

Tightening torques	Nm
Self-locking nuts on compensating tube (model 107 only)	20-25
Self-locking nuts on exhaust manifold to exhaust flange	20-25
Self-locking hex. nuts on lateral support of clamp (model 126 only)	7
Hex. head screws of flange connection	20
Hex. head screws of lateral support on transmission (model 126 only)	20

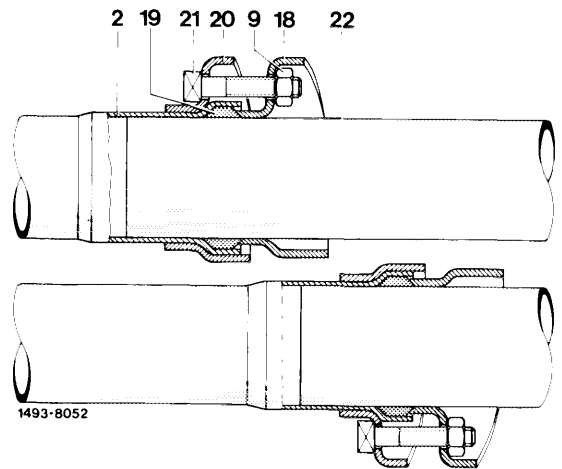
Removal and installation of exhaust system is not explained completely but attention is called to particularly important items, which must be observed during removal and installation or when renewing parts, for example end muffler with plug connection.

The same procedure is adopted on vehicles fitted with a retrofit catalytic converter (uncontrolled).

Removal and installation of catalytic converter (controlled), see 14-200.

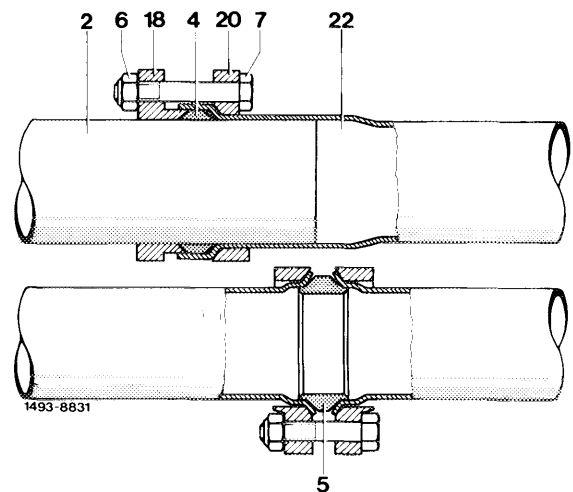
Removal

- 1 If separation at plug flange connection is not possible, spray exhaust pipes in range of flange connection with a corrosion solvent and let solvent penetrate.
- 2 Check suspension members for re-use and renew, if required.



Model 107

- 2 Front exhaust pipe
- 4 Asbestos sealing ring
- 5 Sinter sealing ring
- 6 Self-locking hex. nut
- 7 Hex. head screw
- 9 Hex. nut
- 18 Two-hole flange
- 19 Graphite gasket
- 20 Counterflange
- 21 Square head screw
- 22 Rear exhaust pipe



Model 126

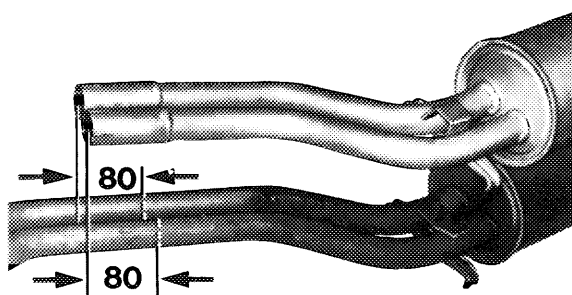
3 Prior to assembly of exhaust system, make sure that the flanges are not distorted, align flanges, if required (refer to model 107 on compensating pipe). Clean cone connections of pipes, as well as sinter sealing ring (on model 126), if required, with emery cloth from combustion residue.

4 Renew self-locking hex. nuts and asbestos or graphite gasket after one-time use on principle.

Installation

5 For renewing end muffler, place new end muffler with plug connection accurately above removed installation and mark pipe length of new end muffler on removed installation.

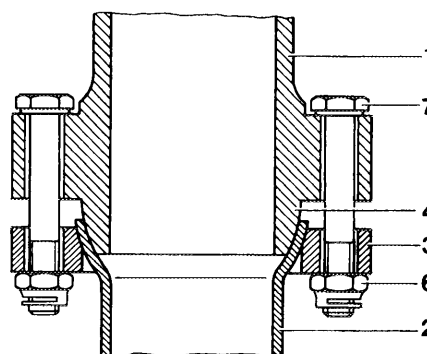
Cut pipe 80 minus 10 mm from mark in direction of end muffler to guarantee a plug-in depth of 70–80 mm.



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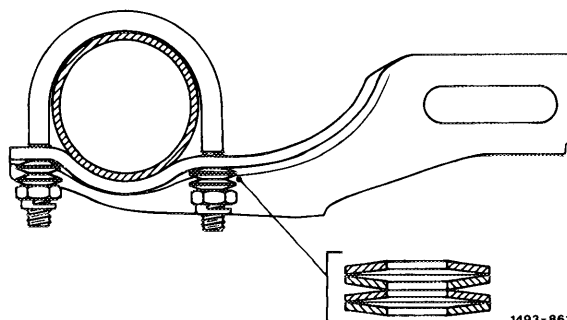
6 Tighten flange connection to exhaust manifold only after the complete installation has been connected to rubber rings. Pay attention to correct seat of front exhaust pipe. Tightening torque of hex. bolts 20–25 Nm.

