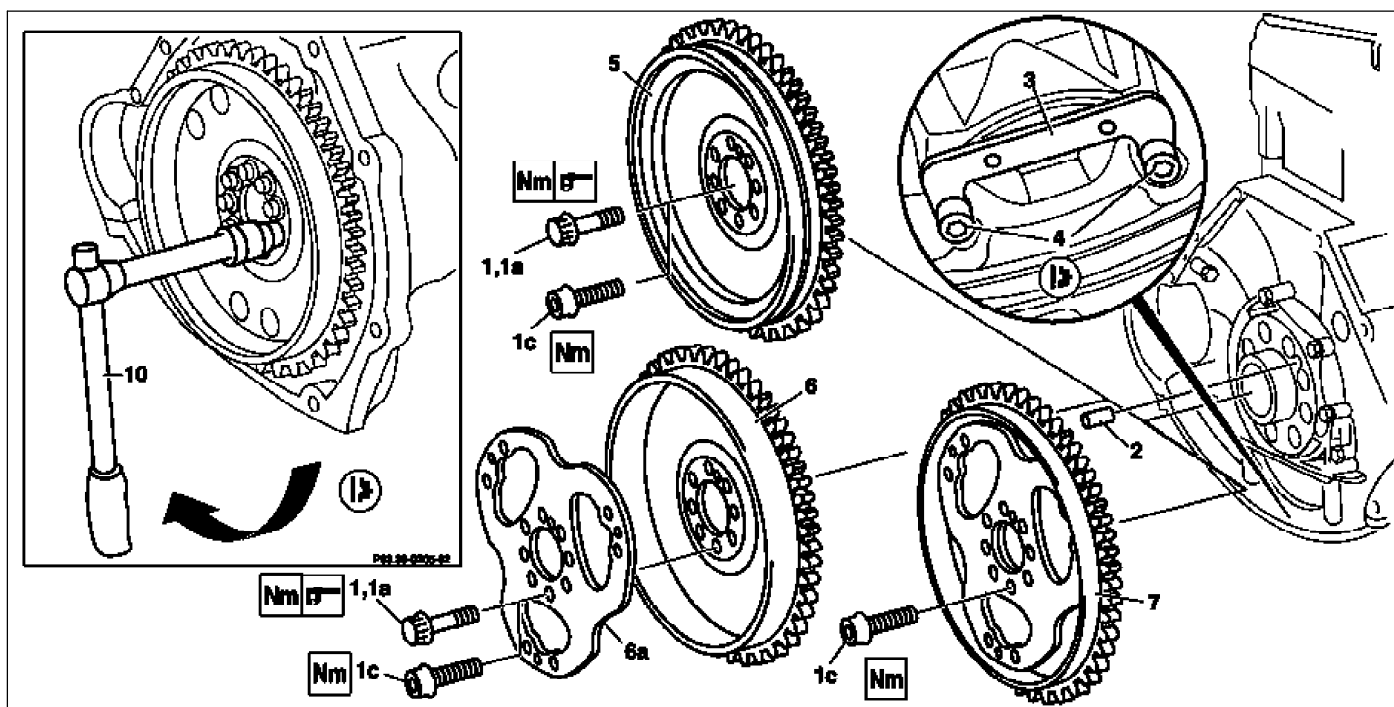


ENGINE 601, 602, 603 (except 602.982)



P03.30-2007-09

☒ ☒	Removing, installing		
1.1	Remove manual transmission		
1.2	Remove automatic transmission		
2.1	Remove clutch	Manual transmission	AR25.10-P-0050A
3	Install retaining lock (3, 4) for crankshaft/ring gear	⚠ Use bolts M6×90 otherwise the threads in the rear end cover will be damaged.	ra03006010500x
4	Unscrew bolts (1, 1a, 1c)	<p>⚠</p> <p>Nm Stretch shank bolts (1)</p> <p>Nm Straight stretch shank bolts (1a)</p> <p>Nm Torx bolts (1c)</p> <p>i Replace torx bolts and straight stretch shank bolts</p> <p>i Installation: If no torquing angle wrench is available, the bolts can be torqued further by the specified angle in a single operation using a wrench and tommy arm (10).</p> <p>⚠ Do not use a flexi-rod torque wrench for tightening to angle degrees in order to avoid any angle errors.</p>	<p>*000589011000</p> <p>*BA03.30-P-1004-01A</p> <p>*BA03.30-P-1005-01A</p> <p>*BA03.30-P-1001-01A</p>
5.1	Inspect bolts (stretch shank bolts) (1) for flywheel/ driven plate	<p>⚠</p> <p>⚠ If the minimum stretch shank \varnothing is achieved, replace stretch shank bolts</p>	*BE03.30-P-1001-01C
6	Take off flywheel (5), two-mass flywheel or flywheel (6) with driven plate (6a), or starter ring gear (7)	<p>Straight pin (2) centers flywheel and driven plate.</p> <p>i Flywheels do not need to be balanced and must not be interchanged.</p>	
7	Install in the reverse order		

Inspection data bolts for flywheel/driven plate

Number	Designation	Engine 601,602 except 602.98, 603 with two-mass flywheel	Engine 601, 602 except 602.98, 603 manual and automatic transmission driven plate 1st version

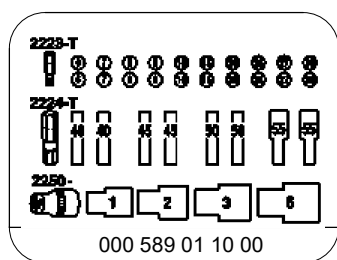
BE03.30-P-1001-01C	Flywheel or driven plate bolts (1st version)	Thread Ø (D)	M	10×1	10×1
		Stretch shank Ø (d)	when new	mm	8.3-8.5
			min	mm	8.1
		Length of shank (L)	when new	mm	56.8-57.2
			max.	mm	-
			Part no.		103 032 00 71
					102 032 00 71

Inspection data bolts for flywheel/driven plate

Number	Designation	Engine 601, 602 except 602.98, 603 automatic transmission driven plate 2nd version			
BE03.30-P-1001-01C	Flywheel or driven plate bolts (1st version)	Thread Ø (D)	M	10×1	
		Stretch shank Ø (d)	when new	mm	8.3-8.5
			min	mm	8.0
		Length of shank (L)	when new	mm	25.8-26.2
			max.	mm	26.5
			Part no.		601 032 01 71

Flywheel, driven plate, vibration damper, starter ring gear

Number	Designation	Engine 601, 602, 603 with/without automatic transmission			
BA03.30-P-1001-01A	Central bolt of vibration damper	8.8	1st stage	Nm	200
			2nd stage	∠ °	90
		10.9	1st stage	Nm	320
			2nd stage	∠ °	-
BA03.30-P-1004-01A	Stretch shank bolt for flywheel to crankshaft		1st stage	Nm	35
			2nd stage	∠ °	90
BA03.30-P-1005-01A	Straight stretch shank bolt for flywheel or two-mass flywheel to crankshaft		1st stage	Nm	45
			2nd stage	∠ °	90



Torx bit set

