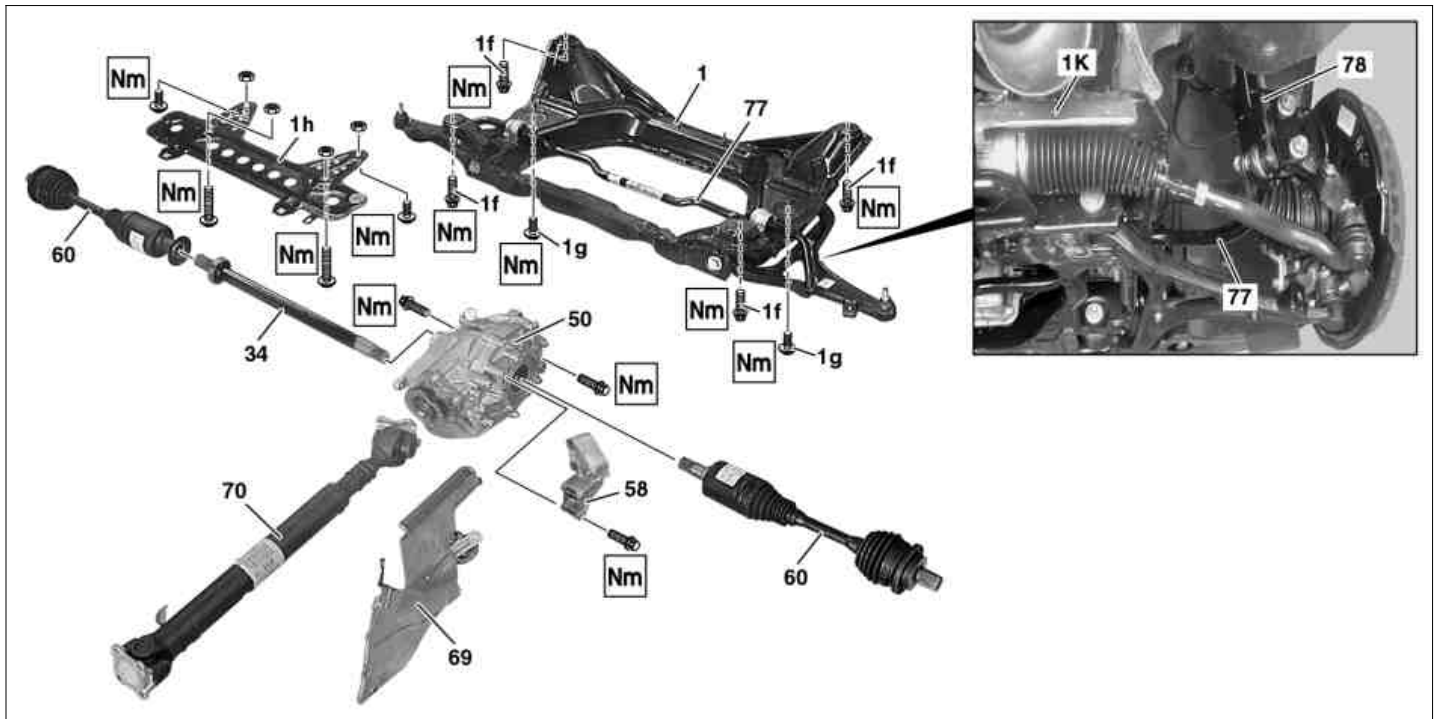


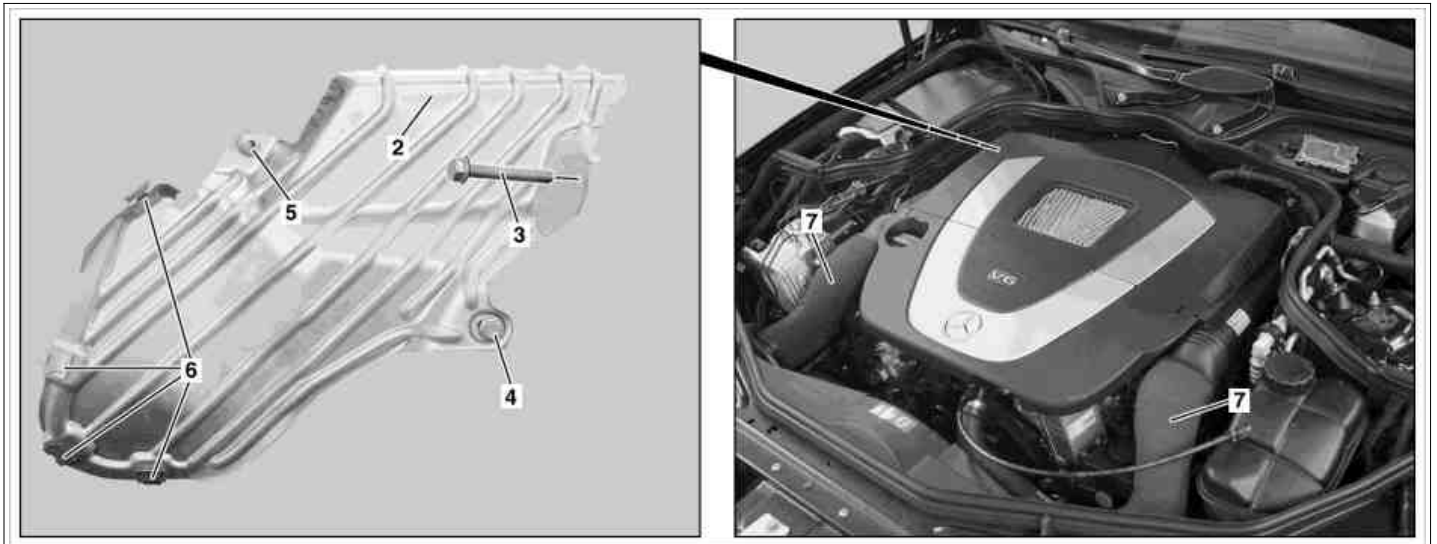
MODEL 203.081 /084 /087 /092 /281 /284 /287 /292



P33.30-2053-09

Shown on model 203 with engine 112

- | | | | | | |
|----|-------------------------|----|--------------------------------------|----|---------------------------------|
| 1 | Front axle carrier | 34 | Intermediate shaft | 69 | Exhaust shielding plate |
| 1f | Bolts | 50 | Front axle gear | 70 | Front axle gear propeller shaft |
| 1g | Bolts | 58 | Mounting support for front axle gear | 77 | Stabilizer bar |
| 1h | Retaining plate | 60 | Front axle shaft | 78 | Link rods |
| 1k | Exhaust shielding plate | | | | |



P09.10-2168-08

Shown on model 203 with engine 272

- | | | | | | |
|---|-------------------------|---|-------|---|-----------------|
| 2 | Exhaust shielding plate | 4 | Screw | 6 | Retaining clips |
| 3 | Screw | 5 | Nut | 7 | Intake air duct |

Modification notes

29.11.07	Value changed: bolted connection, rack-and-pinion steering to front axle carrier, 1st stage	*BA46.20-P-1002-01F
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	Value changed: bolted connection of rack-and-pinion steering to front axle carrier, 2nd stage		*BA46.20-P-1002-01F
	Value changed: Threaded connection, retaining plate to front axle carrier, 1st stage		*BA46.20-P-1004-01F
	Value changed: Threaded connection, retaining plate to front axle carrier, 2nd stage		*BA46.20-P-1004-01F

