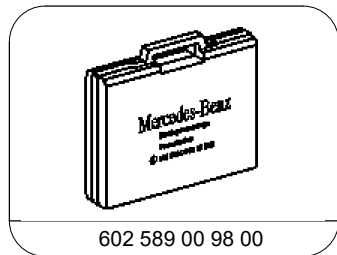


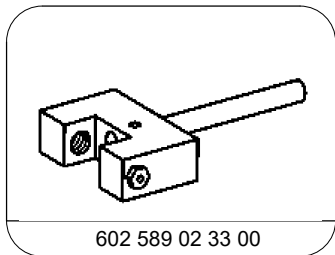
Modification notes

22.9.99	Supersedes SI05/95 dated 14.2.96		
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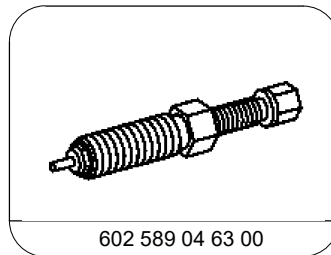
602 589 00 98 00

Case



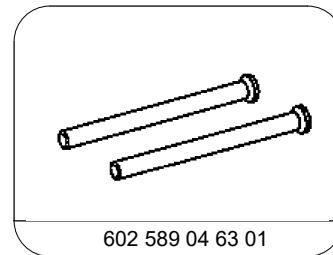
602 589 02 33 00

Chain separating tool



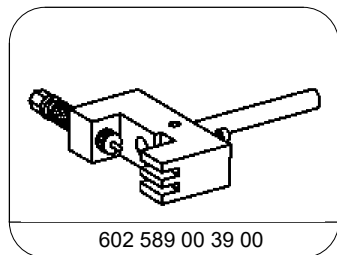
602 589 04 63 00

Thrust spindle



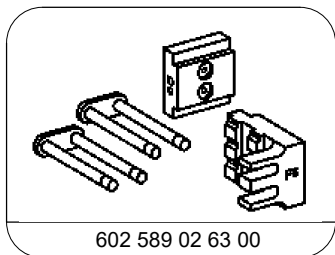
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Thrust pins



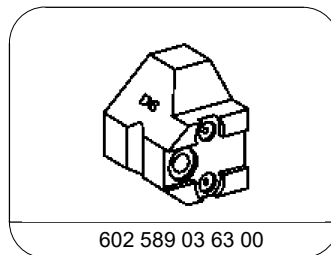
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Riveting tool



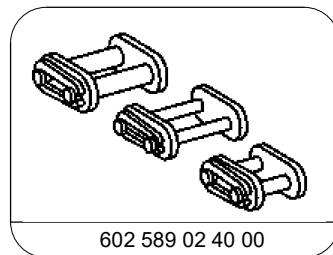
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Assembly inserts



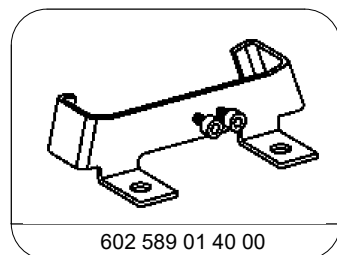
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Thrust piece



602 589 02 40 00

Assembly links

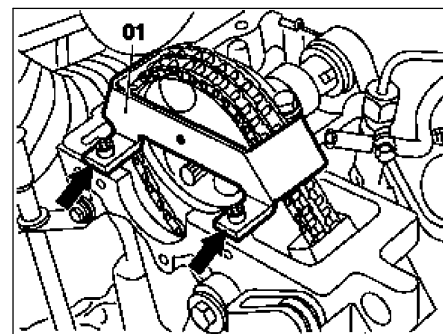


602 589 01 40 00

Holding device

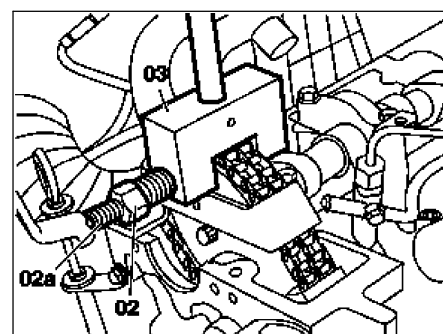
Separating

- 1 Attach holding device 602 589 01 40 00 to cylinder head with screws (supplied).
- 2 Cover over chain housing with a clean cloth.



