

ENGINES 271.940 in MODEL 203.042 /242 /742, 209.342 /442

ENGINES 271.942 in MODEL 203.043 /243 /743, 209.343

ENGINES 271.946 in MODEL 203.046 /246 /746

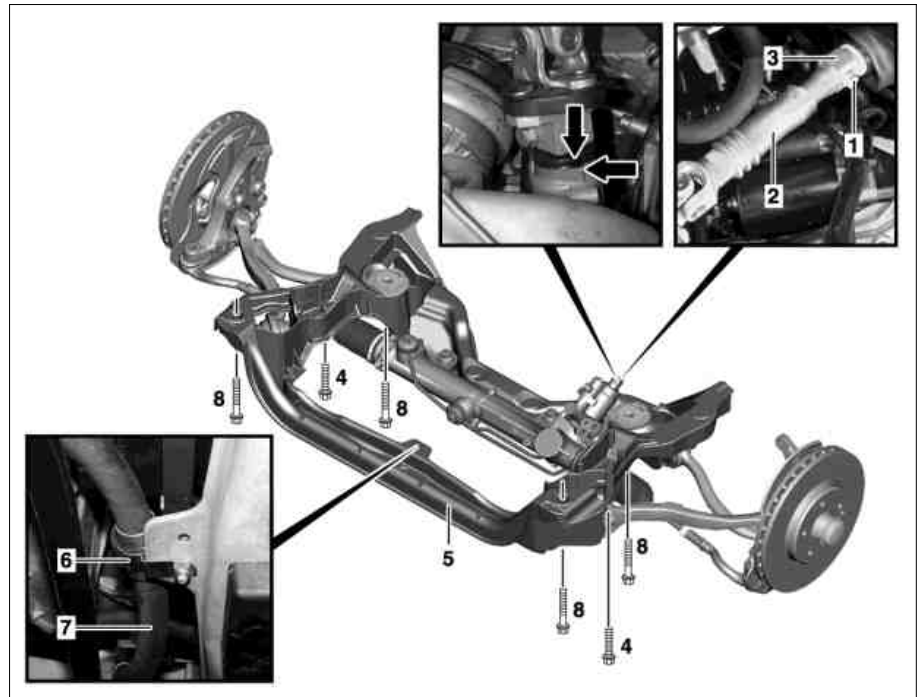
ENGINES 271.948 in MODEL 203.040 /240 /740

ENGINES 271.921 in MODEL 203.730

ENGINES 271.955 in MODEL 209.341 /441

ENGINES 271.957 in MODEL 203.741

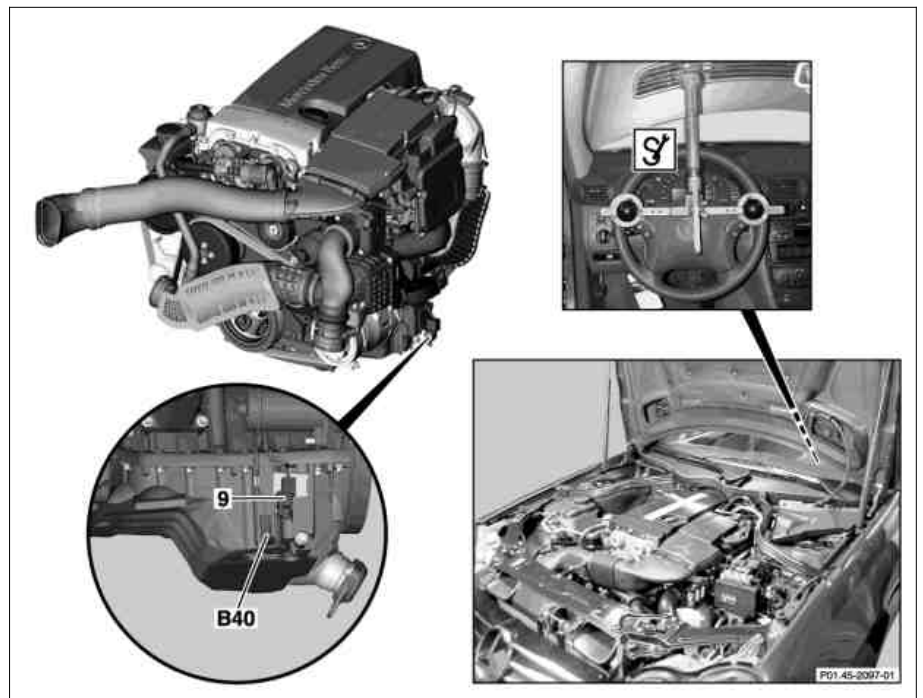
- 1 Bolt
- 2 Drag link
- 3 Locking plate
- 4 Bolt
- 5 Front axle carrier
- 6 Bracket
- 7 Power steering pressure line
- 8 Screw



P33.00-2031-06



























- 9 Electrical connector

B40 Oil sensor (oil level, temperature and quality)



P01.45-2099-06

⚠	Remove/install		
⚠ Danger!	Risk of death caused by vehicle slipping or toppling off 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 to skin and eyes caused by handling hot or glowing objects.	Wear safety gloves, protective clothing and safety glasses, if necessary.	AS00.00-Z-0002-01A
🔧	Notes on avoiding damage through contamination and foreign objects		AH00.00-P-5000-01A

