Tightening torques	Nm
Self-locking hex. nuts on lateral support of clamp	7
Self-locking hex. nuts on exhaust manifold to exhaust flange	30
Upper exhaust pipe flange connection	20
Lower exhaust pipe flange connection	15
Hex. head screws of lateral support on transmission	20

Removal and installation of exhaust system are not explained in full scope, and reference is made only to particularly important items, which must be observed during removal and installation or during a partial replacement e.g. of end muffler with plug connection.

Removal

1 Check mounting components for re-use and adjust, if required.

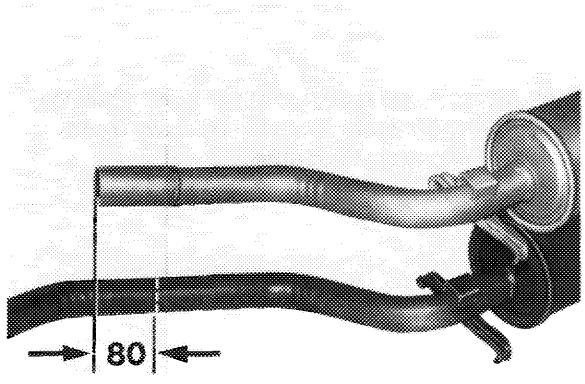
2 Prior to assembly of exhaust system, make sure that the flanges are not distorted and straighten flanges, if required. Clean cone connections of pipes, if required, from combustion residue with emery cloth.

Installation

Replacement of end muffler.

3 Place new end muffler with plug connection accurately above removed system and mark pipe length of new end muffler on removed system.

Starting from mark, separate pipe at a distance of 80 minus 10 mm in direction of end muffler to guarantee plug-in depth of 70–80 mm.



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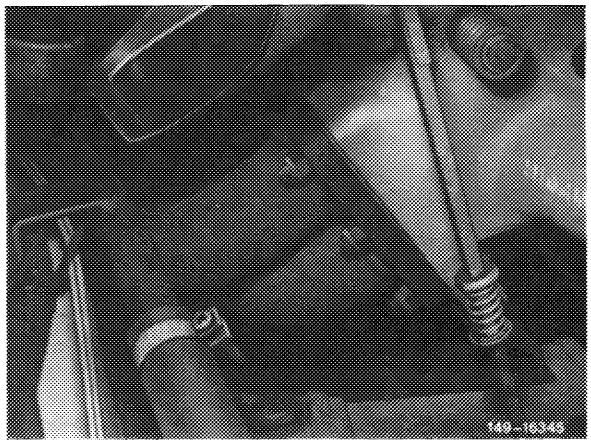
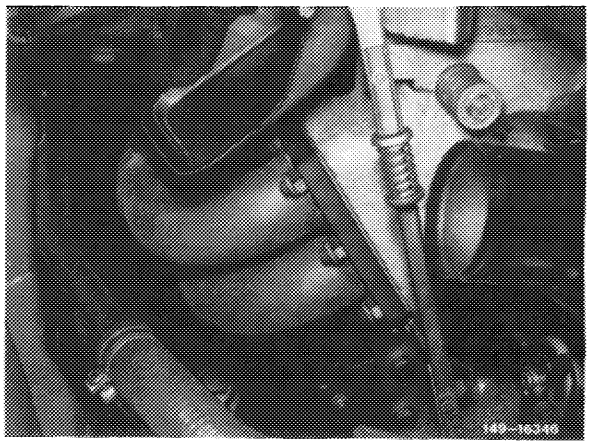
4 Always replace self-locking hex. nuts and gasket between exhaust manifold and exhaust flange.

