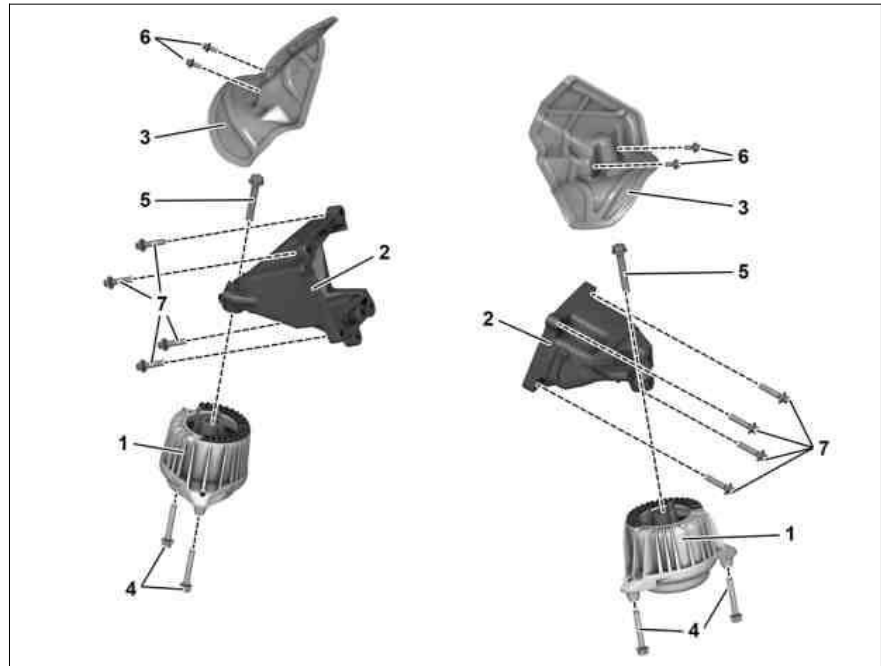


## ENGINE 276.8 in MODEL 231

- 1 Engine mount  
 3 Heat shield  
 4 Screw/bolts  
 5 Screw/bolt  
 6 Screw/bolts  
 7 Screw/bolts



P22.10-2475-06

ⓘ	Notes on bolted connections with self tapping screws		AH00.00-P-0007-01SF
⊠ ⊠	<b>Remove/install</b>		
1	Attach engine hoist and raise engine until the engine mount (1) is not under tension		AR33.10-P-0105RK
2	Remove lower engine compartment paneling		AR61.20-P-1105RK
3	Detach CAT on left and right on exhaust pipe		AR49.10-P-7100RK
4	Remove heat shields (3) for engine mount (1) on left and right	Nm	Screw/bolt, heat shield to engine support *BA22.10-P-1003-02A
5	Remove screw/bolts (4) of engine mounts (1) at front axle carrier on right and left	Nm	Bolt, front engine mount to front axle carrier *BA22.10-P-1002-03E
6	Lift engine a little	ⓘ	Ensure during lifting that no cables and lines lie on the bulkhead. Damage can occur to cables and lines otherwise.
7	Remove screw/bolts (5) from engine mounts (1) on left and right	Nm	Bolt, front engine mount to engine support *BA22.10-P-1001-03E
8	Remove engine mount (1) to the rear	i	Pay attention to environmental protection regulations for disposal of engine mounts (1). Dispose engine mounts (1) into mixed scrap.
		i	Always replace engine mount (1) in pairs.
9	Install in the reverse order		

## Nm Engine mount, engine support (engine side)

Number	Designation	Model 231
BA22.10-P-1001-03E	Bolt, front engine mount to M10 engine support	Nm 50
	M12	Stage 1 Nm 85
		Stage 2 $\Delta^\circ$ 90

**Nm** Engine mount, engine support (engine side)

<b>Number</b>	<b>Designation</b>	<b>Model 231</b>
BA22.10-P-1002-03E	Bolt, front engine mount to front axle carrier M8 Nm	30

**Nm** Engine support (engine side)

<b>Number</b>	<b>Designation</b>	<b>ENGINE 276</b>
BA22.10-P-1003-02A	Screw/bolt, heat shield to engine support Nm	13