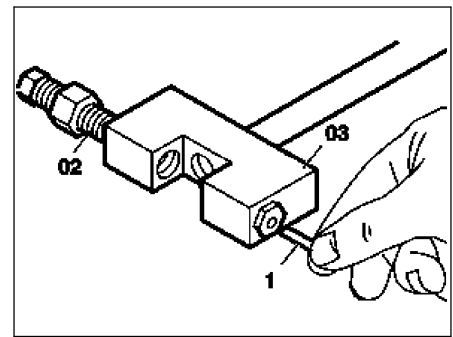
P05.10-0262-01

- 3 Screw thrust spindle (02) 602 589 04 63 00 together with thrust pin 602 589 04 63 01 into chain separating tool (03) 602 589 02 33 00.
- 4 Position chain separating tool (03) against timing chain.
- 5 Screw in thrust spindle (02) sufficiently until thrust pin is positioned against the left (looking in direction of rotation of engine) timing chain pin of a chain link.
- 6 Press out thrust pin of timing chain by screwing in thrust spindle (02a).



P05.10-0263-01

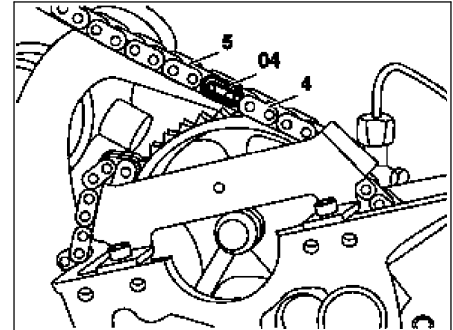
- 7 Unscrew thrust spindle (02), take off chain separating tool (03).
- 8 Pull removed chain pin (1) out of chain separating tool (03).



P05.10-0271-01

Inserting


- 9 Connect new timing chain (5) to the old timing chain (4) with the connecting link (04) 602 589 02 40 00 and secure.
- 10 Rotate engine at crankshaft in direction of rotation of engine and draw in new timing chain (5).
- 11 Remove connecting link (04), take off old timing chain (4).

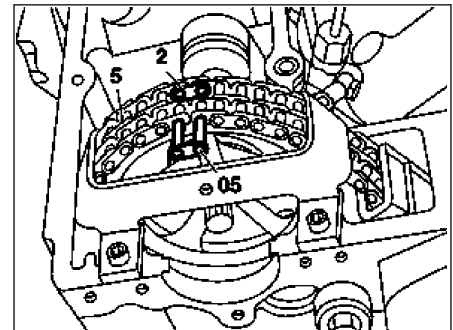


P05.10-0268-01

ⓘ It is essential to remove the connecting link (04). It is only an assembly aid and is not suitable for engine running.

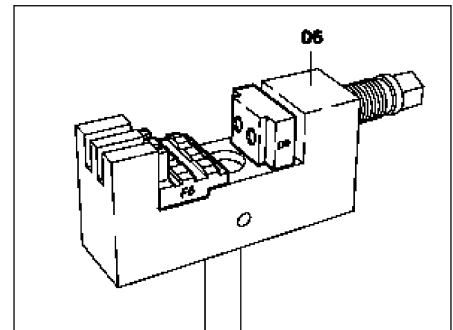
Riveting

- 12 Insert center plate (2) into the timing chain and fix in place with the assembly link  (05).



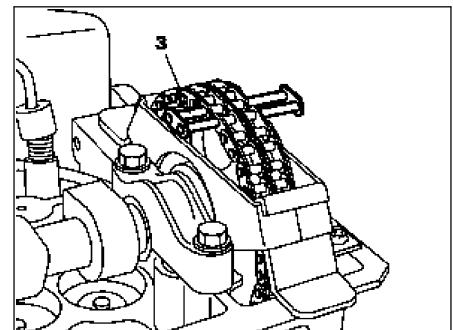
P05.10-0266-01

- 13 Insert assembly inserts (F5 and D9) into riveting tool (06), screw on.



