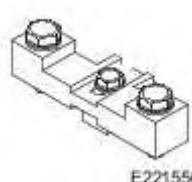
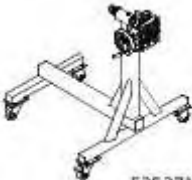
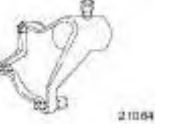
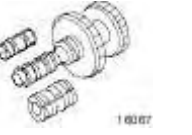


Installation

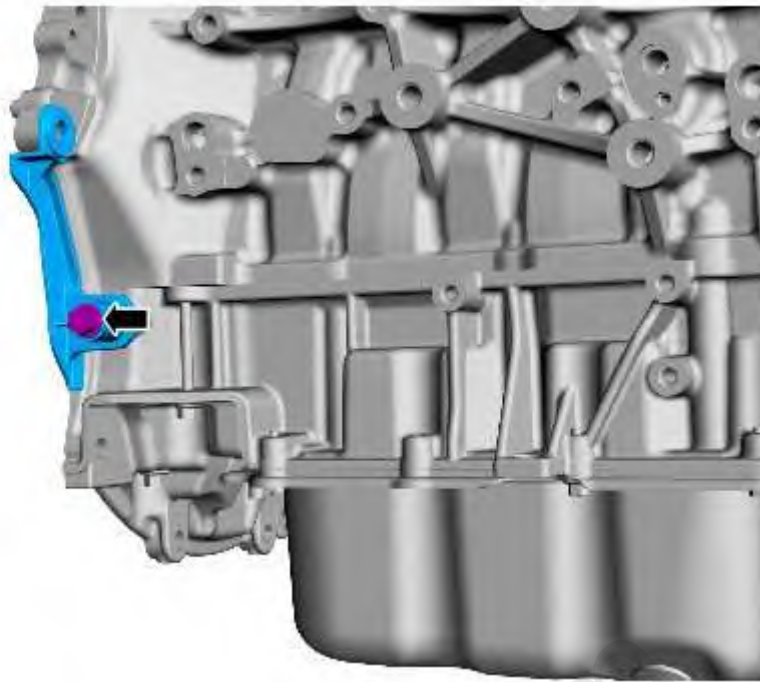
Special Tool(s) / General Equipment

 E221552	303-1635 Remover/Installer, Fuel Injection Pump
 E221556	303-1643 Locking Tool, Flywheel
 E252718	303-435 Mounting Stand
 211084	303-435-04 Mounting Bracket for 303-435
 E229951	303-435-12C Mounting Plate
 1 03 07	308-204 Aligner, Clutch Disc
Floor Crane	
Hose Clamp Remover/Installer	
Lifting Bracket	
Long Nose Pliers	

Materials

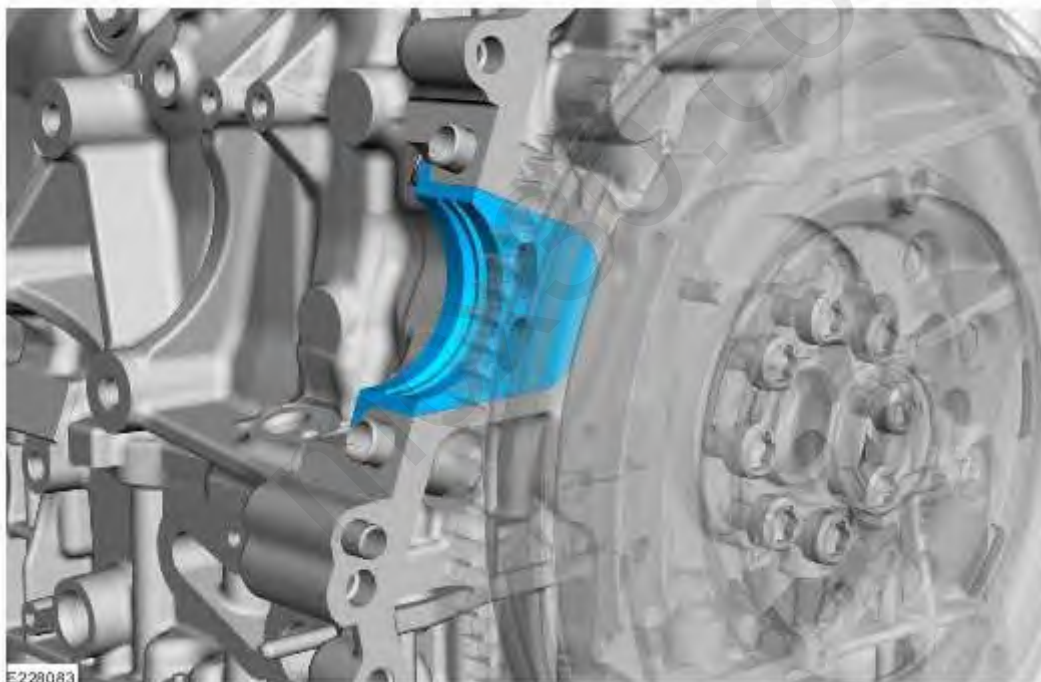
Name	Specification
Grease	WSD-M1C227-A

1. Torque: 40 Nm



E228084

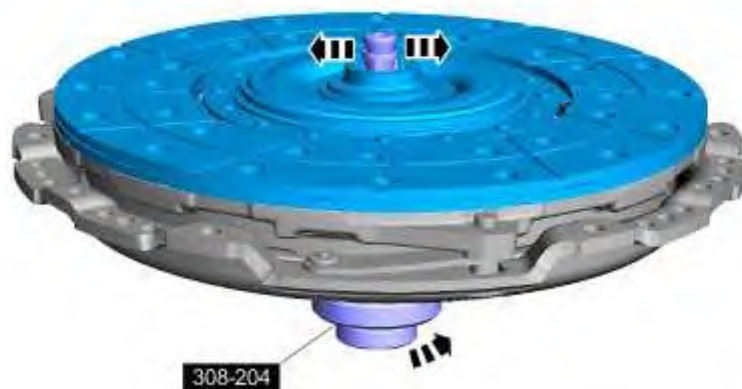
2.



E228083

3.  **NOTICE:** The cone on the special tool must only be tightened finger tight to prevent damage to the clutch disc.

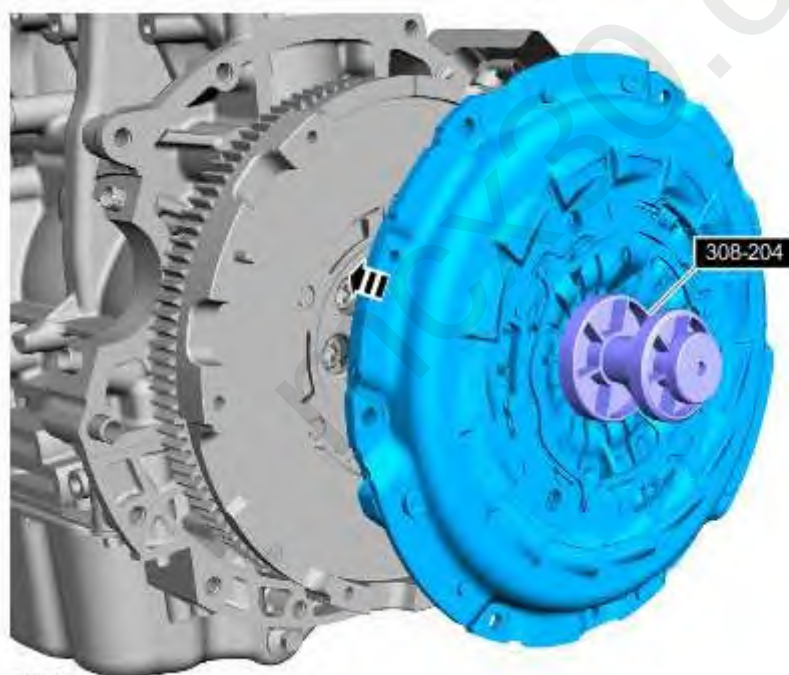
Use Special Service Tool: [308-204](#).



E176070

4. **NOTE:** Make sure that the components are installed to the position noted before removal.

Use *Special Service Tool*: [308-204](#).

