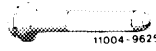


**Special tool**

Mandrel for knocking-in  
core hole closing covers



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**Note**

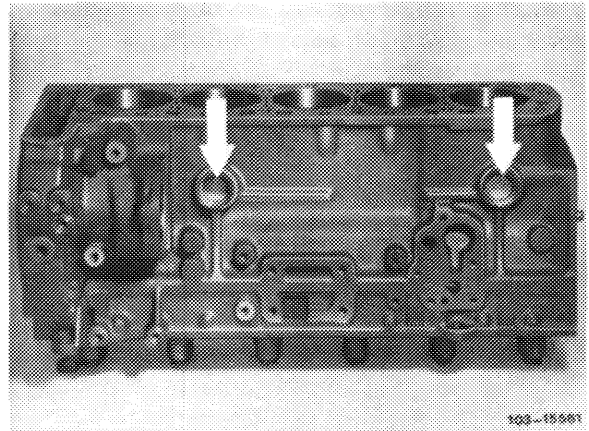
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Core holes in cylinder crankcase are closed with sheet metal covers (34 mm dia.).

Replace leaking closing covers on principle.

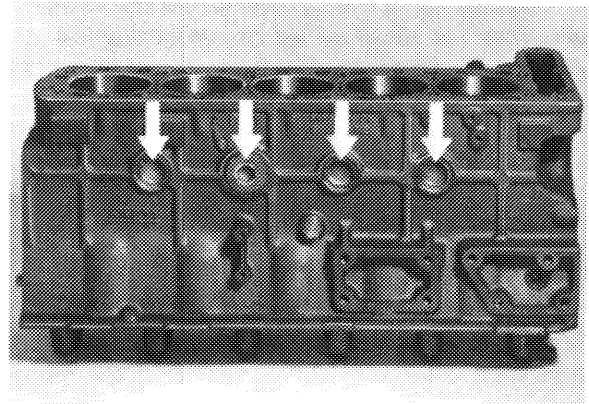
At the right (driving direction) the closing plug (M 38 x 1.5) remains in place.

Driving direction left

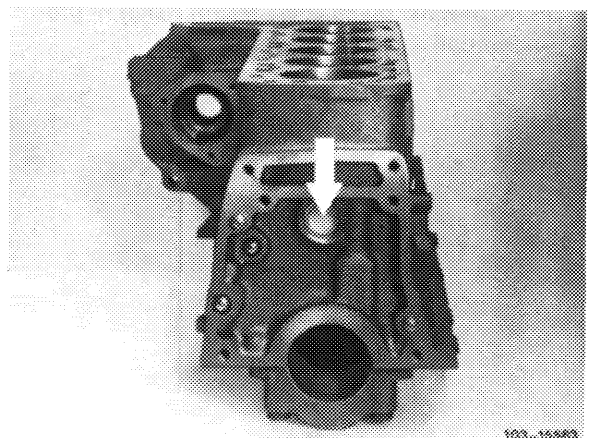


This core hole can be used to insert cooling water preheater.

Driving direction right



Transmission end

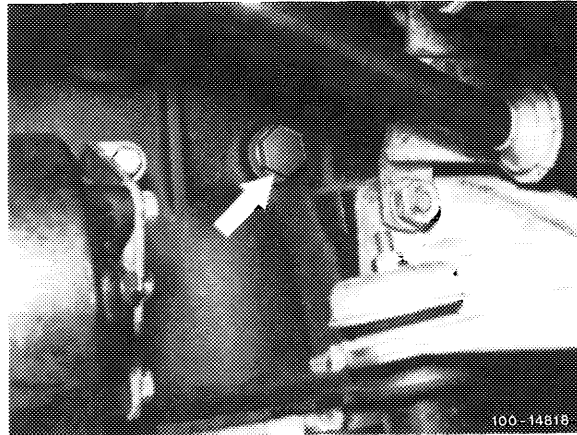


## Replacement

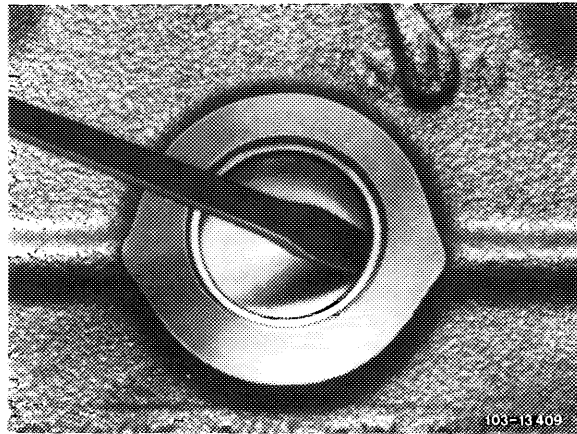
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- 1 Completely drain coolant.
- 2 Remove components which obstruct access (e.g. transmission, intermediate flange, injection pump etc.).