	Remove/install		
Danger!	Risk of death caused by vehicle slipping or toppling off of the lifting platform.	Align vehicle between columns of vehicle lift and position four support plates at vehicle lift support points specified by vehicle manufacturer.	AS00.00-Z-0010-01A
Danger!	Risk of injury caused by fingers being pinched or crushed when removing, installing or aligning hoods, doors, trunk lids, liftgates or sliding roof	Keep body parts and limbs well clear of moving parts.	AS00.00-Z-0011-01A
	Notes on self-locking nuts and bolts	All models	AH00.00-N-0001-01A
1	Open engine hood		AR88.40-P-1000P
2	Remove left and right intake air duct (7) upstream of air filter		
3.1	Detach air filter housing from above vertically from the cylinder head covers	Model 203 with engine 112 Installation: Moisten slightly with antifriction agent the rubber retainers on the cylinder head covers and the sealing ring of the hot film mass air flow sensor in the air filter housing. Lubricant paste	*BR00.45-Z-1002-06A
3.2	Remove air filter housing	Model 203 with engine 272	AR09.10-P-1150QB
4	Loosen bolt (4) on exhaust shielding plate (2) for propeller shaft of front axle gear	Model 203 with engine 272	
5	Mount engine support bracket and raise engine slightly	Engine carrier arm, refer to GOTIS http://gotis.aftersales.mercedes-benz.com	AR33.10-P-0100-01P
6	Detach return line of rack-and-pinion steering from the top of the front axle carrier (1)	Nuts between the engine and radiator and nut in front of the right-hand engine mount.	
7	Raise vehicle		AR00.60-P-1000P
8	Detach front and rear lower engine compartment paneling		AR61.20-P-1105P
9	Detach return line of rack-and-pinion steering from the bottom of the front axle carrier (1)	The nut is located in front of the steering coupling.	
10	Remove right and left front axle shaft (60)		AR33.30-P-0620P
11	Remove intermediate shaft (34)		AR33.30-P-0625P
12	Detach torsion bar (77) on left and right of the link rods (78)		*BA32.20-P-1002-02B
13	Detach the exhaust shielding plate (1k) above the right rubber boot of the rack-and-pinion steering		
14	Remove retaining panel (1h) of rack-and-pinion steering	 	*BA46.20-P-1002-01F *BA46.20-P-1004-01F
15	Pull rack-and-pinion steering slightly backwards and tie in place		
16	Remove right O2 sensor downstream of CAT (G3/6)	Model 203 with engine 272	AR07.52-P-5303QB
17	Unclip electrical feed line of O2 sensor from retaining clamps (6)	Model 203 with engine 272	
18	Undo bolt (3) and nut (5) and remove exhaust shielding plate (2)	Model 203 with engine 272 	*BA33.30-P-1001-03D
19	Mark front axle gear propeller shaft (70) in relation to front axle gear flange		
20	Detach front axle gear propeller shaft (70) from front axle gear flange	Installation: Observe marking. Counterhold propeller shaft of front axle gear (70) using counterholder. Counterholder	*203589004000

			*BA33.30-P-1004-02C
21	Tie front axle gear propeller shaft (70) to one side.		
22	Detach the left and right engine mount at the bottom of the front axle carrier	Model 203 with engine 112 Model 203 with engine 272	*BA22.10-P-1001-01R *BA22.10-P-1001-01S
23	Remove headlight range control's linkage rod from lower control arm.	Model 203 with engine 272	
24	Support front subframe (1)	Passenger car transmission platform, refer to GOTIS http://gotis.aftersales.mercedes-benz.com	AR33.10-P-0100-03P
25	Remove bolts (1f) of front axle carrier (1).	Installation: The bolts (1f) are self-tapping, so the following points must be observed: <ul style="list-style-type: none"> ● Never retap the thread in the side member ● Replace screws (1f). ● Use only original bolts (4 x) ● Do not insert bolts (1f) at an incline when turning in ● Do not use an impact bolt tightener ● Observe tightening torque 	*BA33.10-P-1003-01A
26	Lower front subframe (1)	Secure front axle carrier (1) against falling	
27	Detach exhaust shielding plate (69) for front axle gear propeller shaft (70)	Model 203 with engine 112 	*BA33.30-P-1001-03D
28	Detach mounting support of front axle gear (58)		*BA33.30-P-1001-03D
29	Detach high-pressure line of rack-and-pinion steering from the oil pan	Model 203 with engine 112	
30	Insert drift into radial sealing ring on outside right of front axle gear (50)	To prevent transmission fluid from escaping from the hole during removal. 	*210589011500
31	Detach front axle gear (50) and remove	Four bolts from the left and two from the right. Ensure that no transmission oil escapes. 	*BA33.30-P-1002-03D
32	Install in the reverse order		
33	Check front axle gear oil level, refill if necessary	 	AR33.30-P-0525-02P *BF33.30-P-1001-03C *BA33.30-P-1006-03D
34	Read out fault memory with STAR DIAGNOSIS and erase if necessary Connect STAR DIAGNOSIS and read out fault memory	STAR DIAGNOSIS diagnosis system	AD00.00-P-2000-04A