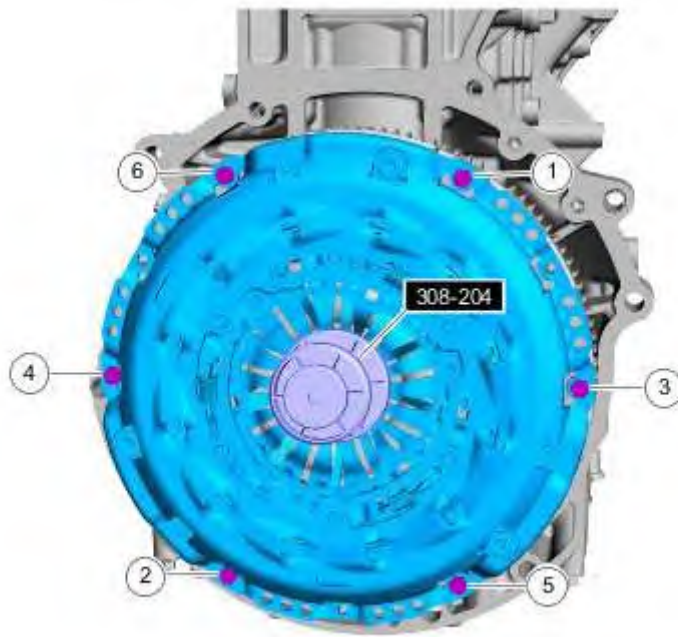


E176071

5. **NOTE:** Make sure that new bolts are installed.
NOTE: Only tighten the bolts finger tight at this stage.

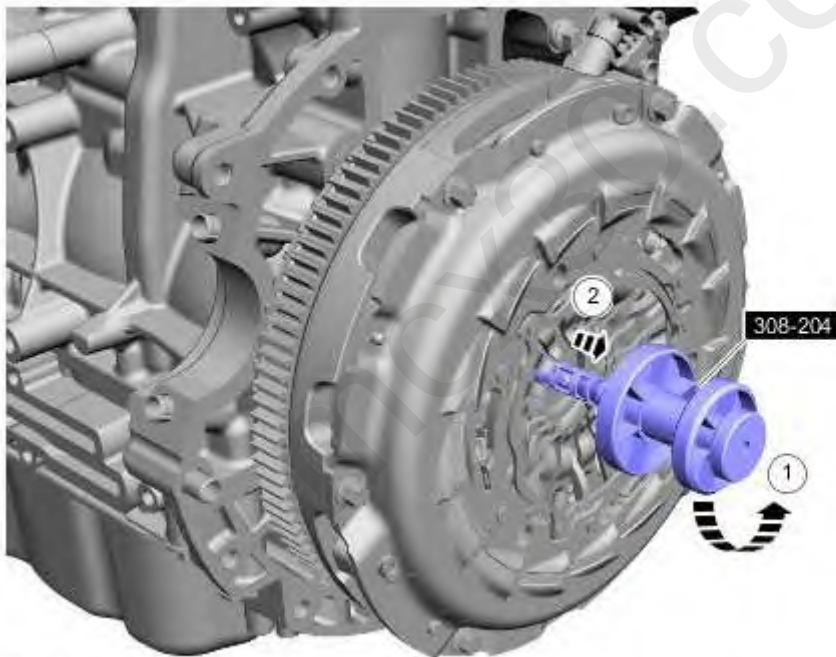
Use *Special Service Tool*: [308-204](#).

Torque: 30 Nm



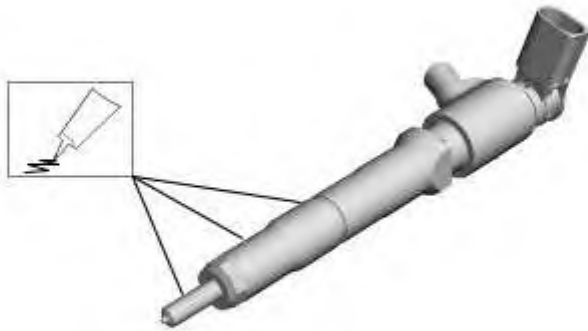
E175738

6. Remove Special Service Tool: 308-204.



E176072

7.  **NOTICE:** To avoid corrosion, lubricate the injector bodies prior to installation.
Material: WSD-M1C227-A (Grease)



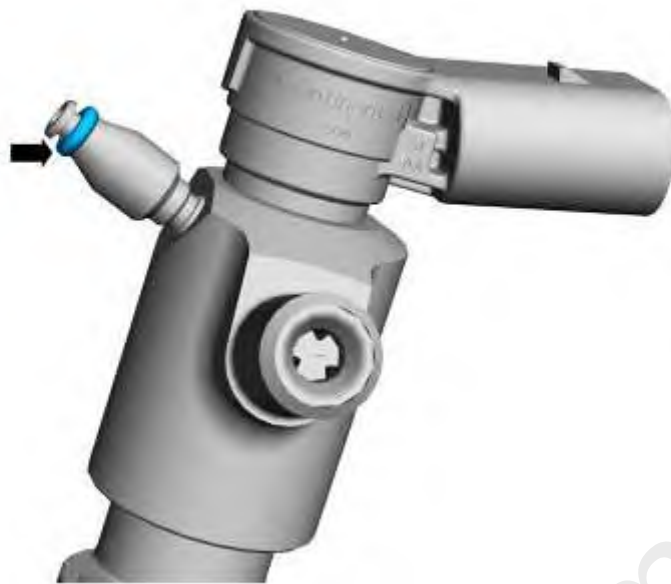
E262905

8. **NOTE:** Use a new seal.
NOTE: This step is only necessary if the original component is to be reused.
Use the General Equipment: [Long Nose Pliers](#)



E230755

9. **NOTE:** The O-ring seal is to be reused unless damaged.
Material: [WSD-M1C227-A \(Grease\)](#)



E252327

10. NOTE: Make sure that new bolts are installed.
NOTE: Make sure that the components are installed to the position noted before removal.

Make sure that new clamps are installed.

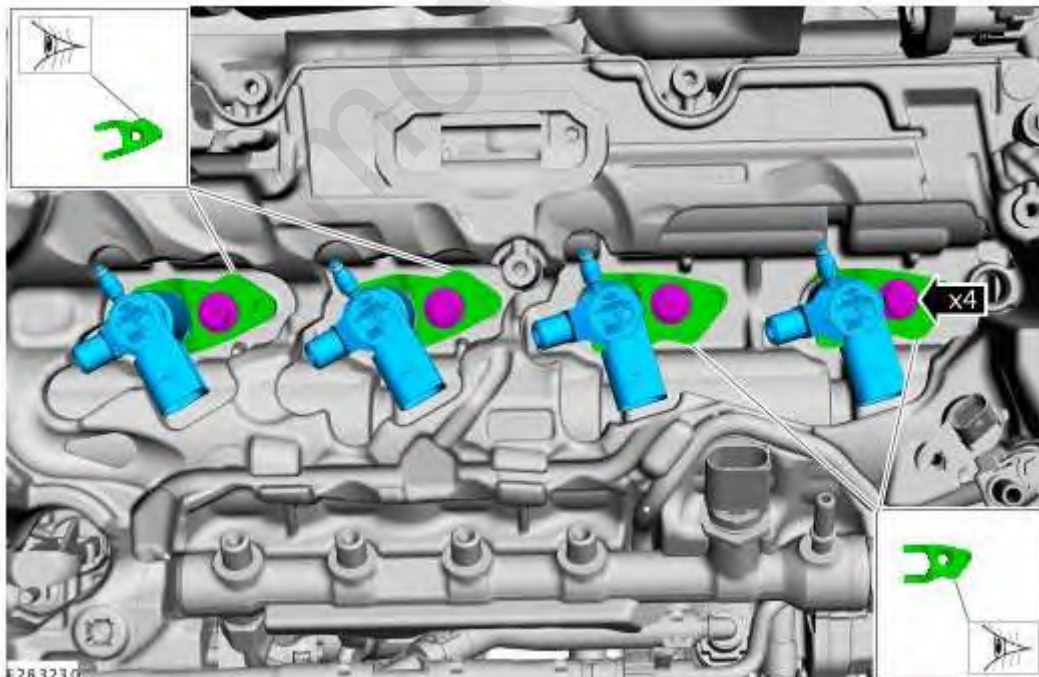
Torque:

