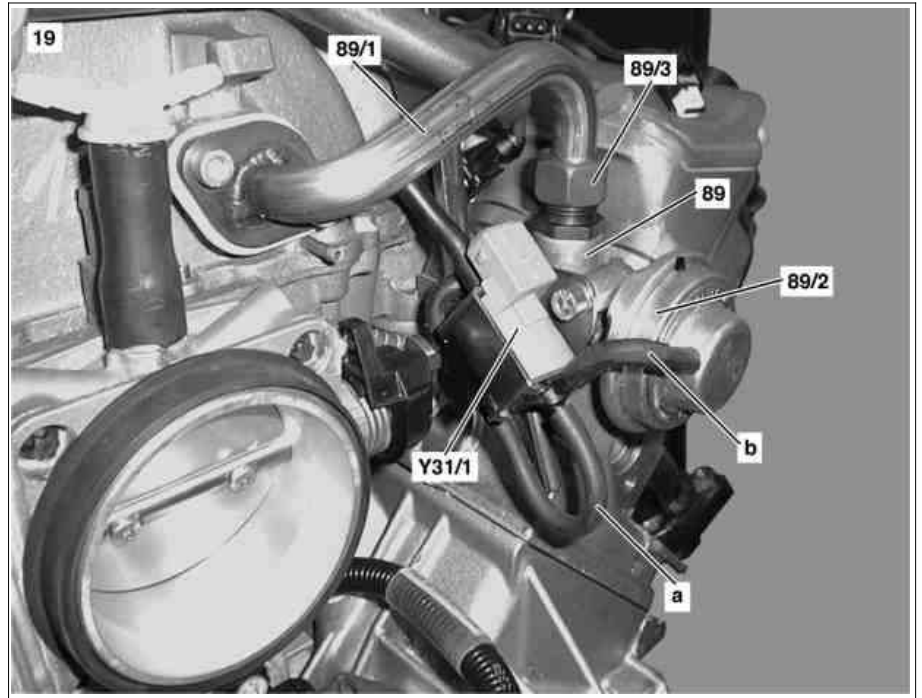


**ENGINE 112.942 in MODEL 163.154**  
**ENGINE 113.942 in MODEL 163.172**  
**ENGINE 113.981 in MODEL 163.174**  
**ENGINE 112.945 in MODEL 463.209 /232 /233 /244 /245 /250**  
**ENGINE 113.962 in MODELS 463.206 /240 /241 /247 /248 /249 /254**  
**ENGINE 113.982 in MODEL 463.243 /246**  
**ENGINE 112.970 in MODEL 163.157**  
**ENGINE 113.965 in MODEL 163.175**

- 19 Intake manifold
- 89 Exhaust gas recirculation valve
- 89/1 Exhaust gas recirculation line
- 89/2 Vacuum reservoir
- 89/3 Union nut
- a Vacuum supply from intake manifold
- b Controlled vacuum from EGR [ARF] vacuum transducer to exhaust gas recirculation valve
- Y31/1 EGR [ARF] vacuum transducer



P14.20-0263-06

**Modification notes**

27.2.02	Figure modified from 23 Nm to 40 Nm	Value modified in series BA14.20-P-1002-01B for Engine 113.940/942/943/944/960/962/968/980/981/984	*BA14.20-P-1002-01B
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		<b>Remove/Install</b>	
1		Remove engine trim panel or cleaner	<b>i</b> The air filter is integrated in the engine trim panel in model 463. Remove engine trim panel or air filter by pulling it vertically up and off the cylinder head covers.
2.1		Remove top part of air filter	<b>i</b> Model 163. only
3		Remove hot film mass air flow sensor with air intake pipe	Model 163.154/ 157.  Model 163.172/174/175. Model 463.
4		Unscrew acorn nut (89/3) on exhaust gas recirculation valve (89)	<b>Nm</b> *BA14.20-P-1002-01B
5		Unbolt exhaust gas recirculation line (89/1) at intake manifold (19)	<b>Nm</b> *BA14.20-P-1003-01B
6		Unbolt EGR valve (89) at cylinder head	<b>Nm</b> *BA14.20-P-1001-01B
7		Disconnect EGR transducer connector (Y31/1)	
8		Remove exhaust gas recirculation valve (89)	
9		Install in the reverse order	<b>i</b> <b>Installation: Replace the gaskets. Pay attention to length and routing of vacuum pipe from intake pipe to EGR transducer (Y31/1). Incorrect routing may cause throttle lever to jam.</b>

<b>Gasket Part #</b>
112 142 02 80
112 141 21 80

**Exhaust gas recirculation**

Number	Designation		Engine 112.910/912/916/ 920/921/922/923/ 940/941/942/943/ 944/945/946/947/ 953/972/975	Engine 112.913/ 917/949/ 954/955/ 970/973	Engine 113.940/941/942/ 943/944/948/960/ 961/962/964/965/ 966/967/968/969/ 971/980/981/982/ 984/987/988
BA14.20-P-1001-01B	Bolt, exhaust gas recirculation valve to cylinder head	Nm	20	20	20
BA14.20-P-1002-01B	Acorn nut, exhaust gas recirculation pipe to exhaust gas recirculation valve	Nm	40	40	40
BA14.20-P-1003-01B	Screw, exhaust gas recirculation pipe to intake pipe	Nm	9	8	9