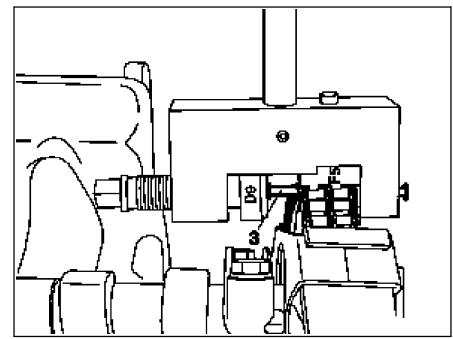
D05.10-0051-01

- 14 Push riveted link (3) into new timing chain.



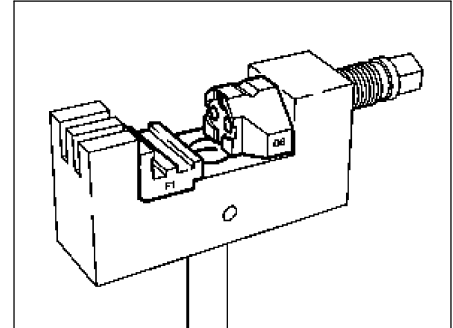
D05.10-0052-01

- 15 Fit riveting tool onto timing chain.
- 16 Turn spindle and press in riveted link (3) as far as the stop.
- 17 Take off riveting tool.



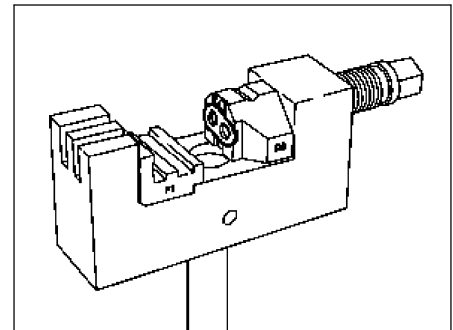
D05.10-0053-01

- 18 Insert riveting inserts (D8) and (F1) into riveting tool (06).



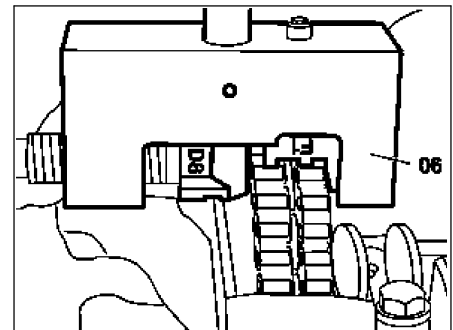
D05.10-0055-01

- 19 Insert outer plate of riveted link into riveting tool (magnetic fixture)



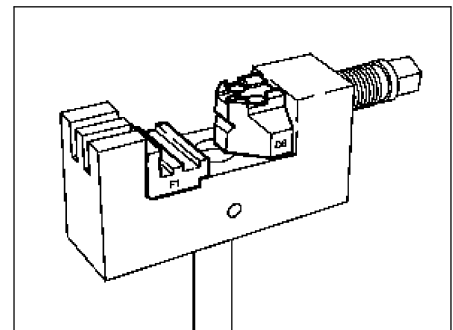
D05.10-0054-01

- 20 Press on outer plate



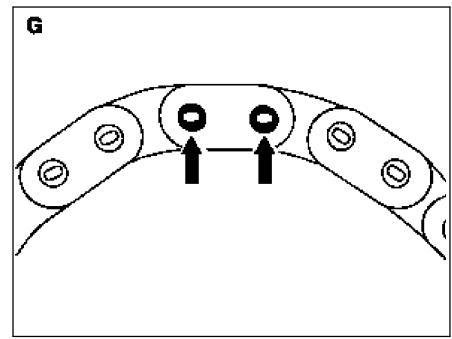
P05.10-0265-01

- 21 Turn over riveting insert (D8)
- 22 Rivet pins of riveted link individually



D05.10-0056-01

23 Inspect riveting (arrows), re-rivet if necessary.



P05.10-0213-01