Stage 1: 9 Nm

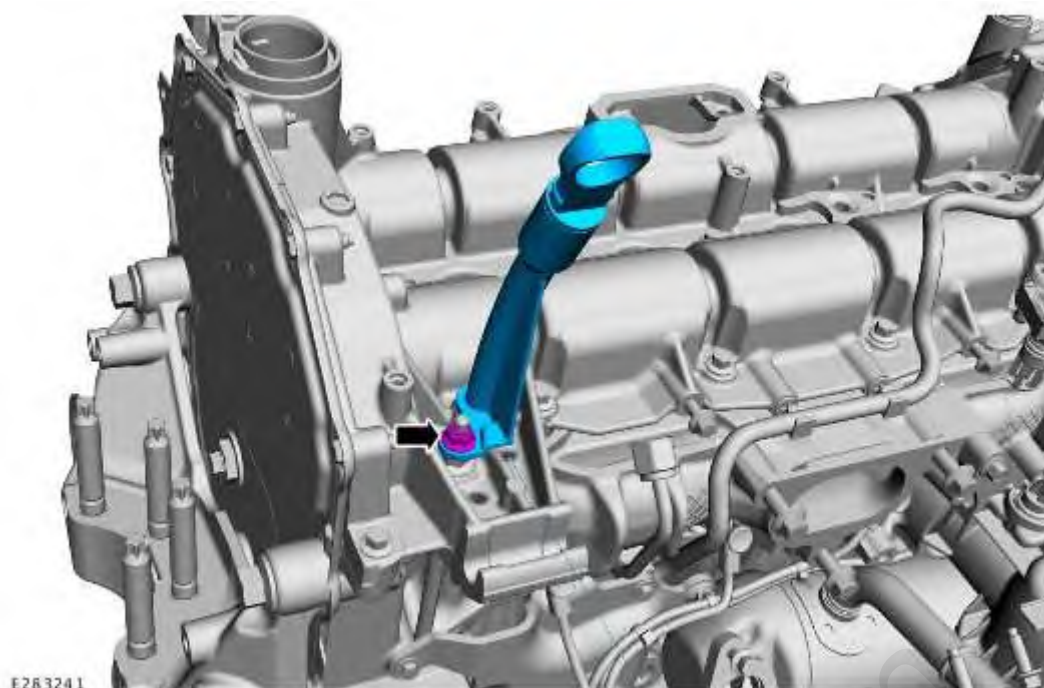
Stage 2: Loosen: 45°

Stage 3: 6 Nm

Stage 4: 180°



11. *Torque:* 10 Nm

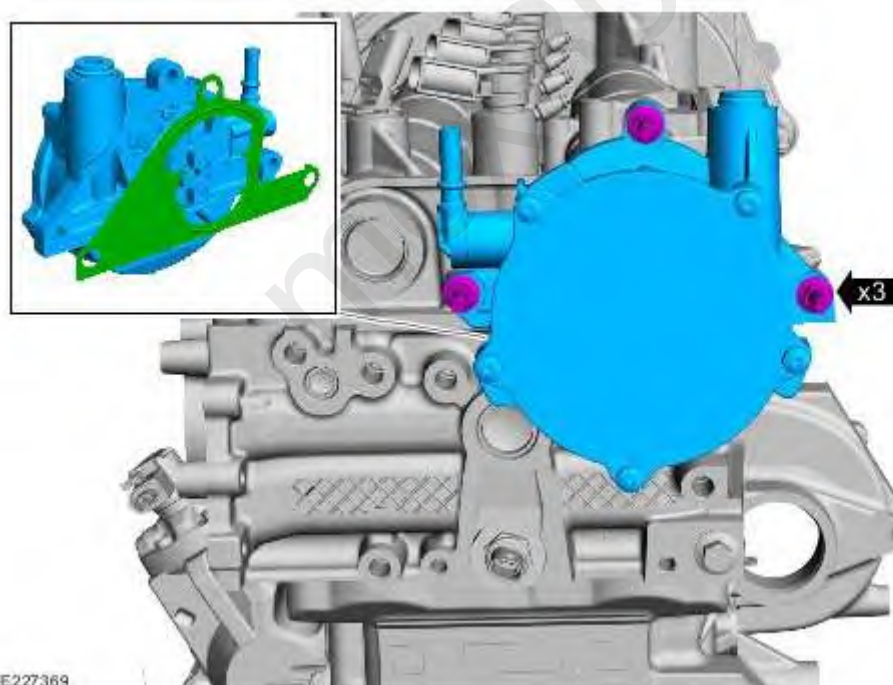


12. **NOTE:** Use a new seal.
NOTE: Make sure that the components are installed to the position noted before removal.

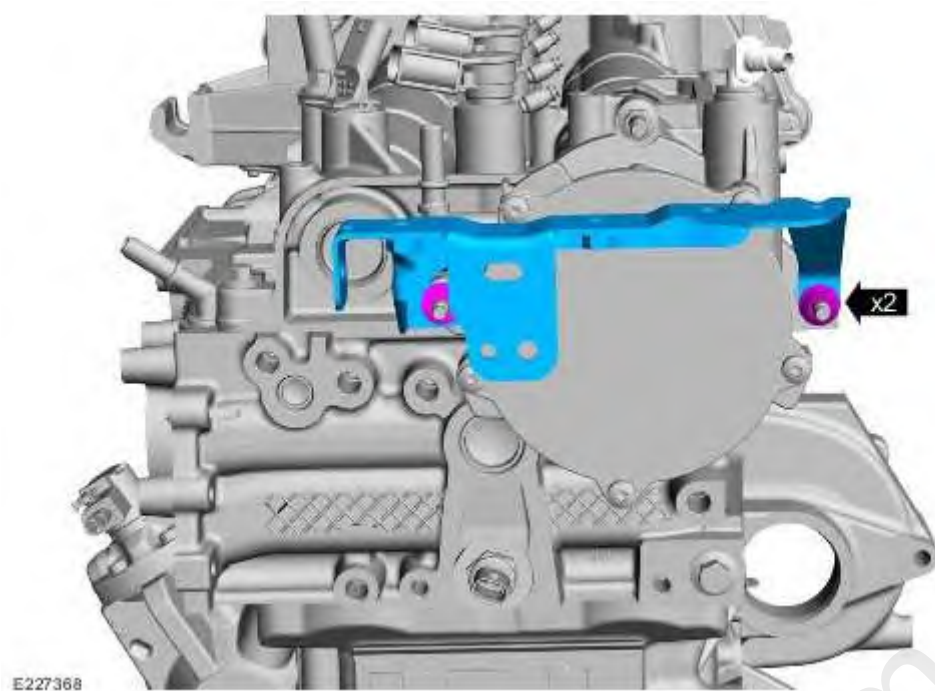
Torque:

