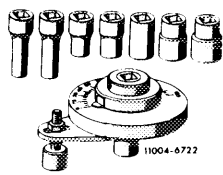


## 03-327 Renewing rear crankshaft radial sealing ring

Tightening torques		Nm
Necked-down screw for camshaft gear		80
Connecting rod nuts	initial torque	40-50
	angle of rotation torque	90-100°
Necked-down screws for flywheel or driven plate	initial torque	30-40
	angle of rotation torque	90-100°
Crankshaft bearing bolts		90

### Special tool

Angle of rotation tool		116 589 01 13 00
------------------------	--	------------------

### Self-made tool

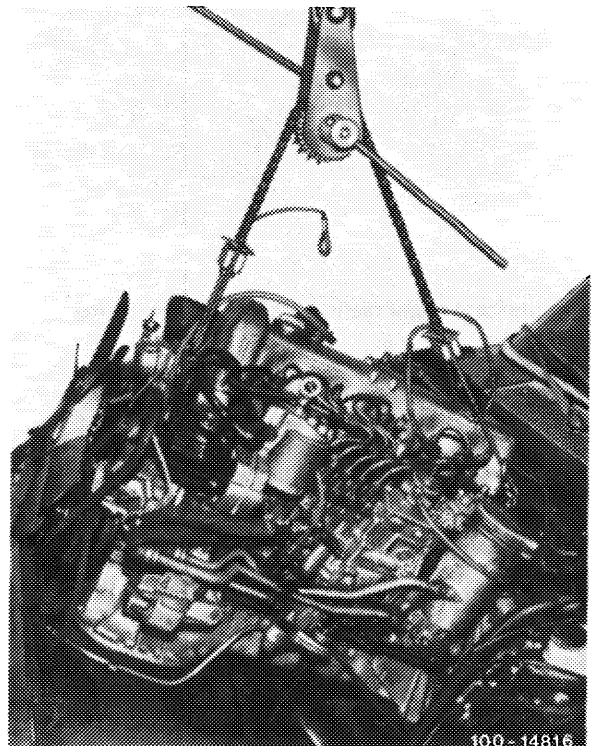
Gauge for cutting-off rear radial sealing ring	refer to Fig. item 4
--	----------------------

### Note

The radial sealing ring is graphite gray similar to that in other diesel engines.

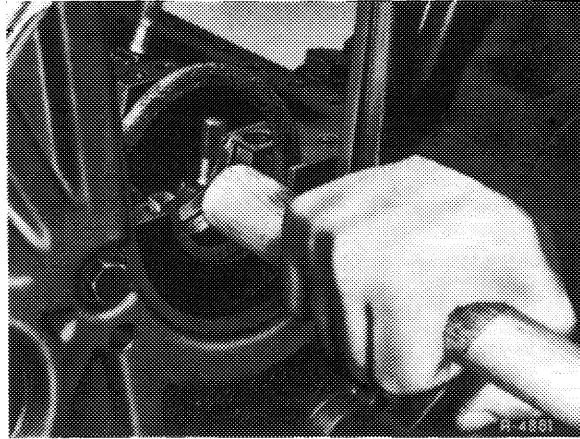
### Renewing

- 1 Remove engine (01-030).
- 2 Remove crankshaft.

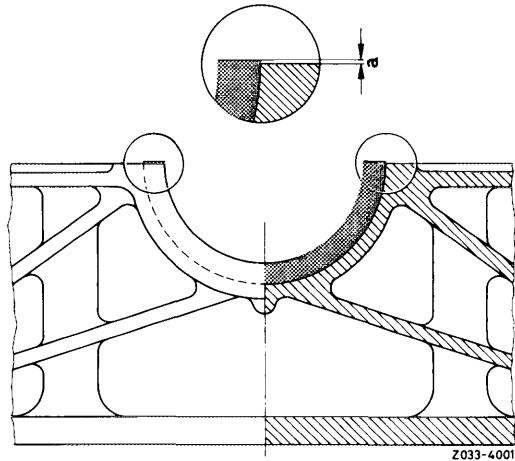


100 - 14816

3 Place radial sealing ring into cylinder crankcase and into oil pan and work in by means of a lubricated hammer handle.

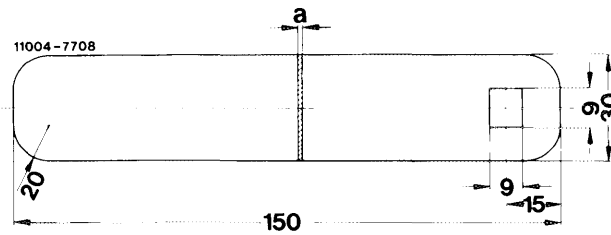


4 To obtain the required overlap, cut off radial sealing ring in cylinder crankcase and oil pan approx. 1.0 mm above parting surface.



Dimension a = 1.0 mm

**Note:** For cutting-off, a self-made template according to drawing can be used.



Dimension a = 1.0 mm

5 Lubricate radial sealing ring prior to installing crankshaft.

6 Install crankshaft.

7 Mount oil pan, rotate crankshaft and check for unobstructed operation.