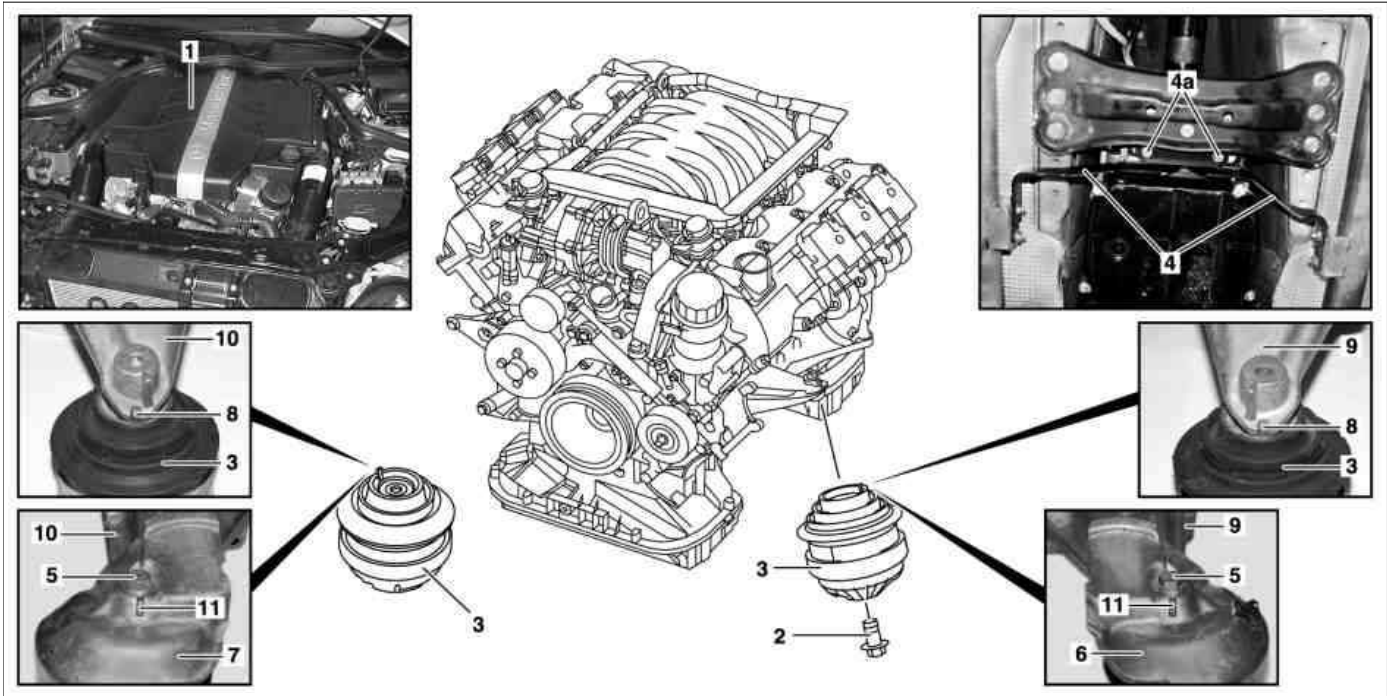


ENGINE	112.912 in MODEL 209.361, 203.261, 209.461, 203.061 with TRANSMISSION 722.6, 716.6
ENGINE	112.946 in MODEL 203.264 /064 with TRANSMISSION 722.6
ENGINE	112.961 in MODEL 203.265 /065 with TRANSMISSION 722.6
ENGINE	113.968 in MODEL 209.475 /375 with TRANSMISSION 722.633
ENGINE	112.913 in MODEL 211.261 /061 with TRANSMISSIONS 722.6, 716.6
ENGINE	112.949 in MODEL 211.265 /065 with TRANSMISSION 722.618
ENGINE	113.967 in MODEL 211.270 /070 with TRANSMISSION 722.633
ENGINE	113.987 in MODEL 209.376 /476 with TRANSMISSION 722.636
ENGINE	112.955 in MODEL 209.365 /465 with TRANSMISSION 722.618
ENGINE	113.990 in MODEL 211.276 /076 with TRANSMISSION 722.643



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Shown on engine 112

- | | | |
|-----------------------|----------------|-------------------------|
| 1 Air cleaner housing | 4a Bolts | 8 Anti-twist locks |
| 2 Bolt | 5 Bolts | 9 Left engine support |
| 3 Engine mount | 6 Left shield | 10 Right engine support |
| 4 Bracket | 7 Right shield | 11 Anti-twist locks |
| 12 Cross strut | | |



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Modification notes

16.5.06	"Disconnect/connect battery ground line" removed		
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	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
	Notes on self-locking nuts and bolts		AH00.00-N-0001-01A