Stage 1: 5 Nm

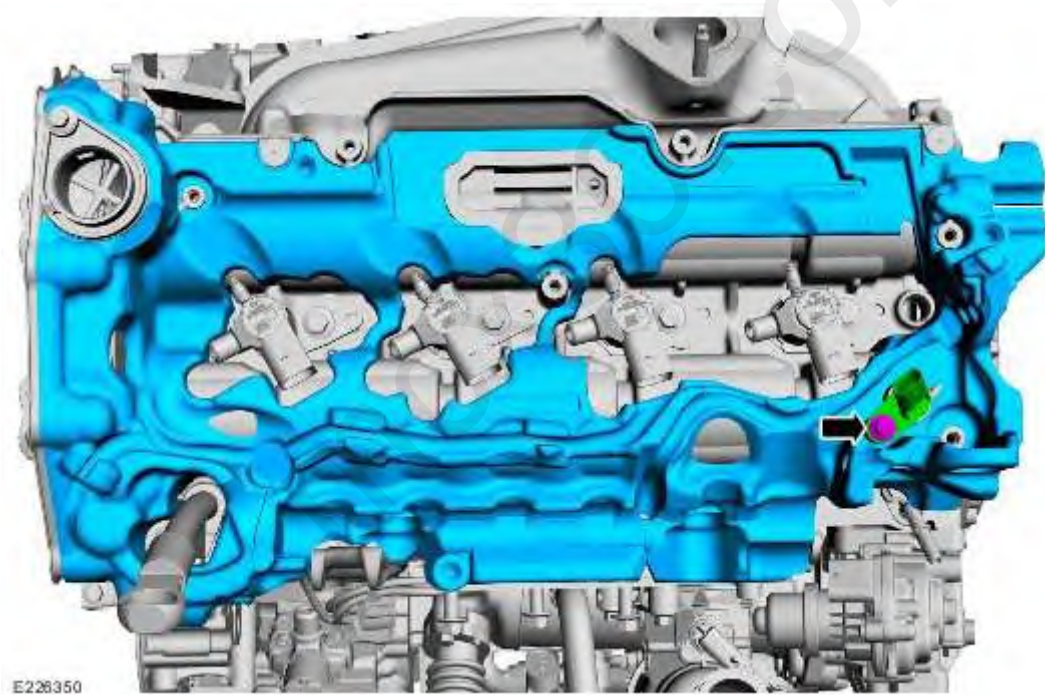
Stage 2: 10 Nm



13. *Torque:* 10 Nm



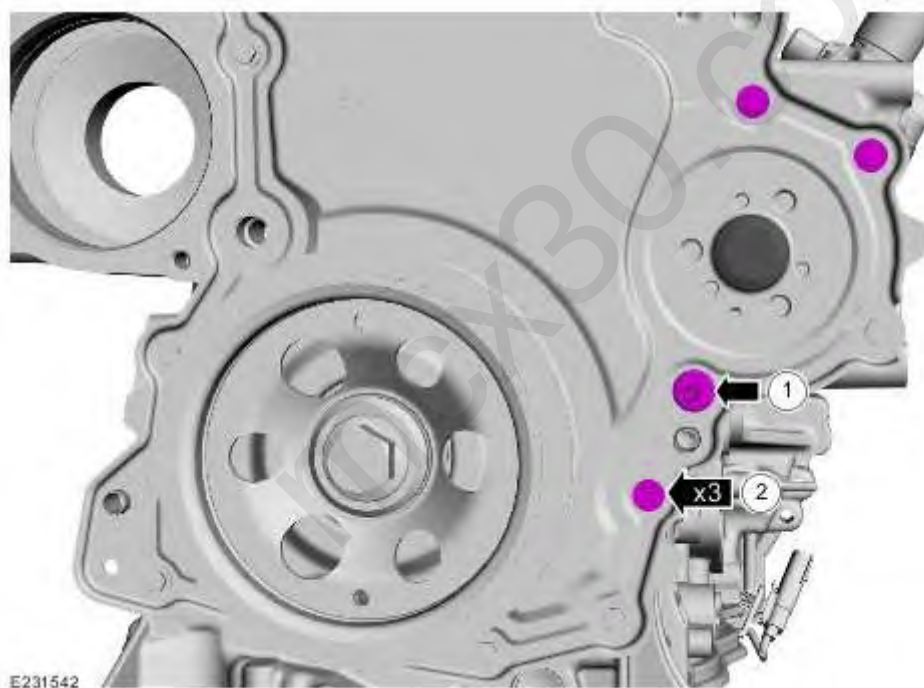
14.



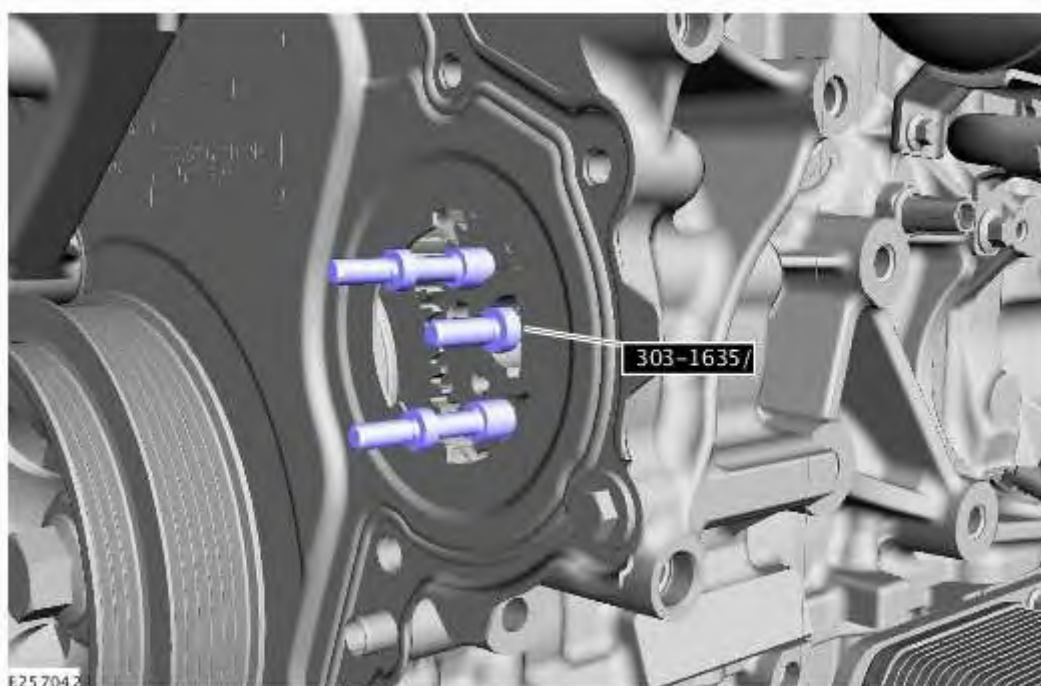
15.



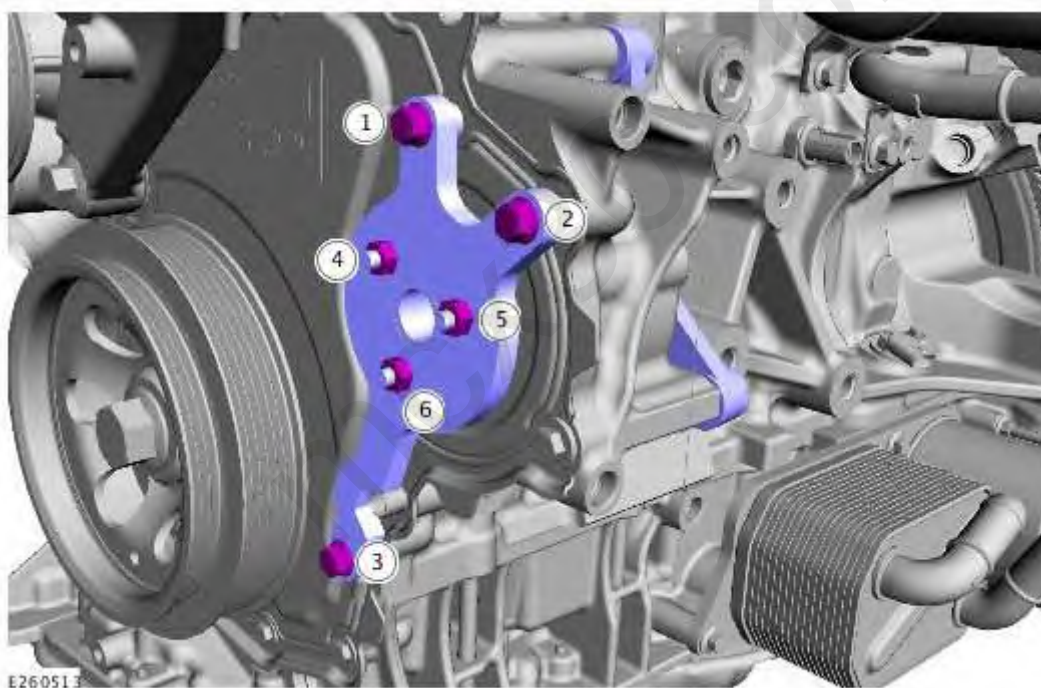
16.



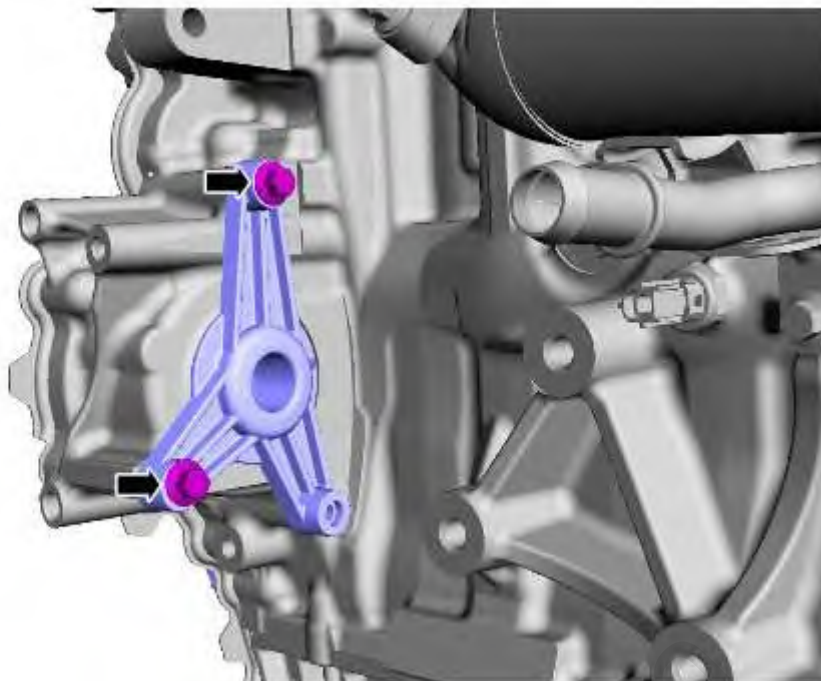
17. Install Special Service Tool: [303-1635](#).



18.



19.



E260514

20. NOTICE:



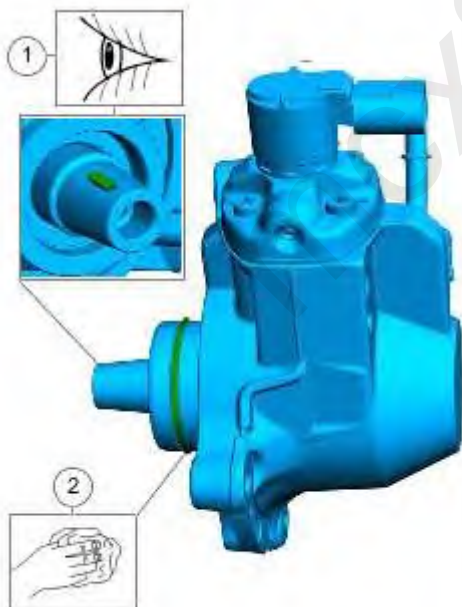
Extreme cleanliness must be exercised when handling the component.



