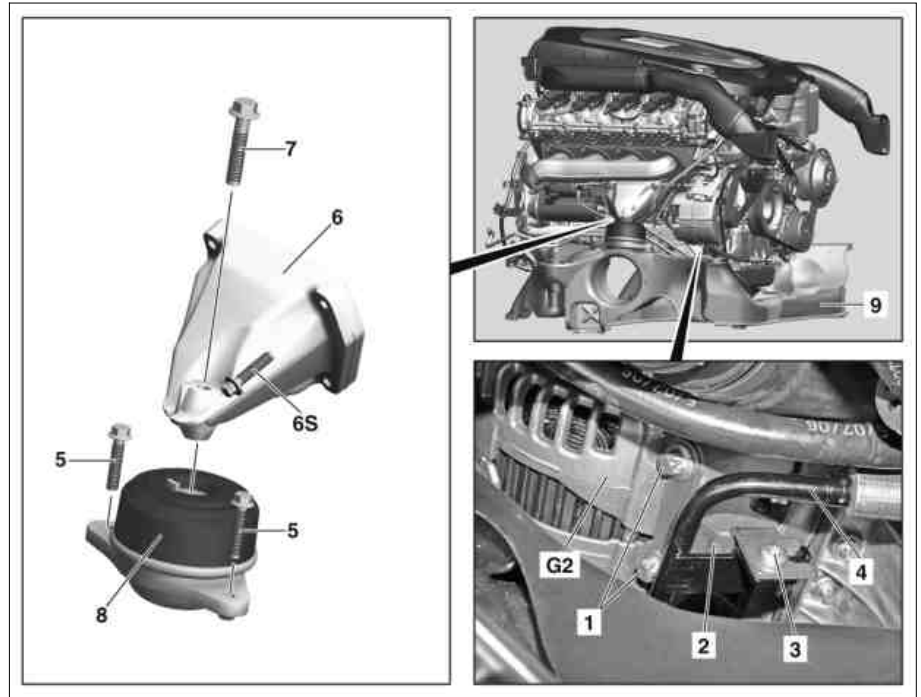


ENGINES 273.924 /968 in MODEL 221.08 /18

ENGINES 273 in MODEL 216.38

- 1 Bolts
- 2 Bracket
- 3 Screw
- 4 Oil line
- 5 Bolts
- 6 Engine support
- 6S Bolts
- 7 Screw
- 8 Engine mount
- 9 Front axle carrier
  
- G2 Generator



P22.10-2288-06

**Modification notes**

17.3.08	Disable entry/exit support replaced by detach ground line(s) from battery(batteries) Remove heat shield from engine mount added	Step 1  Operation step 4	
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	<b>Remove/install</b>		
<b>Both engine mounts</b>			
	General information	Engine mounts (8) must be replaced in pairs.	
1	Remove ground line(s) from battery (batteries)		AR54.10-P-0003SX
2	Move front wheels to straight-ahead position and secure steering wheel.	The steering wheel must not be turned when the steering coupling is detached, otherwise the clock spring contact will be destroyed. 	*129589012100
3	Remove air filter housing		AR09.10-P-1150SX
4	Remove heat shields from engine mounts (8)		
5	Remove bolts (5, 7)	    	*001589011600 *BA22.10-P-1001-03D *BA22.10-P-1002-03D *BA22.10-P-1001-03C *BA22.10-P-1002-03C
6	Attach engine hoist and raise engine	No not apply tension to or damage lines or hoses. Attach shackle to front engine suspension lug <b>only</b> .	AR33.10-P-0105SX
7	Remove bottom engine compartment paneling		AR61.20-P-1105SX
8	Detach steering coupling at steering shaft		AR46.10-P-8000SX
9	Remove left engine mount (8) to the rear and down	<b>Installation:</b> Align anti-twist lock on engine mount (8) to cutout on engine support (6). Pay attention to environmental protection regulations for disposal of engine mounts (8). Dispose engine mounts (8) into mixed scrap.	

10	Detach power steering oil line (4) from holder (2)		
11	Remove holder (2) from alternator (G2) by removing bolts (1)	Nm	*BA15.40-P-1001-01F
12	Remove right engine mount (8) to the front and down	<p><b>i</b> Remove engine mount (8) between front axle carrier (9) and fan shroud.</p> <p><b>i</b> <b>Installation:</b> Align anti-twist lock on engine mount (8) to cutout on engine support (6).</p> <p><b>i</b> Pay attention to environmental protection regulations for disposal of engine mounts (8). Dispose engine mounts (8) into mixed scrap.</p>	
	<b>Left engine support</b>		
13	Remove left catalytic converter		AR49.10-P-7100SX
14	Remove refrigerant compressor bolt on engine support (6)	Nm	*BA83.55-P-1001-01M
15	Remove engine support (6) from cylinder crankcase by removing bolts (6S)	Nm	*BA22.10-P-1001-02A
16	Remove engine support (6) to the rear and down		
	<b>Right engine support</b>		
17	Remove right catalytic converter		AR49.10-P-7100SX
18	Remove right exhaust manifold		AR14.10-P-3915SX
19	Remove bolt from engine support (6) to front axle transmission	Nm	*BA33.30-P-1007-03G
20	Remove bolts (6S)	Nm	*BA22.10-P-1001-02A
21	Remove engine support (6) to the rear and down		
22	Install in the reverse order		

#### Nm Alternator

Number	Designation	Engine 273
BA15.40-P-1001-01F	Bolt, alternator to timing case	Nm 20

#### Nm Engine support (engine side)

Number	Designation	Engine 273
BA22.10-P-1001-02A	Bolt, engine support to cylinder crankcase	Stage 1 Nm 20
		Stage 2 4° 90

#### Nm Engine suspension, engine mounts, engine supports

Number	Designation	Model 216.386/394
BA22.10-P-1001-03C	Bolt, front engine mount to front axle carrier	Nm 28
BA22.10-P-1002-03C	Bolt connecting front engine mount to engine support	M10 Nm 50
		M12 Stage 1 Nm 85

		Stage 2	∟°	90
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**Nm Engine suspension, engine mounts, engine supports**

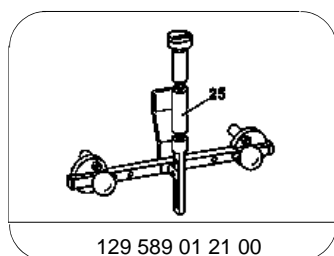
Number	Designation		Model 221.08/094/18/ 194
BA22.10-P-1001-03D	Bolt, front engine mount to front axle carrier	Nm	30
BA22.10-P-1002-03D	Bolt connecting front engine mount to engine support	M10 Nm	50
		M12 Stage 1 Nm	85
		Stage 2 ∟°	90

**Nm Front axle transmission**

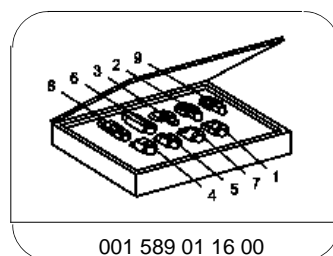
Number	Designation		Model 216	Model 221
BA33.30-P-1007-03G	Collar bolt, front axle transmission to engine support	Stage 1 Nm	5	5
		Stage 2 Nm	50	50
		Stage 3 ∟°	95	95

**Nm Refrigerant compressor**

Number	Designation		Engine 273
BA83.55-P-1001-01M	Bolt, refrigerant compressor to timing case/ crankcase/engine support	Nm	20



Holding device



Set of engine bearing wrenches