1.1	Remove air filter housing (1).	Engine 112.912 /946 /961 in model 203 Engine 112.912 /955 in model 209 Engine 112.913 /949, 113.990 in model 211 Engine 113.987 in model 209.376 /476 as of 24.4.04	AR09.10-P-1150SVK AR09.10-P-1150AC
1.2	Unclip cover on front side of engine	Model 209, 211 with engine 113 except AMG	
2	Detach lower engine compartment paneling	Model 203, 209 Model 211	AR61.20-P-1105P AR61.20-P-1105T
3	Remove bolt (2)	 Model 209  Model 211  Model 203	*BA22.10-P-1001-01L *BA22.10-P-1002-03A *BA22.10-P-1001-01R
4.1	Remove complete exhaust system	Engine 112 in model 203 Engine 112 in model 209 Engine 113.987 in model 209.376 up to 23.4.04, 209.476 Engine 113.968 in model 209.375 /475 Engine 113.987 in model 209.376 as of 24.4.04	AR49.10-P-7000PV AR49.10-P-7000AC
4.2	Remove front exhaust system from right and left exhaust manifold	Model 211  Installation: Replace bolts and check rivet nuts in the exhaust manifold, replace if required: ↓ Replace rivet nuts in exhaust manifold.  	AR49.10-P-7000TB AR49.10-P-5531-01DA *BA14.10-P-1002-01B *103589013900
5	Remove bolts (4a)	Model 211 	*BA49.10-P-1011-01A
6	Detach bracket (4) for exhaust system from transmission	Model 211	
7	Remove cross strut (12)	Model 211	
8	Mount bracket on supercharger	Engine 112.961, 113.990  For engine lifting device.	
9	Mount engine lifting device	Model 203, 209 Model 211  Model 211	AR33.10-P-0100-01P AR33.10-P-0100-01T *240589006100
10	Raise engine	 When lifting engine ensure that components are neither pinched or overstretched to avoid causing damage.	
11	Remove bolts (5)	 Model 209  Model 211  Model 203	*BA22.10-P-1004-01L *BA22.10-P-1001-03A *BA22.10-P-1004-01R
12	Remove engine mounts (3)	 Remove engine mount (3) from left engine carrier (9) and right engine carrier (10). Remove engine mount (3) with left head shield (6) and right heat shield (7).  Installation: Anti-twist locks (8) on engine mounts (3) must latch into retaining grooves in the left engine support (9) and right engine support (10). Anti-twist locks (11) on the right engine support (10) and the left engine support (9) must sit in the cutouts on the left shield (6) and the right shield (7).  Pay attention to environmental protection regulations for disposal of engine mounts (3). Dispose engine mounts (3) into mixed scrap.	
13	Install in the reverse order		
14	Connect STAR DIAGNOSIS and delete fault memory		

Exhaust manifold

Number	Designation	Engine 112 except 112.951 / 976	Engine 113.940/941/ 942/943/944/ 945/946/948/ 960/961/962/ 963/964/965/ 966/967/968/ 969/971/980/ 981/982/984/ 986/992/993/ 995	Engine 113.987/ 988/990/ 991
BA14.10-P-1002-01B	Flange connection, exhaust manifold/front exhaust pipes	Nm 20	20	20

Engine mounts, engine supports

Number	Designation	Engine 112.912 in model 209	Engine 112.955 in model 209
BA22.10-P-1001-01L	Bolt, front engine mount to front axle carrier	Nm 35	35
BA22.10-P-1004-01L	Bolt connecting front engine mount to engine support	Nm 55	55

Engine mounts, engine supports

Number	Designation	Engine 113.968 in model 209	Engine 113.987 in model 209
BA22.10-P-1001-01L	Bolt, front engine mount to front axle carrier	Nm 35	35
BA22.10-P-1004-01L	Bolt connecting front engine mount to engine support	Nm 55	55

Engine mount, engine support (engine side)

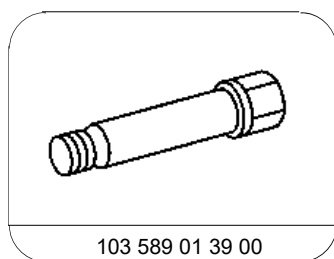
Number	Designation	Model 211 except 4 MATIC
BA22.10-P-1001-03A	Front engine support on engine mount	Nm 50
BA22.10-P-1002-03A	Front engine mount on front axle carrier	Nm 35

Engine mounts, engine supports

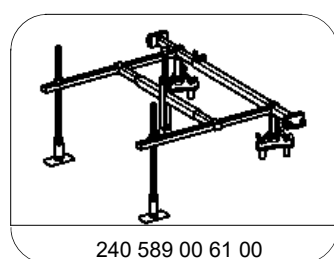
Number	Designation		Engine 112.912/ 946 in model 203	Engine 112.961 in model 203
BA22.10-P-1001-01R	Bolt, front engine mount to front axle carrier	Nm	35	35
BA22.10-P-1004-01R	Bolt, engine mount to engine support	Nm	55	-

Exhaust system

Number	Designation		Engine 112, 113 in model 211
BA49.10-P-1011-01A	Bolt, three way catalytic converter bracket to transmission housing	Nm	20



Caulking bolt



Engine lifting fixture