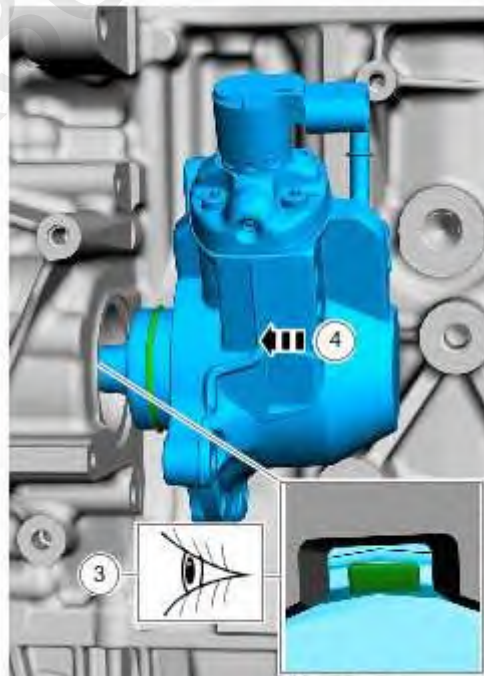
Use lint free cloth.

NOTE: Make sure that the seal is correctly located.

NOTE: The component must be installed by hand before final tightening.

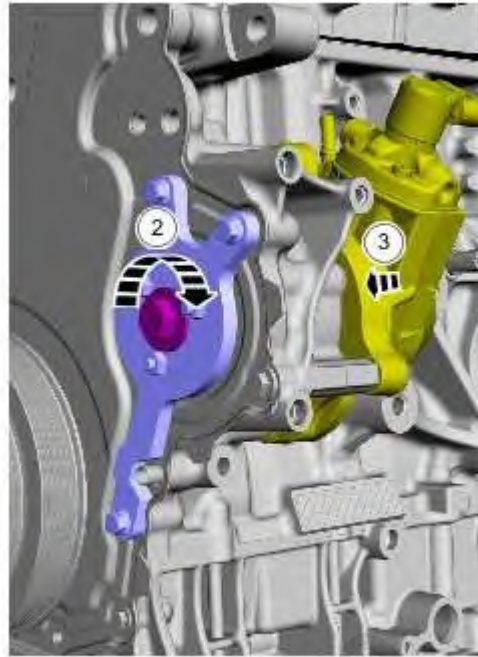
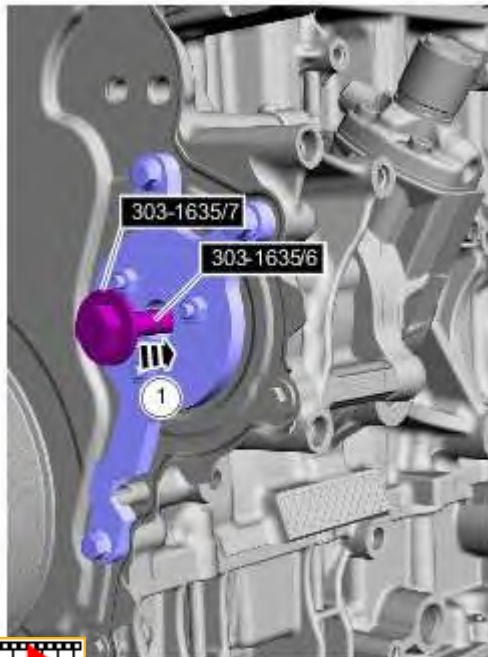


E228872



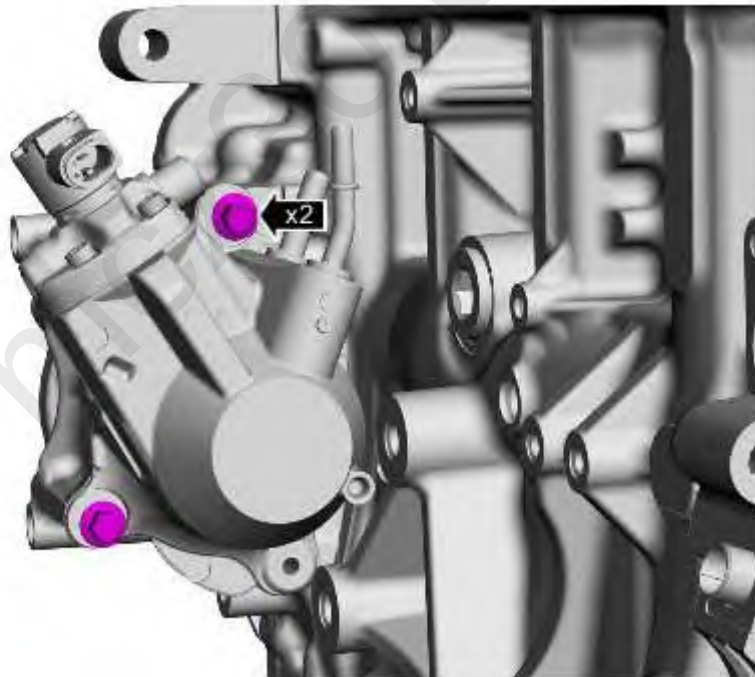
21. NOTE: Only use moderate force.

Install Special Service Tool: [303-1635](#).



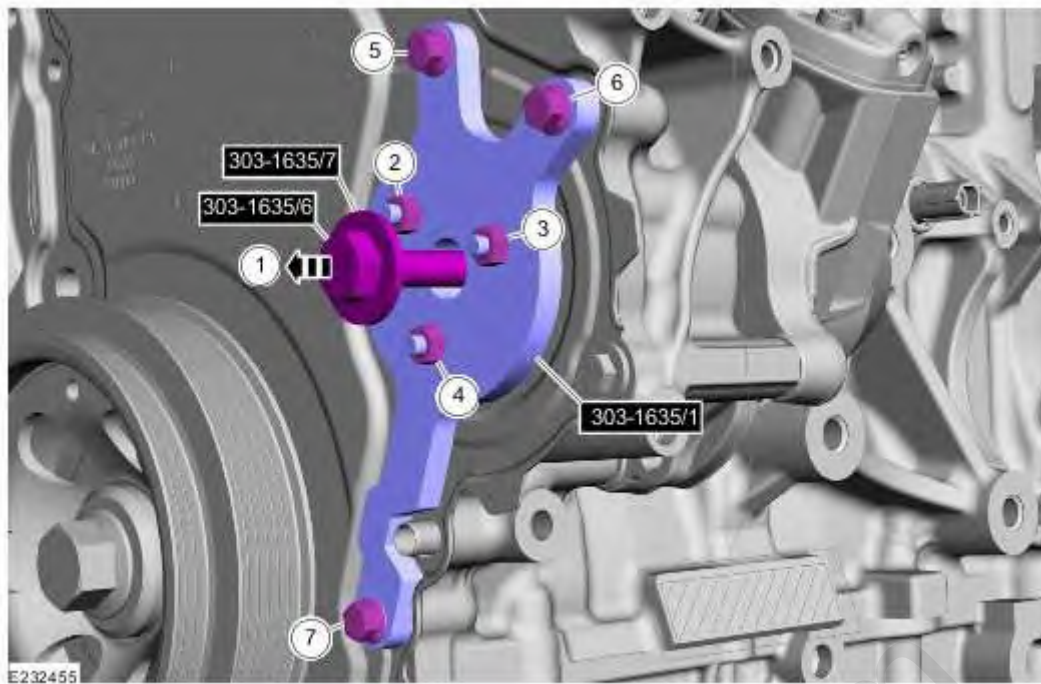
22. NOTE: Make sure that new bolts are installed.

