

**Disassembly and Assembly of Engine
(Individual Removal of Assemblies and Parts)**

Job No.

00-20

A. OM 636

B. OM 621

C. General

Apart from a general overhaul only those assemblies and engine parts are normally removed which have to be repaired or tested. The operations have therefore been subdivided and arranged in such a way that all operations for removal and installation of the assembly or the part in question are given in the respective section.

A. OM 636

If an engine has to be completely stripped, the operations of the sections 1 through 20 have to be carried through.

1. Removal and installation of air filter (see Job No. 09-7).
2. Removal and installation of intake line with throttle duct and exhaust manifold (see Job No. 14-1 and 14-5).
3. Removal and installation of starter motor (see Job No. 15-1).
4. Removal and installation of generator (see Job No. 15-11).
5. Removal and installation of injection lines, vacuum line and fuel main filter (see Job No. 07-15 and 09-1).
6. Removal and installation of cylinder head (see Job No. 01-3).

Disassembly of cylinder head:

- a) Removal and installation of glow plugs (see Job No. 15-31).
 - b) Removal and installation of nozzle holders with nozzles (see Job No. 07-17).
 - c) Removal and installation of prechambers (see Job No. 01-1).
 - d) Removal and installation of valves (see Job No. 05-11).
 - e) Removal and installation of water pump (see Job No. 20-5).
 - f) Removal and installation of cooling water outlet pipe.
7. Removal and installation of oil filter (see Job No. 18-7).
 8. Removal and installation of injection pump and fuel feed pump (see Job No. 07-11).
 9. Removal and installation of fan bracket with pulley and support for fan bracket, if installed (see Job No. 20-15).
 10. Removal and installation of operation hour counter, if installed (see Job No. 01-11).
 11. Removal and installation of revolution counter drive, if installed (see Job No. 01-12).
 12. Removal and installation of injection timing device, if installed (see Job No. 07-25).
 13. Removal and installation of timing gear housing cover (see Job No. 01-15).
 14. Removal and installation of timing gears (see Job No. 05-31).
 15. Removal and installation of oil pressure relief valve (see Job No. 18-3).
 16. Removal and installation of oil pan (see Job No. 01-21).
 17. Removal and installation of oil pump (see Job No. 18-11).

18. Removal and installation of crankshaft and flywheel (see Job No. 03-5).
Disassembly of crankshaft:
 - a) Removal and installation of intermediate piece and crankshaft gear (see Job No. 03-5, section A, item 8).
 - b) Removal and installation of flywheel (see Job No. 03-16).
 - c) Removal and installation of grooved bearing and cap (see Job No. 03-17).
19. Removal and installation of pistons with connecting rods (see Job No. 03-11).
20. Removal and installation of camshaft, camshaft bearings and valve tappets (see Job No. 05-35).

B. OM 621

In an engine has to be completely stripped, the operations of the sections 1 through 20 have to be carried through.

1. Removal and installation of air filter (see Job No. 09-7).
2. Removal and installation of intake line with throttle duct and exhaust manifold (see Job No. 14-1 and 14-5).
3. Removal and installation of starter motor (see Job No. 15-1).
4. Removal and installation of generator (see Job No. 15-11).
5. Removal and installation of water pump with fan (see Job No. 20-5).
6. Removal and installation of injection lines, vacuum line and fuel main filter (see Job No. 07-15 and 09-1).
7. Removal and installation of cylinder head (see Job No. 01-3).
Disassembly of cylinder head:
 - a) Removal and installation of slide vail in cylinder head (see Job No. 05-29).
 - b) Removal and installation of glow plugs (see Job No. 15-31).
 - c) Removal and installation of nozzle holders with nozzles (see Job No. 07-17).
 - d) Removal and installation of prechambers (see Job No. 01-1).
 - e) Removal and installation of camshaft with bearings (see Job No. 05-36).
 - t) Removal and installation of valves (see Job No. 05-11).
 - g) Removal and installation of idler sprocket and idler sprocket bearing (see Job No. 05-23).
 - h) Removal and installation of guide sprocket (see Job No. 05-25).
8. Removal and installation of oil filter (see Job No. 18-7).
9. Removal and installation of injection pump and fuel feed pump (see Job No. 07-11).
10. Removal and installation of oil pump drive (see Job No. 18-16).
11. Removal and installation of injection timing device (see Job No. 07-25).
12. Removal and installation of injection pump drive (intermediate gear shaft) (see Job No. 05-28).
13. Removal and installation of oil pressure relief valve (see Job No. 18-3).
14. Removal and installation of oil pan (see Job No. 01-21).
15. Removal and installation of oil pump (see Job No. 18-11).
16. Removal and installation of crankshaft with flywheel (see Job No. 03-5).
Disassembly of crankshaft:
 - a) Removal and installation of counterweight, seal ring, spacer ring, oil thrower ring, crankshaft gear spacer washer (see Job No. 03-5, section B, item 7).
 - b) Removal and installation of flywheel (see Job No. 03-16).
 - c) Removal and installation of annular grooved bearing and cap (see Job No. 03-17).