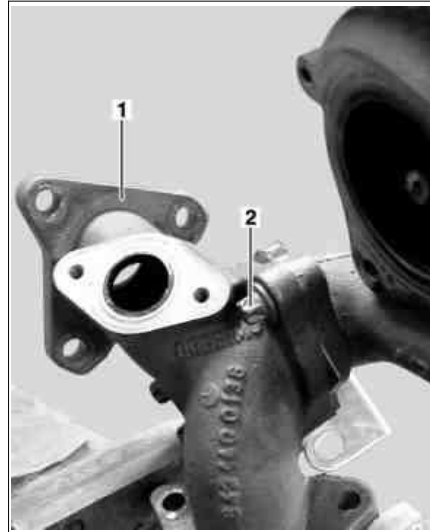


AR09.40-P-6024-15A	Replace seal between turbocharger and exhaust collector		
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Nm Turbocharger

Number	Designation	Engine 642
BA09.40-P-1011-01K	Bolt, turbocharger to exhaust collector pipe	Stage 1 Nm 20
		Stage 2 Δ° 90

- 1 Clamp exhaust collector with turbocharger in vise.
- i** Use an assistant to ensure it is clamped in at the flange (1) to the exhaust manifold.
- 2 Slacken bolts (2, 3).
- i** Use an assistant to prevent the turbocharger from falling out of the vise.
- 3 Remove turbocharger from exhaust collector.
- i** Pay attention to installation position of seal and position of seal tab.
- 4 Clean sealing surfaces on exhaust collector and turbocharger.



P09.40-2243-02

P09.40-2244-02

- 5 Install new seal between exhaust collector and turbocharger.
- i** Correct position of seal tab permits correct hole pattern.
- 6 Screw in bolts (2, 3) finger-tight.
- i** It must be easy to move the Turbocharger on the sealing surface to the exhaust collector in order to permit alignment.
- 7 Reinsert turbocharger with exhaust collector.
- i** Temporary installation serves a final assembly that is free of tension.
- 8 Screw turbocharger with old seal onto oil supply connection fitting.
- 9 Screw exhaust collector onto exhaust manifolds finger-tight using the old seal.
- i** Fasten bolts crosswise in order to ensure an evenly level contact of the exhaust collector on both manifolds.
- 10 Tighten bolt (2) **Nm** with torque.
- i** A later displacement between exhaust collector and turbocharger leads to distortions that cause substantial engine damage.
- 11 Loosen bolts again between exhaust collector and exhaust manifolds.
- 12 Unscrew turbocharger again from oil supply connection fitting.
- 13 Carefully remove turbocharger with exhaust collector.
- i** It is imperative to avoid touching surrounding components, since a displacement between exhaust collector and turbocharger leads to distortions that cause substantial engine damage.
- 14 Tighten the bolts (3) **Nm** between exhaust collector and turbocharger with torque.