Torque: 23 Nm

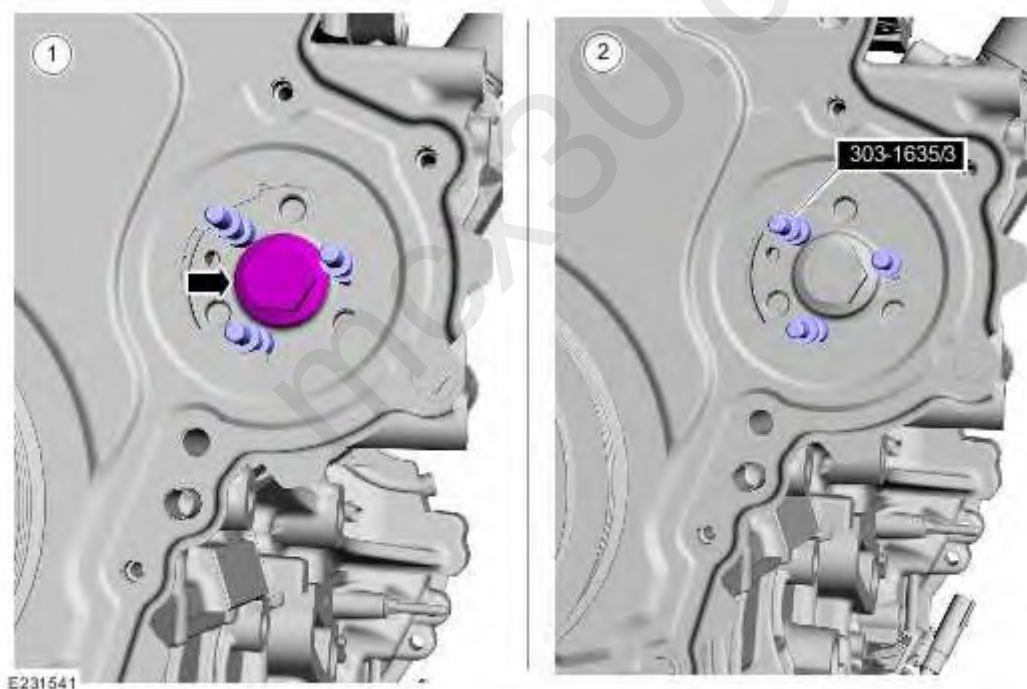


E2280a1

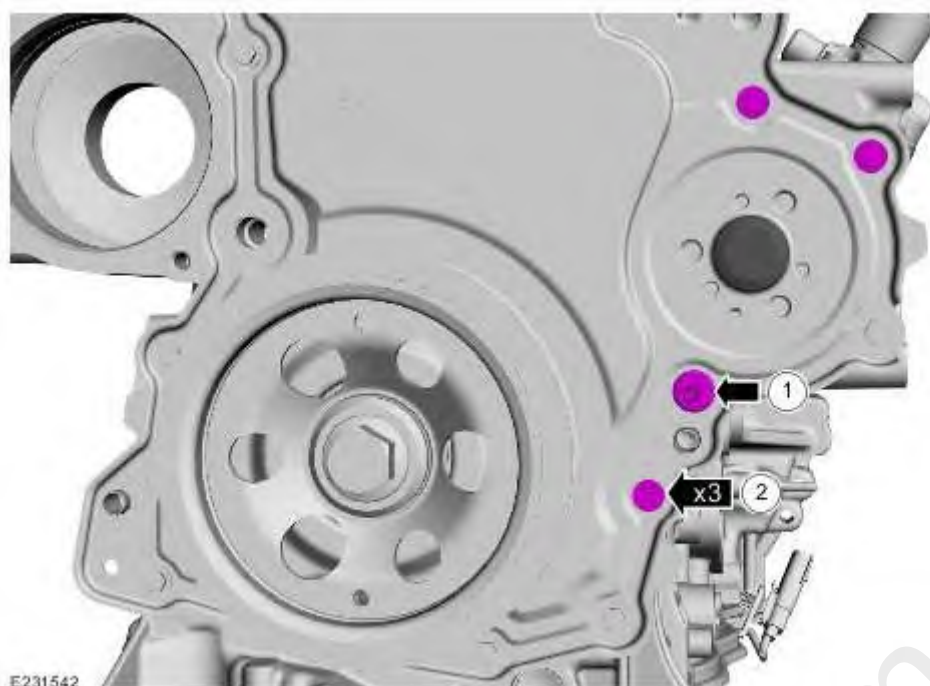
23. Remove Special Service Tool: 303-1635.



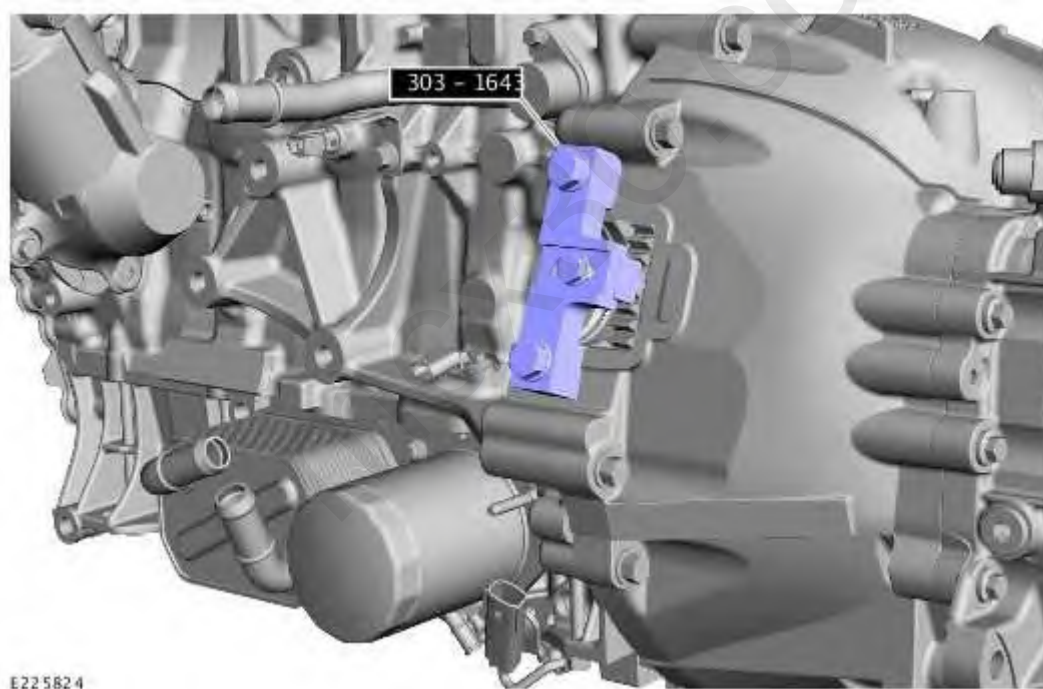
24. NOTE: Make sure a new bolt is installed.
 NOTE: Only tighten the bolt finger tight at this stage.
 Remove Special Service Tool: 303-1635.



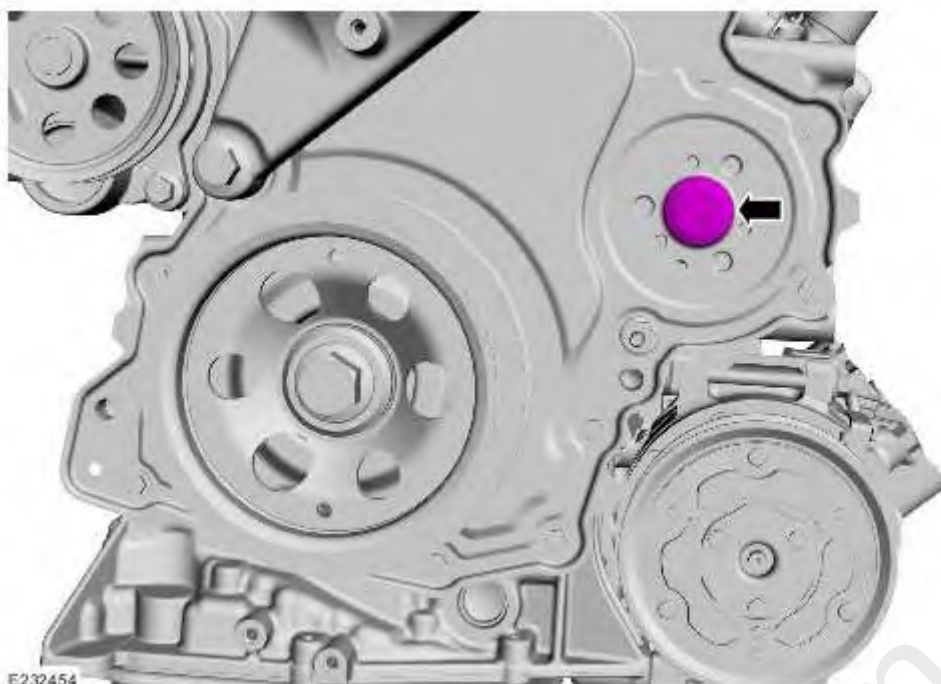
25. Torque:
- 1:
 - Stage 1: 5 Nm
 - Stage 2: 18 Nm
 - 2:
 - Stage 1: 5 Nm
 - Stage 2: 10 Nm



