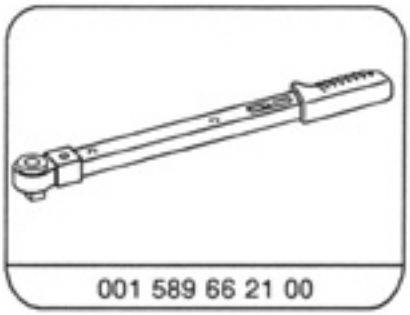
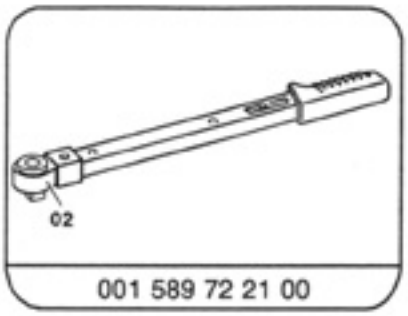
Tightening torques and tightening angle		Nm
Hexagon bolts of cylinder head cover		10
Twelve-point bolt of camshaft sprocket	initial torque	25
	tightening angle	90°
Hexagon bolts of camshaft bearing caps		25

Special tools



001 589 66 21 00



001 589 72 21 00

Commercially available tools and testers

Designation	e.g. make	Order no.
Rubber suction cup ∅ 30 mm	Hazet 42804 Remscheid	795-3

Removing

Turbo engine model 603.972

1 Remove boost air pipe and air cleaner cross pipe.

Engine 602.942 in model 461

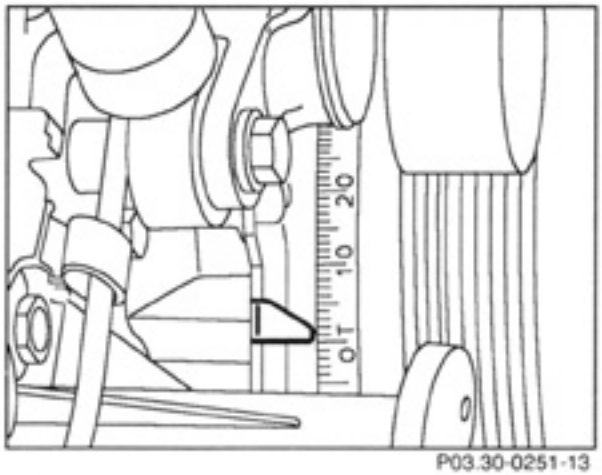
2 Remove air cleaner cross pipe.

3 Remove cylinder head cover.

4 Position engine to ignition TDC of cylinder 1 (arrow).

⚠

Do not crank engine at the bolt of the camshaft sprocket. Do not crank engine back.

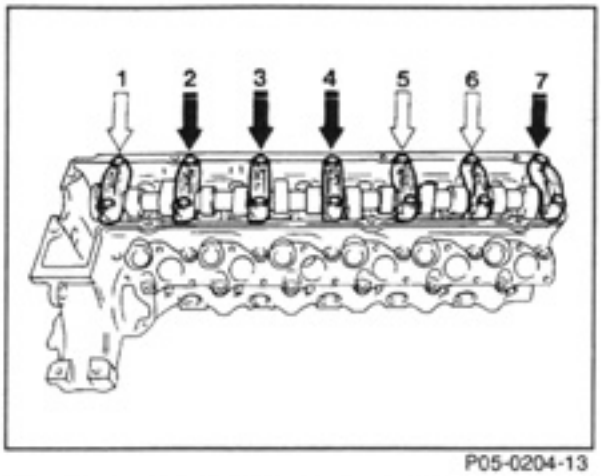


P03.30-0251-13

Engine 603

Unscrew both hexagon bolts at camshaft bearing caps 1, 5, 6 (light arrows).

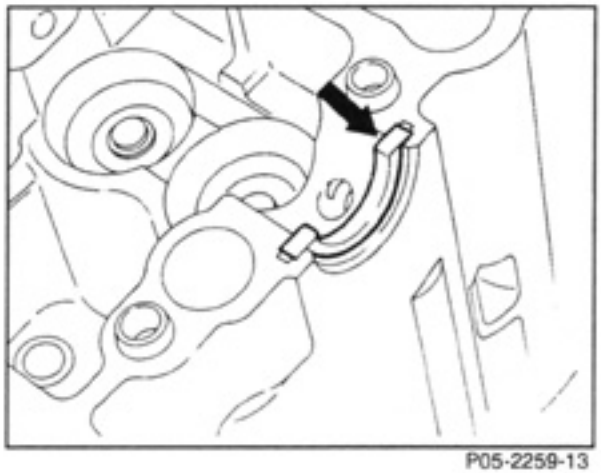
Slacken both hexagon bolts for camshaft bearing caps 2, 3, 4 and 7 in stages of one turn each until the back-pressure has been reduced (dark arrows).