5 Tighten flange connection to manifold uniformly. Tightening torques of self-locking hex. nuts 30 Nm.

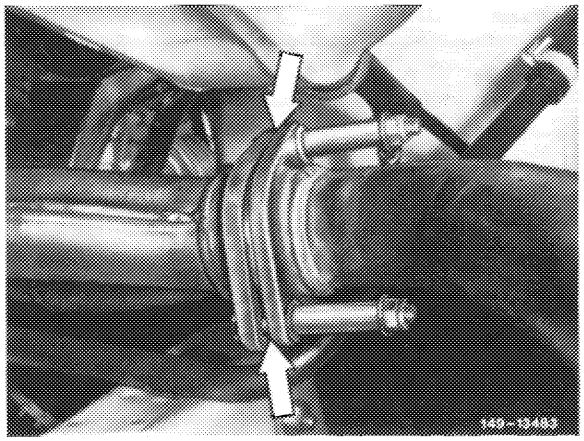


Connection exhaust pipe-manifold on model 115



Connection exhaust pipe-manifold on model 123

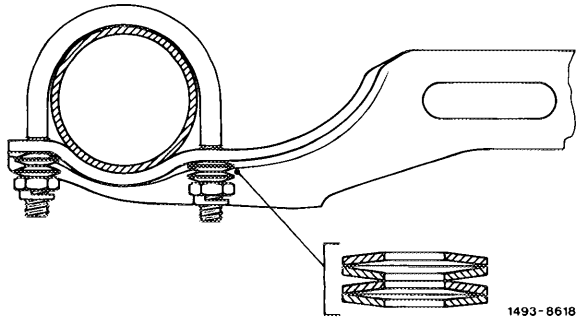
6 Loosely mount exhaust intermediate pipe with sleeves. Add one washer each between flange and sleeve and between sleeve and self-locking hex. nut.



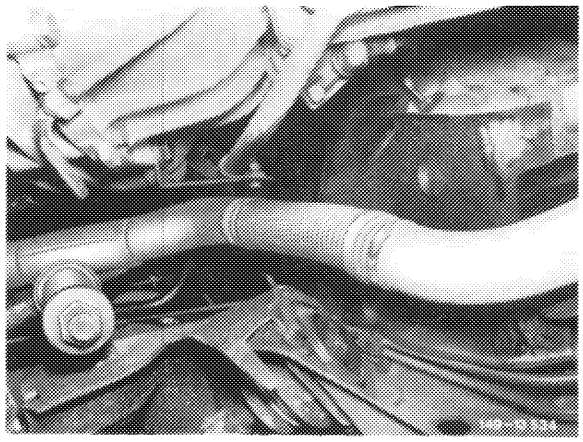
Model 115 and 123 (version 1)

7 Loosely mount exhaust level support on transmission in relation to pipe.

Note: Mount 4 cup springs each per side on holding clamp in such a manner that the respective crowns are facing away from each other.



8 On model 123 version 2 (starting March 1979) with a rolled hose at front exhaust pipe, prior to introducing rear axle system into front exhaust pipe, mount clamp of lateral support slightly tensioned to relieve rolled hose.

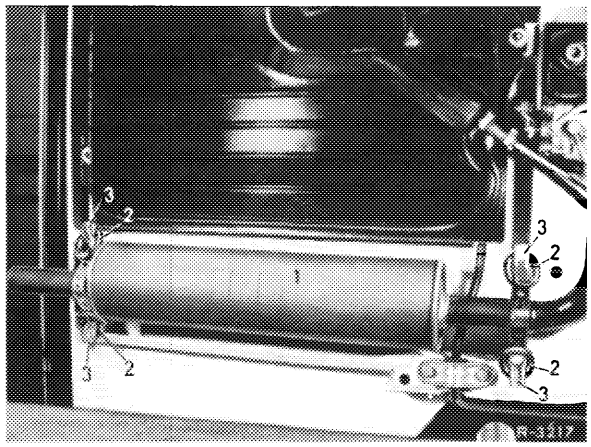


Model 123 (version 2)

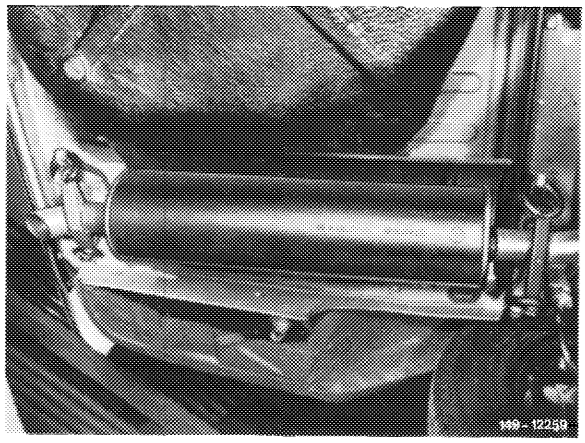
9 Mount rear exhaust system with center and end muffler.