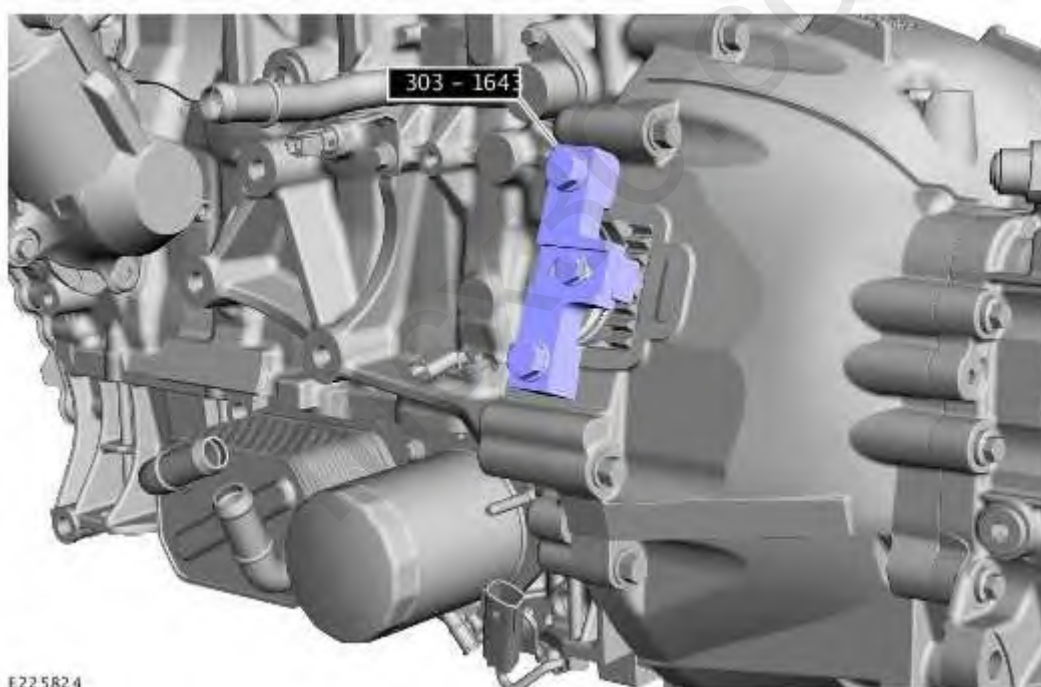
26. Install Special Service Tool: [303-1643](#).



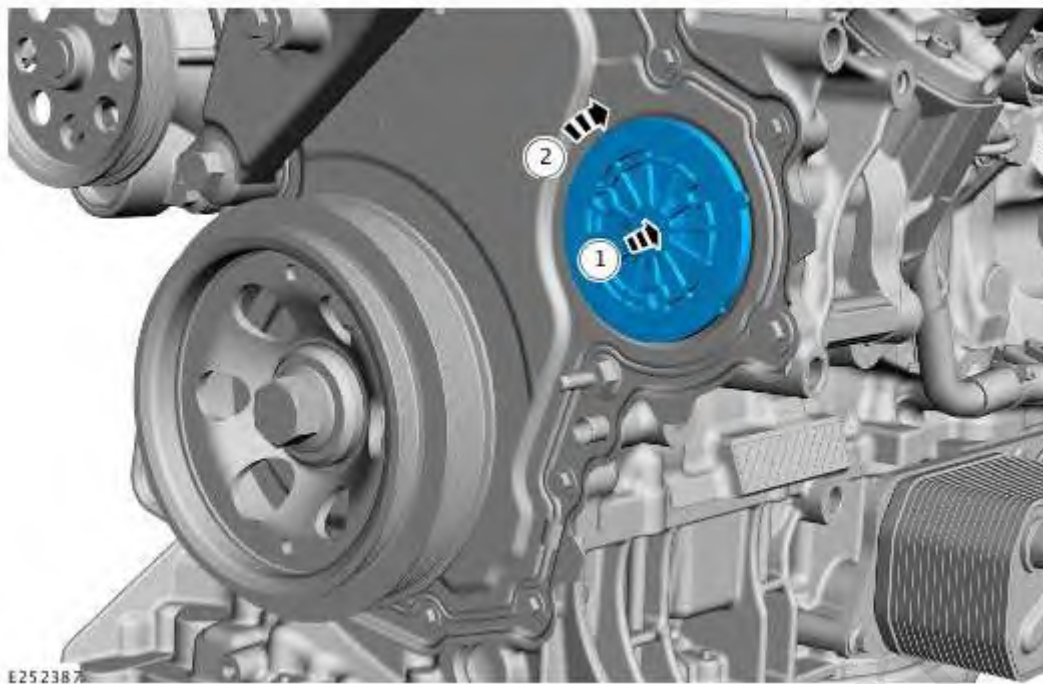
27. Torque:
 Stage 1: 25 Nm
 Stage 2: 75 Nm



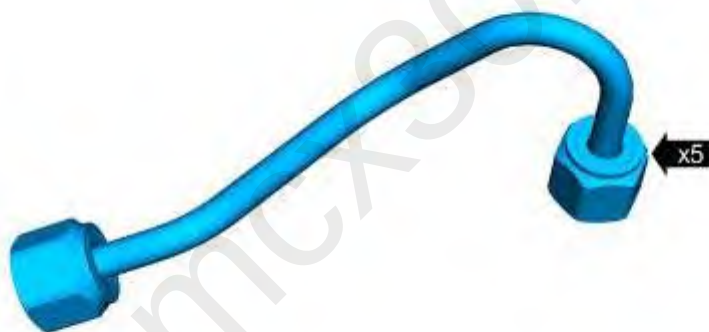
28. Remove Special Service Tool: 303-1643.



29.



30. NOTE: Make sure that new components are installed.



31.  NOTICE: Make sure that the area around the component is clean and free of foreign material.

NOTE: Only tighten the nuts and bolts finger tight at this stage.

Torque:

1:

Stage 1: 12 Nm

Stage 2: 16 Nm

Stage 3: 50°

2: 13 Nm

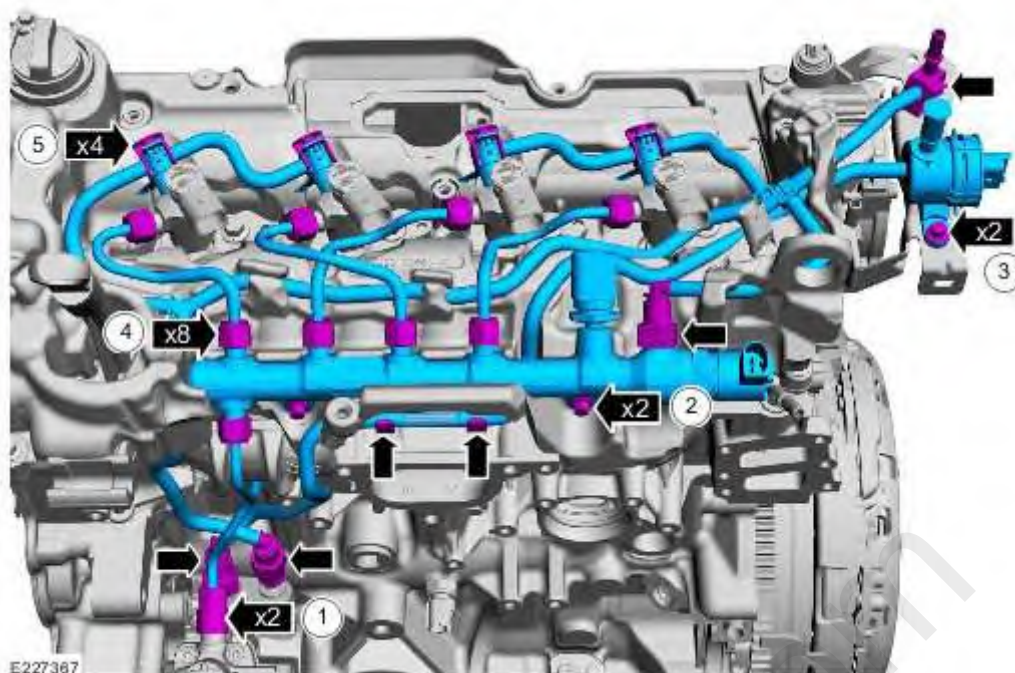
3: 10 Nm

4:

