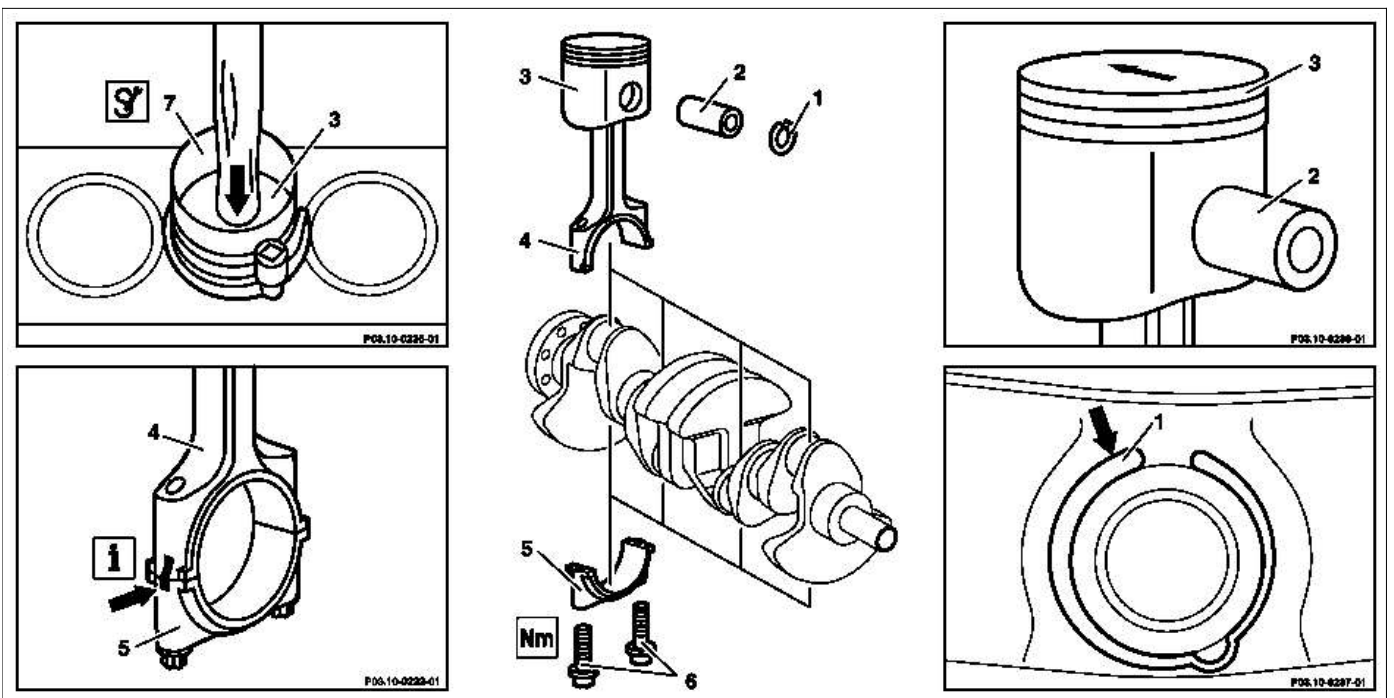


P08.10-0231-09





P08.10-0232-09

Shown on engine 166

1 Circlip

2 Piston pin
3 Piston
4 Connecting rod

5 Connecting rod bearing cap
6 Torx bolts
7  Tensioning strap

	Removing		
1	Remove engine with front axle carrier	Engine 166 Engine 668	AR01.10-P-2500GF AR01.10-P-2500GD
2	Detach engine from front axle carrier	Engine 166 Engine 668	AR01.10-P-2510GF AR01.10-P-2510GD
3	Remove cylinder head	Engine 166 Engine 668	AR01.30-P-5800GF AR01.30-P-5800GD
4	Remove oil pan	Engine 166 Engine 668	AR01.45-P-7500GF AR01.45-P-7500GD
5	Remove oil pump	Engine 166, 668	AR18.10-P-6020GF