- 1 Exhaust manifold
- 2 Flared exhaust pipe
- 3 Two-hole flange
- 4 Ball connection connected firmly to exhaust manifold
- 6 Self-locking hex. nut
- 7 Hex. bolt



7 Prior to introducing rear exhaust system, position front exhaust pipes with clamp and lateral support first, but do not yet tighten (model 126 only).

8 Mount four disk springs on holding clamp in such a manner that the crowns are each time opposite each other.



Model 126

9 Tighten flange connection on compensating pipe only after the complete exhaust system has been mounted. Then tighten pipe clamp. Tightening torque of self-locking nuts 20–25 Nm (model 107 only).

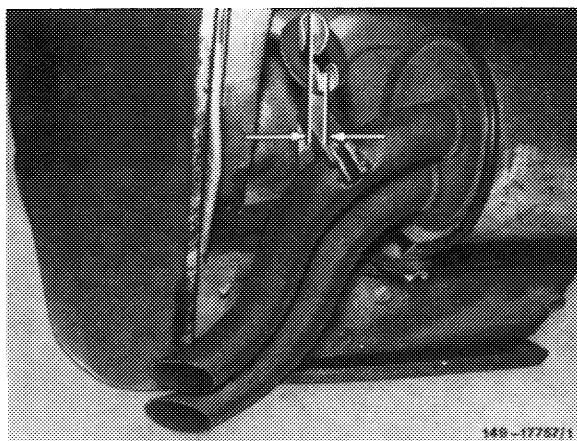
Note: Flanges must be in parallel with each other and should have no contact with each other.

10 Mount rear exhaust system with center and end muffler.

11 Mount end muffler in such a manner that clamps of end muffler are approx. 10 mm in front of holders on frame floor (arrow), so that the exhaust system is correctly located for elongation.

Note: The above refers to repair version mufflers only with plug connection between center and end muffler.

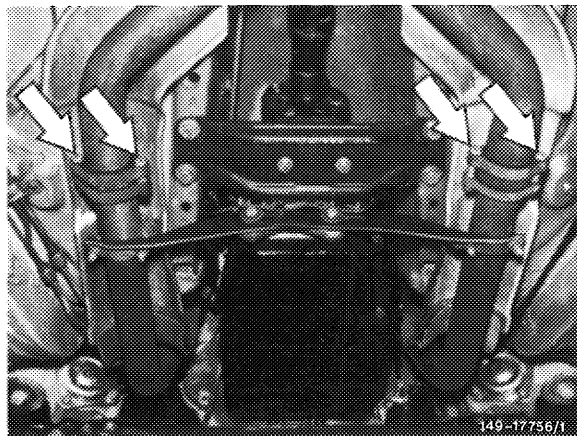
Model 126



12 Uniformly tighten hex. head bolts of flange connection to 20 Nm (arrows).

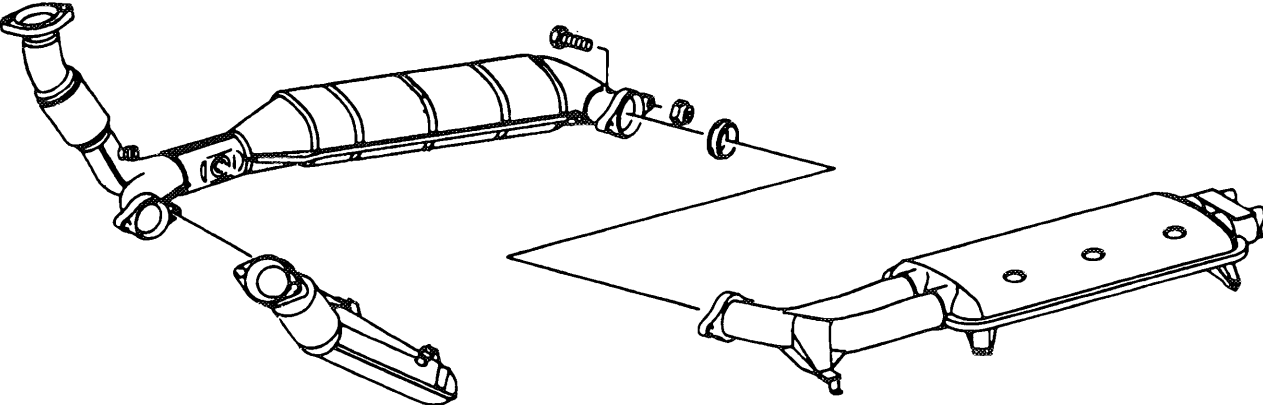
13 Mount exhaust lateral support free of tension. Tightening torque of self-locking hex. nuts on clamp 7 Nm, hex. bolts of lateral support on transmission 20 Nm.

Model 126



14 Run engine and check exhaust system for leaks.

Exhaust system
Model 107.025/045



Exhaust system,
Model 126.032/033/037/043/044