Engine mounts, engine supports

Number	Designation	Engine 112.916/ 953 in model 203
BA22.10-P-1001-01R	Bolt, front engine mount to front axle carrier	Nm 35

Engine suspension, engine mounts, engine supports

Number	Designation	Engine 272 in model 203 with 4-MATIC
BA22.10-P-1001-01S	Bolt, front engine mount to front axle carrier	Nm 35

Nm Front axle stabilizer bar

Number	Designation	Model 203.08/09/ 28/29
BA32.20-P-1002-02B	Self-locking nut of connecting rod to torsion bar	M10 Nm 55
		M10×1.5 Nm -
		M12×1.5 Nm -
		M14×1.5 Nm -

Nm Front axle carrier

Number	Designation	Model 203
BA33.10-P-1003-01A	Bolt, front axle carrier to front end	Nm 100

Nm Front axle shaft

Number	Designation	Model 203.08/09/28/29
BA33.30-P-1004-02C	Bolt, front axle gear propeller shaft to front axle gear flange	M8 Stage 1 Nm 15
		Stage 2 \angle° 60
		M10 Stage 1 Nm -
		Stage 2 \angle° -

Nm Front axle transmission

Number	Designation	Model 203.08/09/ 28/29
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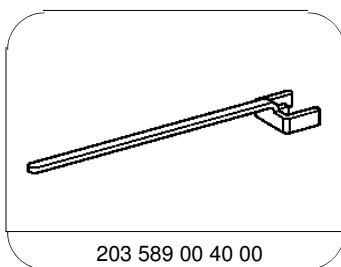
BA33.30-P-1001-03D	Collar bolt connecting mounting support to front axle final drive and engine mount carrier	Nm	22
BA33.30-P-1002-03D	Collar bolt of front axle gear to engine oil pan	Nm	65
BA33.30-P-1006-03D	Oil filler opening screw plug	Nm	30

Steering gear

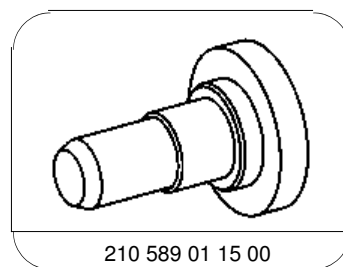
Number	Designation			Model 203
BA46.20-P-1002-01F	Bolted connection, rack-and-pinion steering to front axle carrier	Stage 1	Nm	50
		Stage 2	∟°	90
BA46.20-P-1004-01F	Bolted connection, supporting plate to front axle carrier	Stage 1	Nm	50
		Stage 2	∟°	60

Front axle gear

Number	Designation		Model 203.08/09/28/29
BF33.30-P-1001-03C	Hypoid gear oil	Filling capacity	Liters 0,46
		Specifications for service products	Sheet BB00.40-P-0235-07 A



Counterholder



Drift

Repair materials

Number	Designation	Order number
BR00.45-Z-1002-06A	Lubricating paste, rubber parts 2.5 kg, DB supply specification 6867.00	A 000 989 01 60