6	Take off connecting rod bearing cap (5)	Mark connecting rod (4) and connecting rod bearing cap (5) to each other, pointing to the exhaust side (arrow). Connecting rod (4) and connecting rod bearing cap (5) are cracked	
7	Remove connecting rod (4) together with pistons (3) by lifting up and out	Mark direction of travel on piston (3) opposite power flow with an arrow	
8	Use a screwdriver to press out circlip (1)	Do not damage piston (3); use a clean cloth as a base	
9	Press out piston pin (2) and take piston (3) off the connecting rod (4) Assignment of pistons to cylinder bore Assignment of pistons to cylinder bore	Engine 166.940/960/990/995 Engine 668.940/941/942	AH03.10-P-0001-02GF AH03.10-P-0001-02GD
	Install		
10	Oil piston pin (2) and connecting rod bush		
11	Assemble piston (3) and connecting rod (4)	Assemble piston (3) and connecting rod (4) so that the arrow is pointing in the opposite direction of the power flow. The marking on the connecting rod (4) points toward exhaust side.	
12	Push in piston pin (2) by hand		
13	Insert circlip (1) into the groove (arrow) at the piston		
14	Oil cleaned cylinder bores, connecting rod bearing journals, connecting rod bearing shells and pistons (3)	Install connecting rod bearing shell with oil drilling in the connecting rod (4) otherwise the connecting rod bush will not be lubricated	
15	Fit on tensioning strap (7) for piston rings and tension	Offset piston ring gaps by 120°.	*000589041400
16	Install piston (3) with arrow facing in opposite direction of power flow	The marking on the connecting rod (4) points toward the exhaust side	
17	Check connecting rod bolts	Engine 166.940/960/990/995 Engine 668.940/941/942	AR03.10-P-6111-01GF *BE03.10-P-1001-03E *BE03.10-P-1001-03D
18	Fit on connecting rod bearing cap (5)	Pay attention to marking of connecting rod bearing cap (5) to connecting rod (4) Engine 166 Engine 668	*BA03.10-P-1001-01F *BA03.10-P-1001-01G
19	Rotate crankshaft and inspect clearance		
20	Install oil pump	Engine 166, 668	AR18.10-P-6020GF
21	Installing oil pan	Engine 166 Engine 668	AR01.45-P-7500GF AR01.45-P-7500GD
22	Install cylinder head	Engine 166 Engine 668	AR01.30-P-5800GF AR01.30-P-5800GD
23	Attach engine to front axle carrier	Engine 166 Engine 668	AR01.10-P-2510GF AR01.10-P-2510GD
24	Install engine with front axle carrier	Engine 166 Engine 668	AR01.10-P-2500GF AR01.10-P-2500GD

Test specifications for connecting rod bolts

Number	Designation	Engine 166.940/ 960/990/ 995
BE03.10-P-1001-03E	Connecting rod bolt	
	Thread \varnothing	M 7x1X1
	Shank length	New mm 38 max. mm 38.4

Test specifications for connecting rod bolts

Number	Designation	Engine 668.940/941/942

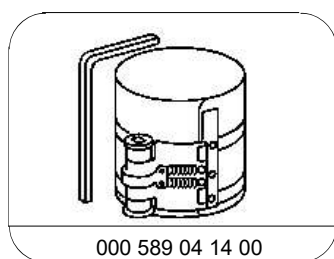
BE03.10-P-1001-03D	Connecting rod bolt	Thread dia.	M	7×1
		Shank length	New	mm 38
			max.	mm 38.4

Nm Connecting rod

Number	Designation	Engine 166.940/ 960/990/ 995
BA03.10-P-1001-01F	Bolt connecting connecting rod cap to connecting rod	Stage 1 Nm 5
		Stage 2 Nm 15
		Stage 3 ° 90

Nm Connecting rod

Number	Designation	Engine 668.940/ 941/942
BA03.10-P-1001-01G	Bolt, connecting rod cap to connecting rod	Stage 1 Nm 5
		Stage 2 Nm 15
		Stage 3 ° 90



Tensioning strap