10 Mount end muffler in such a manner that the holding clamps of the end muffler are located approx. 10 mm in front of holders on frame floor, so that the correct installation position is assured in the event of an elongation of exhaust system.

Note: This refers only to mufflers in repair version with a plug connection between center and end muffler.



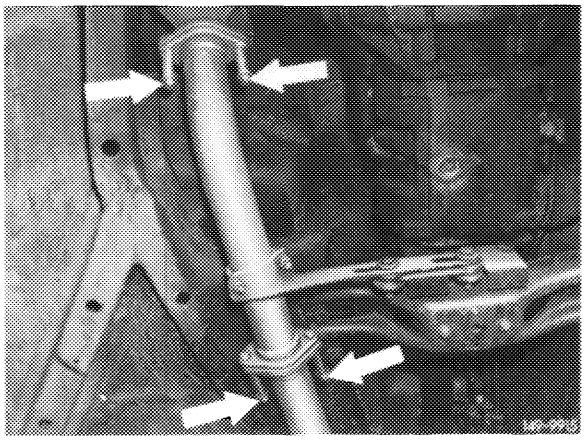
Model 115



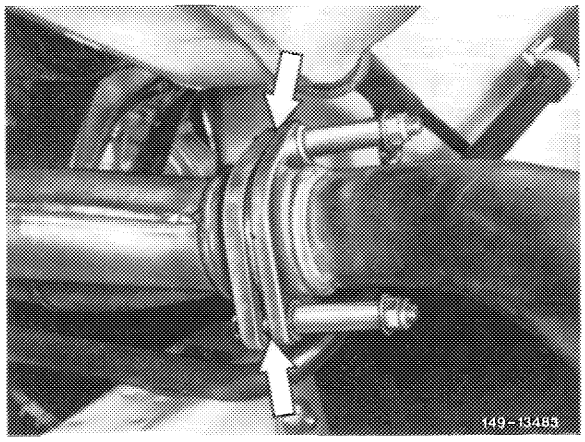
Model 123

11 Uniformly tighten upper flange connection to 20 Nm and lower flange connection to 15 Nm.

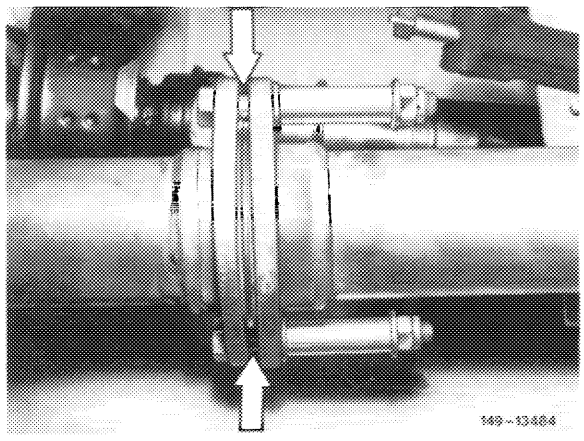
Note: Flanges should be in parallel with each other and should not be in touch with each other.