P05-0204-13

10 Lift out camshaft.

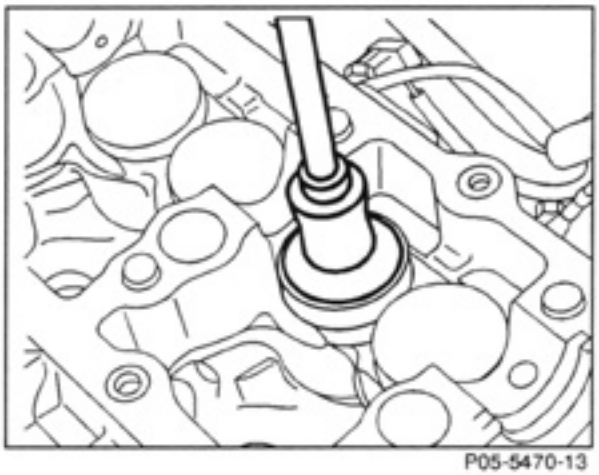
11 Take out locking plate for axial location (arrow) and inspect condition.


P05-2259-13

12 Use a rubber suction cup to lift out valve tappets.

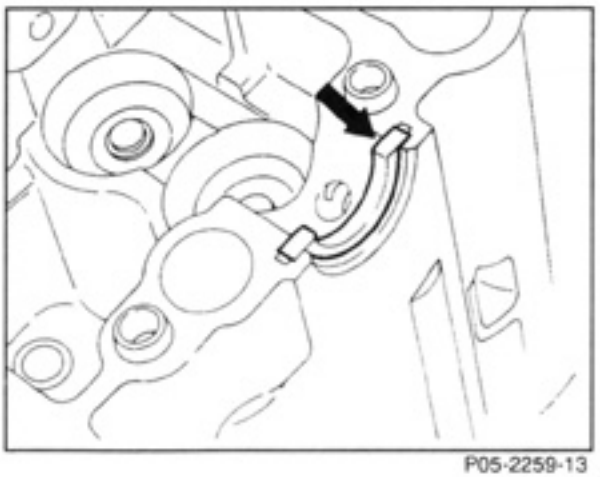
13 Inspect condition of valve tappets (visual inspection), replace if necessary.

⚠
Install valve tappets at the same point again.


P05-5470-13

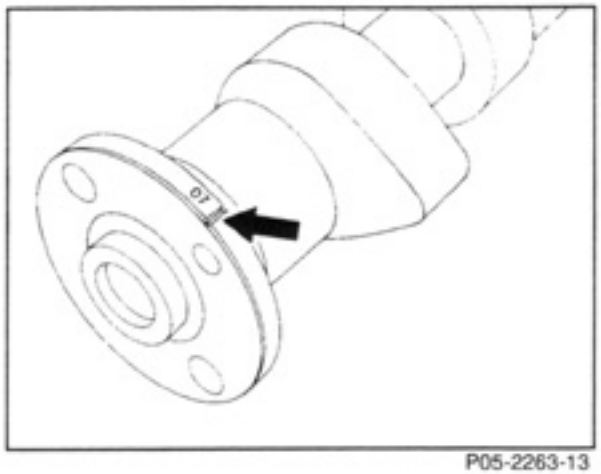
Installing

14 Insert locking plate for axial location (arrow) in cylinder head.


P05-2259-13

15 Oil camshaft and place into the cylinder head so that the TDC marking (arrow) is facing up vertically.

16 Install camshaft bearing caps. Pay attention to the marking of the bearing caps.



P05-2263-13

Insert bolts of the camshaft bearing caps (dark arrows) and tighten alternately in stages of one turn each as specified in the tightening diagram; refer to step 10.

Engine 602:	camshaft bearing caps 3, 4 and 5
Engine 603:	camshaft bearing caps 2, 3, 4 and 7

The remaining camshaft bearing caps (light arrows) can then be installed in any desired order.

Tightening torque 25 Nm