	Notes on self-locking nuts and bolts		AH00.00-N-0001-01A
1	Deactivate easy entry/exit function for driver seat and steering wheel	Vehicles with code (275) Driver seat, steering column and electrically adjustable outside mirrors with memory  In order to damage on the upper frame for an installed holding device .	
2	Move out steering column as far as possible and put the steering in the straight-ahead position		
3	Lock steering wheel in position using the retainer.	 The steering wheel must not be turned when steering coupling is detached otherwise the clock spring contact is destroyed. 	*129589012100
4	Remove bottom engine compartment paneling		AR61.20-P-1105P
5	Remove bolt (1) of drag link (2)	 Installation: Replace locking plate (3) to prevent loosening. 	*BA46.10-P-1001-01E
6	Remove catalytic converter	Engine 271.942	AR49.10-P-5531QD
 AP	Extract or drain engine oil Engine oil change and filter change		AP18.00-P-0101AB
8	Remove bolt (4) on the right and left engine mount on the front axle carrier (5)	 Model 203  Model 209	*BA22.10-P-1006-01O *BA22.10-P-1002-03B
9	Detach bracket (6) for power steering pressure line (7) from front axle carrier (5)		
10	Mount engine lifting device and raise engine	 In order to avoid damage, do not get components caught in moving parts or overstretch them. 	AR33.10-P-0100-01P *240589006100
11	Unlock and disconnect the electrical connector (9) at the oil sensor (oil level, temperature and quality) (B40)		
12	Prop front axle carrier (5)		AR33.10-P-0100-03P
13	Remove bolts (8) of front axle carrier (5)	 Model 203  Model 209	*BA33.10-P-1003-01A *BA33.10-P-1001-01H AH00.00-P-0007-01SF
	Notes on bolted connections with self tapping screws		
14	Lower front axle carrier (5)	 Installation: Do not tilt the lower and upper steering shaft to avoid damage.	
15	Remove bolts from oil pan	 Installation: Observe different bolt lengths and diameters: Bolt plan for oil pan   	AR01.45-P-7500-06QK *BA01.45-P-1001-01H *BA01.45-P-1006-01H *BA01.45-P-1008-01H
16	Remove oil pan to the back 	 Installation: Apply sealant to sealing surface of oil pan.  Loctite sealant 5970	AH01.45-P-0001-01T *112589002500 *BR00.45-Z-1013-01A
	Clean		
17	Clean sealing surfaces	 Do not use any sharp-edged tools or abrasive paper as this will damage the sealing surfaces. Loctite 7200 Cleaning spray, Loctite 7063 (150ml)	AR01.00-P-0050-01A *BR00.45-Z-1038-04A *BR00.45-Z-1046-04A
18	Install in the reverse order		
 Danger!	Risk of accident caused by vehicle starting off by itself when engine is running. Risk of injury caused by contusions and burns during starting procedure or when working near the engine as it is running	Secure vehicle to prevent it moving off. Wear closed and close-fitting work clothes. Do not touch hot or rotating parts.	AS00.00-Z-0005-01A
19	Conduct engine test run and check engine for leaks		
 AP	Check engine oil level; correct if necessary Engine oil change and filter change		AP18.00-P-0101AB
 AD	Read out and erase fault memory Connect STAR DIAGNOSIS and read out fault memory		AD00.00-P-2000-04A

Nm Oil pan

Number	Designation			Engine 271
BA01.45-P-1001-01H	Bolt, oil pan to cylinder crankcase	M6×30	Nm	9
		M6×90	Nm	9
		M8×35	Nm	20
BA01.45-P-1006-01H	Bolt, transmission bell housing to oil pan		Nm	38
BA01.45-P-1008-01H	Bolt, oil pan to timing case cover	M6	Nm	9

Nm Engine suspension, engine mounts, engine supports

Number	Designation		Engine 271 in model 203
BA22.10-P-1006-01O	Bolt, front engine mount to front axle carrier	Nm	35

Nm Engine mount, engine support (engine side)

Number	Designation		Model 209
BA22.10-P-1002-03B	Bolt connecting front engine mount to front axle crossmember	Nm	35

Nm Front axle carrier

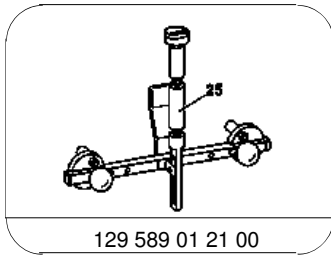
Number	Designation		Model 203
BA33.10-P-1003-01A	Bolt, front axle carrier to front end	Nm	100

Nm Front axle carrier

Number	Designation		Model 209
BA33.10-P-1001-01H	Bolt, front axle carrier to front end	Nm	100

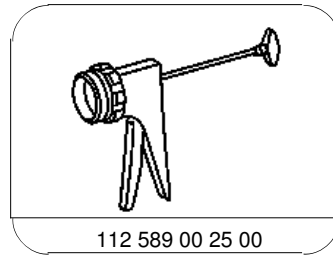
Nm Steering shaft

Number	Designation			Model 203 except 203.081/ 084/087/ 092/281/ 284/287/ 292	Model 209
BA46.10-P-1001-01E	Bolt, steering coupling to steering shaft	Stage 1	Nm	30	30
		Stage 2	°	-	-



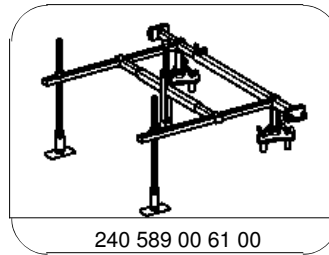
129 589 01 21 00

Holding device



112 589 00 25 00

Squeeze gun



240 589 00 61 00

Engine lifting fixture

Repair materials

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