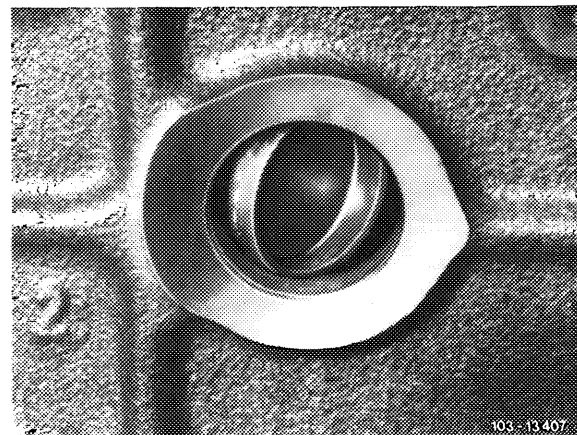
Drain plug on cylinder crankcase



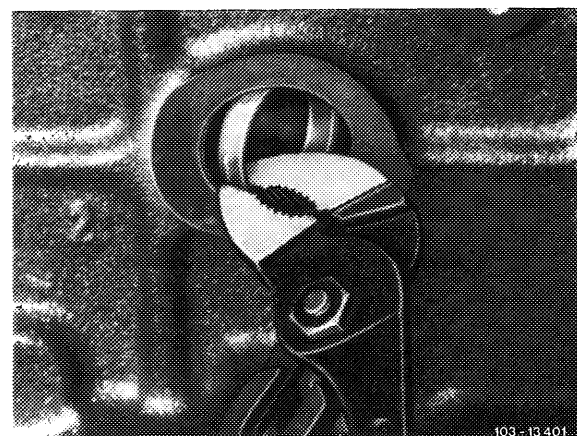
- 3 Position a chisel with a narrow blade or a screwdriver into deep drawn edge of closing cover.



- 4 Carefully knock closing cover on one side down until cover has turned around its own longitudinal axis (approx. 90°).

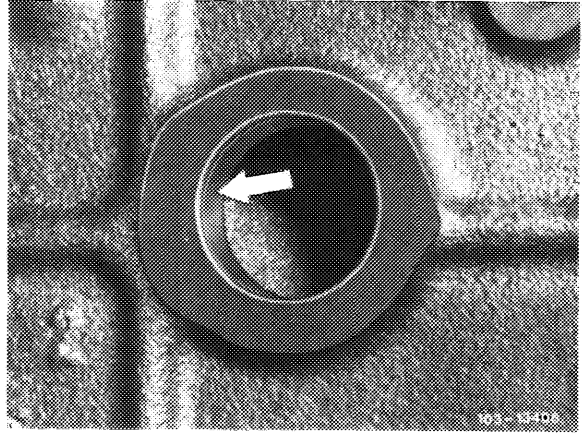


- 5 Position water pump pliers against flange of projecting section and pull out closing cover.



6 Thoroughly clean core hole from residue. Sealing surface should be free of grease (arrow).

7 Coat core hole with sealing glue, part no. 002 989 94 71.

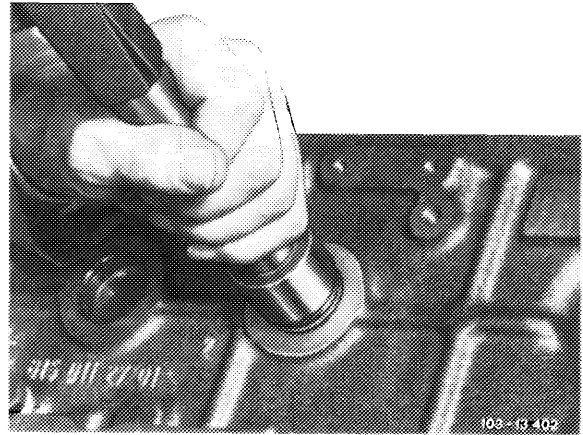


8 Knock-in new closing cover by means of mandrel.

9 Attach removed components.

10 Add coolant.

**Note:** The sealing glue should cure for approx. 45 minutes before adding coolant.



11 Run engine warm and check for leaks.