Model 115

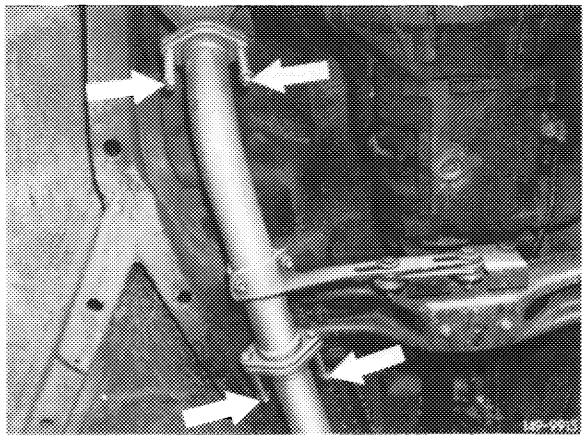


Upper exhaust flange connection on model 123



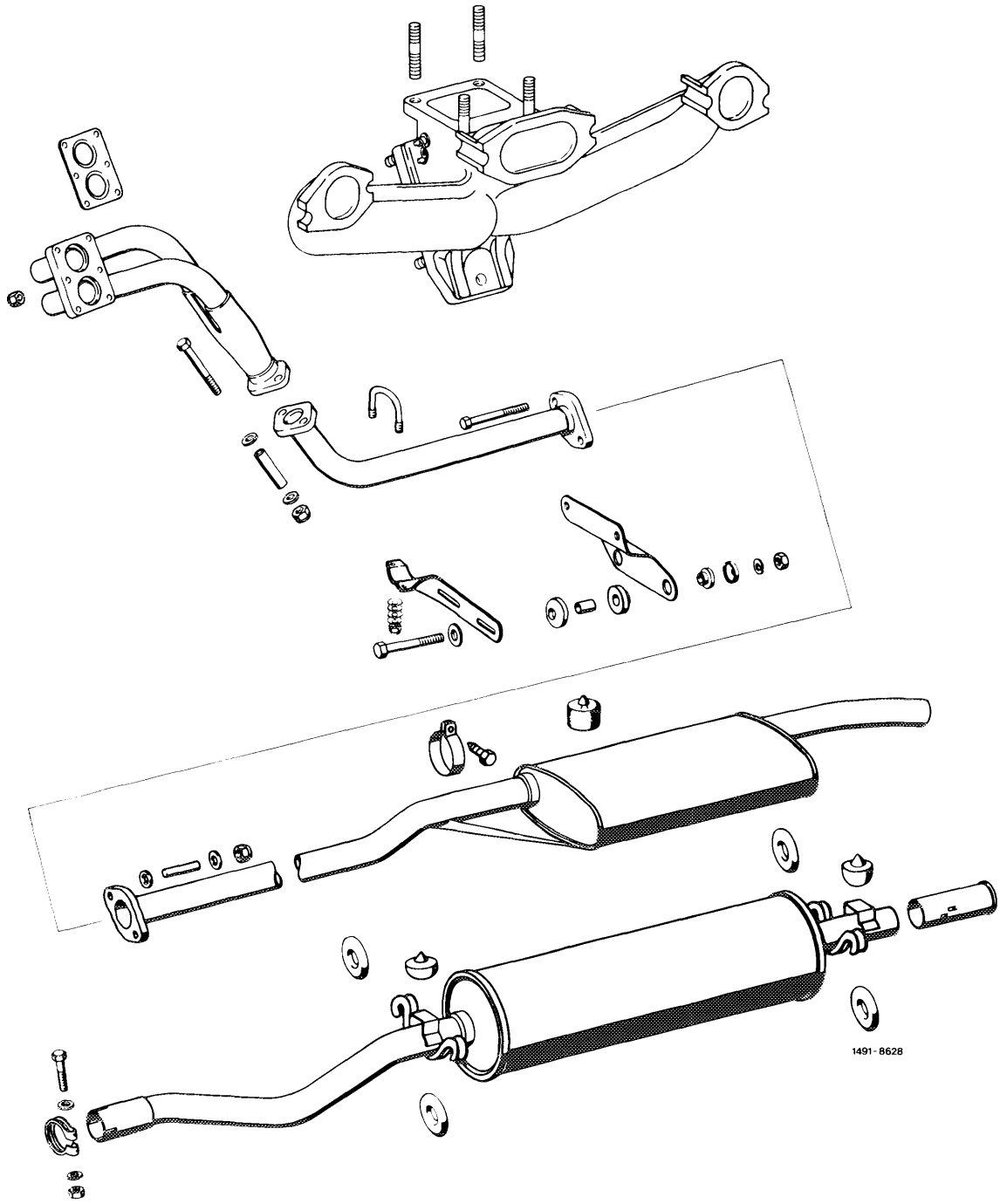
Lower exhaust flange connection on model 123

