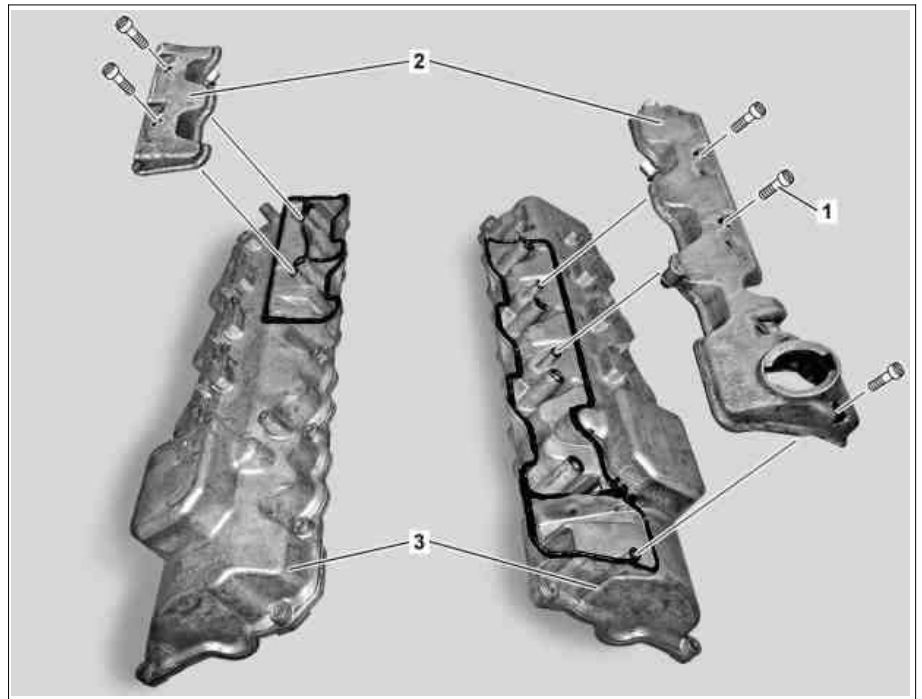


Shown on engine 113

- 1 Bolts T25 Torx Socket
- 2 Cover for crankcase ventilation
- 3 Cylinder head covers

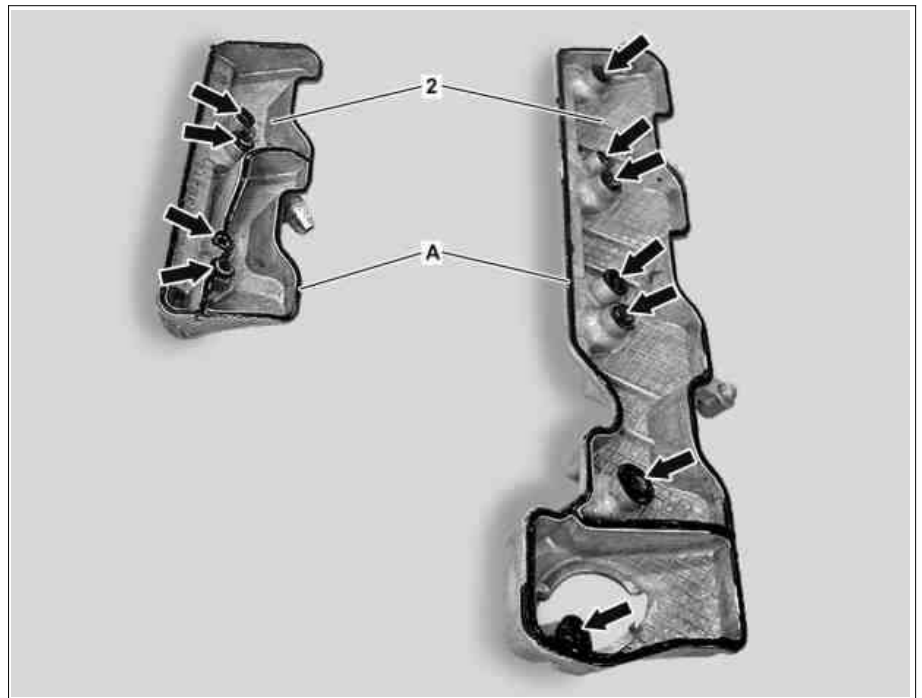


P01.20-2225-06

Sealant path

Shown on engine 113

- 2 Cover for crankcase ventilation
- A Sealant
- Arrow Sealant, bolt holes



P01.20-2226-06

| Picture item, etc. | Work instructions  |  |   |
|--------------------|--|--|---|
| 1                  | Bolts  | <p><b>i</b> Aluminum bolts.<br/> <b>Installation: Install new bolts.</b><br/> <b>Nm</b> Part #000000-004436</p>  | <p>*BA01.20-P-1003-01E</p>  |
| Clean              | When cylinder head covers are installed, cover oil ducts with rags   | <p><b>!</b> Do not use any sharp-edged tools or abrasive paper as this will damage the sealing surfaces.<br/> <b>!</b> Oil channels clogged with sealant will damage the engine.<br/>                     Loctite 7200<br/>                     Loctite 7063 cleaning spray (150 ml)</p> | <p>AR01.00-P-0050-01A</p> <p>*BR00.45-Z-1038-04A<br/>                     *BR00.45-Z-1046-04A</p> |
| <b>i</b> Sealant   | Apply a 2.0 mm thick bead of sealant (A), observing the bolt holes (arrow). Do not spread the silicone bead. Process sealant within 10 minutes | <p><b>!</b> To avoid leaks, use only the silicone sealant specified in the repair materials!</p>   |   |

 **Crankcase ventilation, cylinder head cover**

| Number             | Designation  |    | Engine<br>112 | Engine<br>113 |
|--------------------|--|----|---------------|---------------|
| BA01.20-P-1003-01E | Bolt, crankcase ventilation cover to the cylinder head valve cover | Nm | 4             | 4=3 ft.lbs.   |

**Repair materials**

| Number             | Designation                          | Order number   |
|--------------------|--------------------------------------|--|
| BR00.45-Z-1013-01A | Loctite 5970 sealant                 | A 003 989 98 20  |
| BR00.45-Z-1038-04A | Loctite 7200                         | Henkel Loctite Deutschland GmbH<br>Arabellastrasse 17<br>81925 München<br>Germany<br>Tel. +49 899268-0<br>Fax + 49 899101978<br>www.Loctite.de |
| BR00.45-Z-1046-04A | Loctite 7063 cleaning spray (150 ml) | A 001 986 71 71 10   |