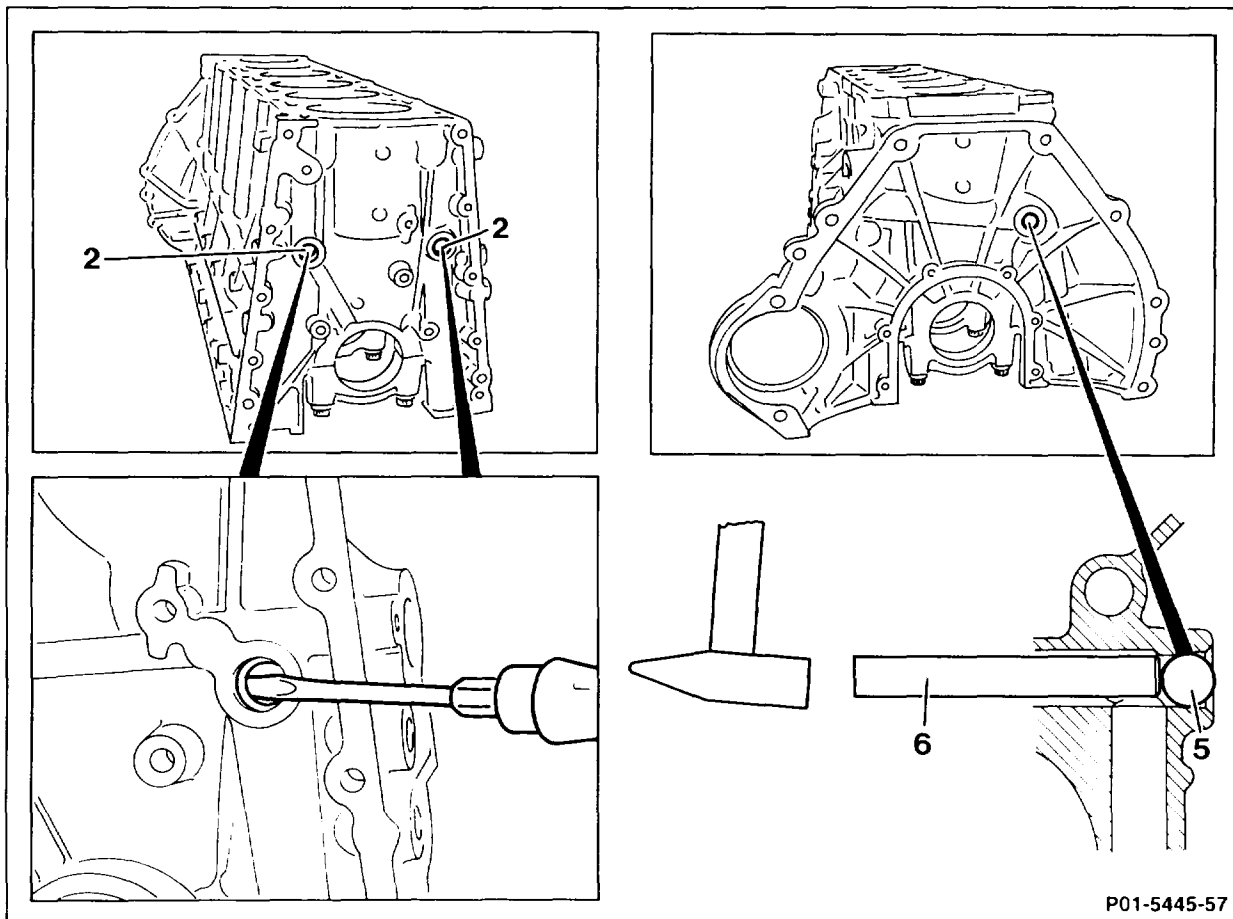


01-1300 Cleaning, sealing main oil galleries

Preceding work:
Engine disassembled

Operation no. of operation texts and work units or standard texts
and flat rates

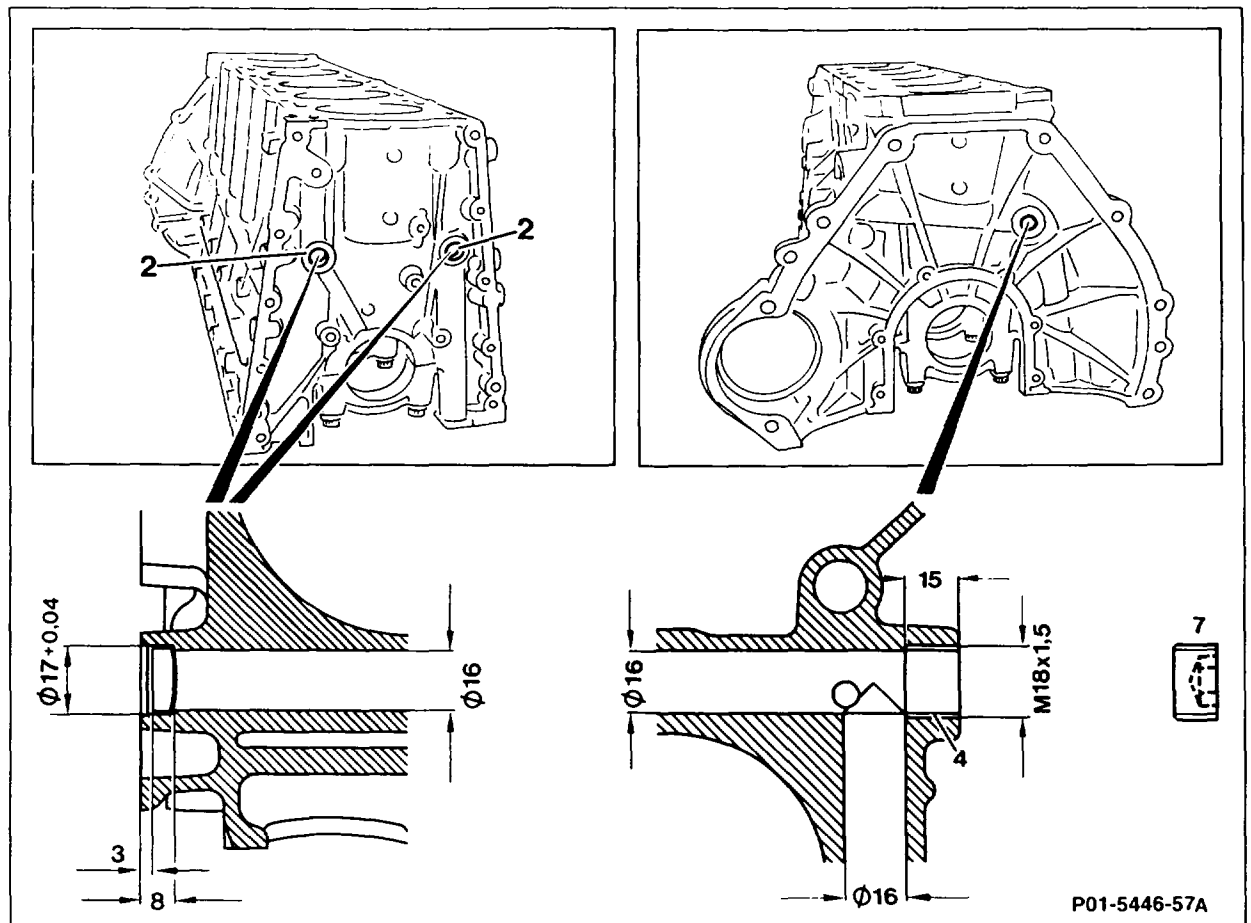
Cleaning



P01-5445-57

Plug (2)	strike with screwdriver at one side, press out.
Steel ball (5)	knock out from front side of engine with bar (6) (approx. 10 mm dia.; length 750 mm).
Oil galleries	clean.

Sealing



Main oil galleries	clean
New plug (2)	coat on circumference with Loctite 270 high-strength 002 989 93 71 10.
New plug (2)	knock in with insertion drift 102 589 12 15 00 as far as a stop on front side of engine.

A. Sealing end of main oil gallery with steel ball

Steel ball knock in with insertion drift 102 589 07 15 00
2 mm deeper than originally so that the steel ball is provided with a new seat in the \varnothing 14.75 H11 bore.

Note

This method is only successful if no leak existed beforehand as a result of porosity in the crankcase oil gallery (ball seat). The steel ball must be free of damage and rust.

B. Sealing end of main oil gallery with screw plug

End of main oil gallery (4) at rear widen (\varnothing 16 mm, depth about 15 mm).
Thread (M18 x 1.5) tap into end of main oil gallery (4)
Swarf thoroughly clean out of oil galleries
Thread and screw plug (7) remove grease
M18 x 1.5 screw plug (7) DIN no. 000 906 018 00 coat with sealing adhesive 000 906 014 000,
screw in, tighten.

Special tool