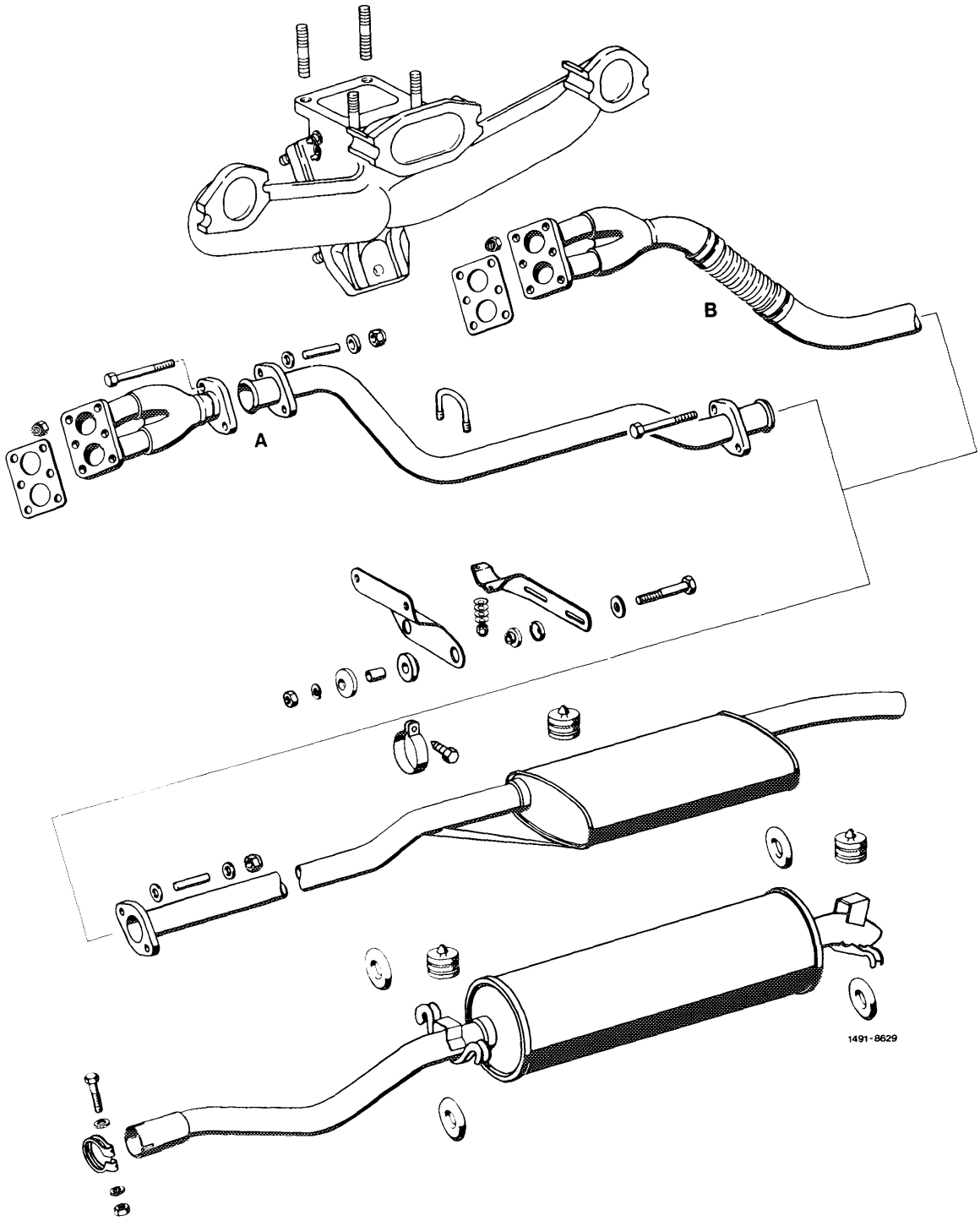
12 Mount exhaust lateral support free of tension. Tightening torque of self-locking hex. nuts on clamp 7 Nm, hex. bolts of lateral support on transmission 20 Nm.



13 Run engine and check exhaust system for leaks.

Exhaust manifold with complete exhaust system
Model 115





A Front exhaust pipe with flange connection (version 1)
B Front exhaust pipe with rolled hose (version 2)