Stage 1: 12 Nm

Stage 2: 16 Nm

Stage 3: 50°

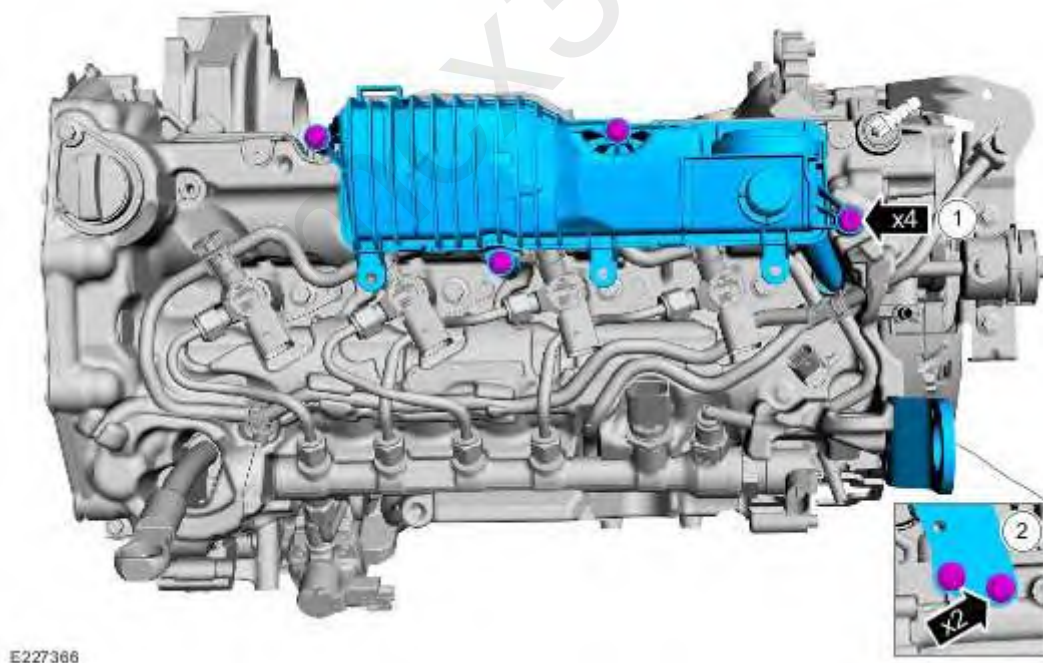


32. NOTE: Only tighten the bolts finger tight at this stage.

Torque:

1: 10 Nm

2: 33 Nm



33.  NOTICE: Make sure that the gasket is correctly located.

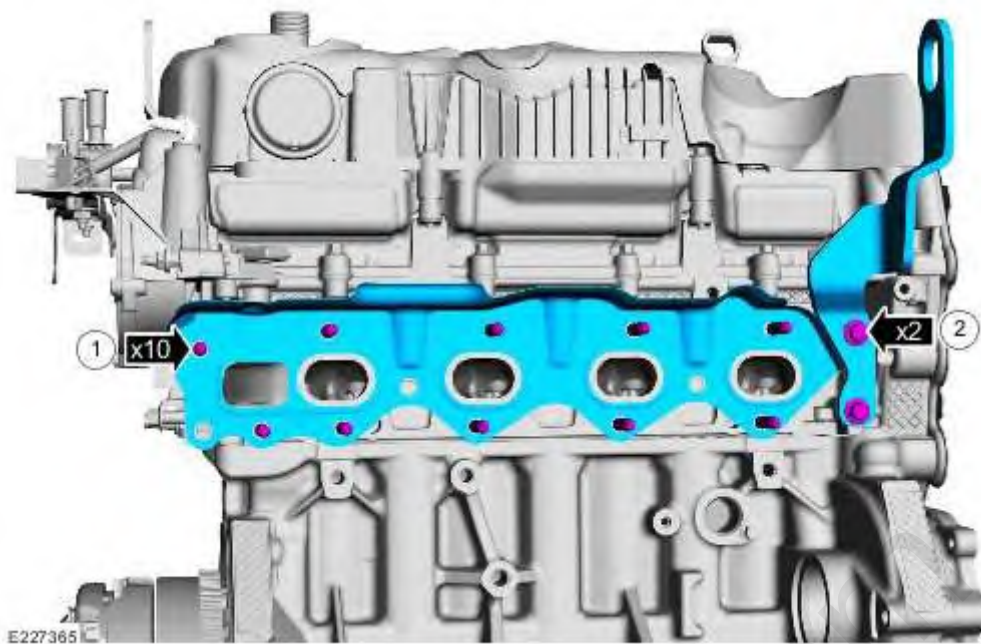
NOTE: Use a new seal.

NOTE: Only tighten the bolts finger tight at this stage.

Torque:

1: 10 Nm

2: 33 Nm



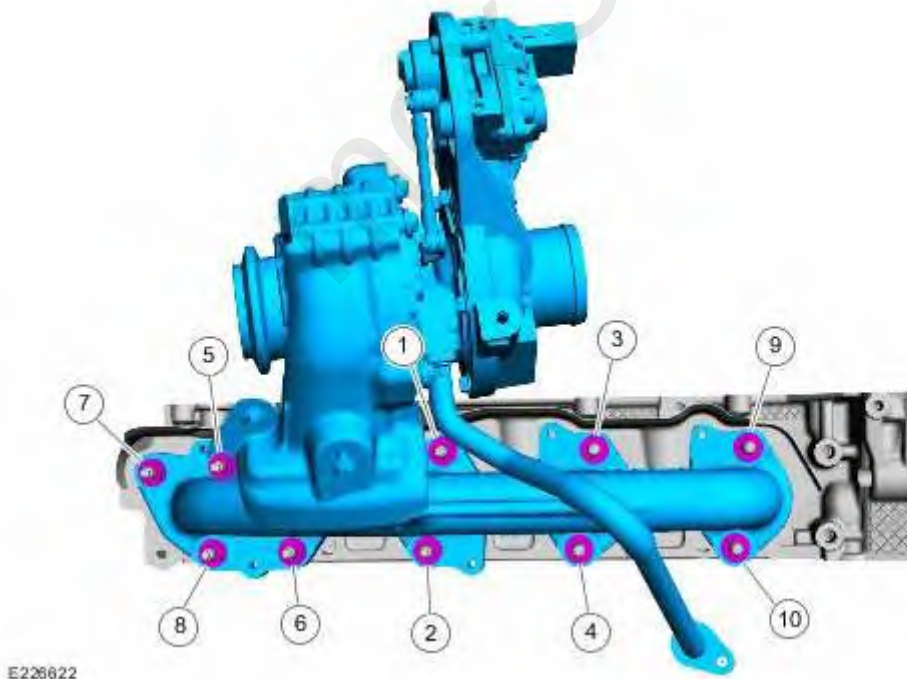
34. NOTE: Make sure that the component is correctly installed.
NOTE: Only tighten the nuts finger tight at this stage.

Torque:

Stage 1: 12 Nm

Stage 2: 23 Nm

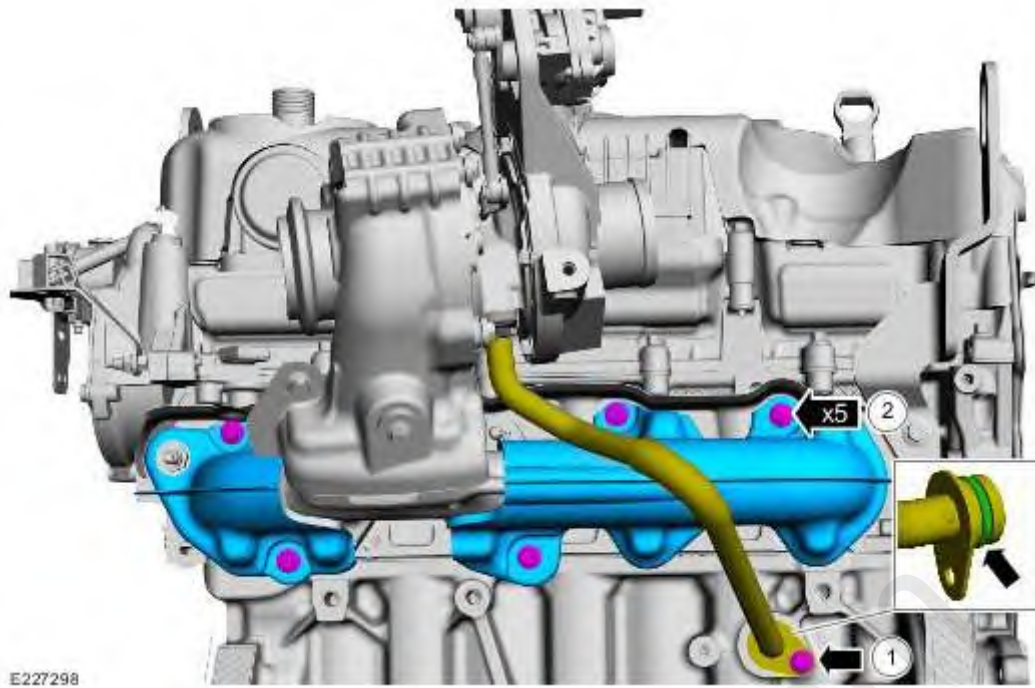
Stage 3: 23 Nm



35. NOTE: Only tighten the bolts finger tight at this stage.
NOTE: Make sure that a new O-ring seal is installed.

1. *Torque:* 10 Nm

2. Torque: 10 Nm

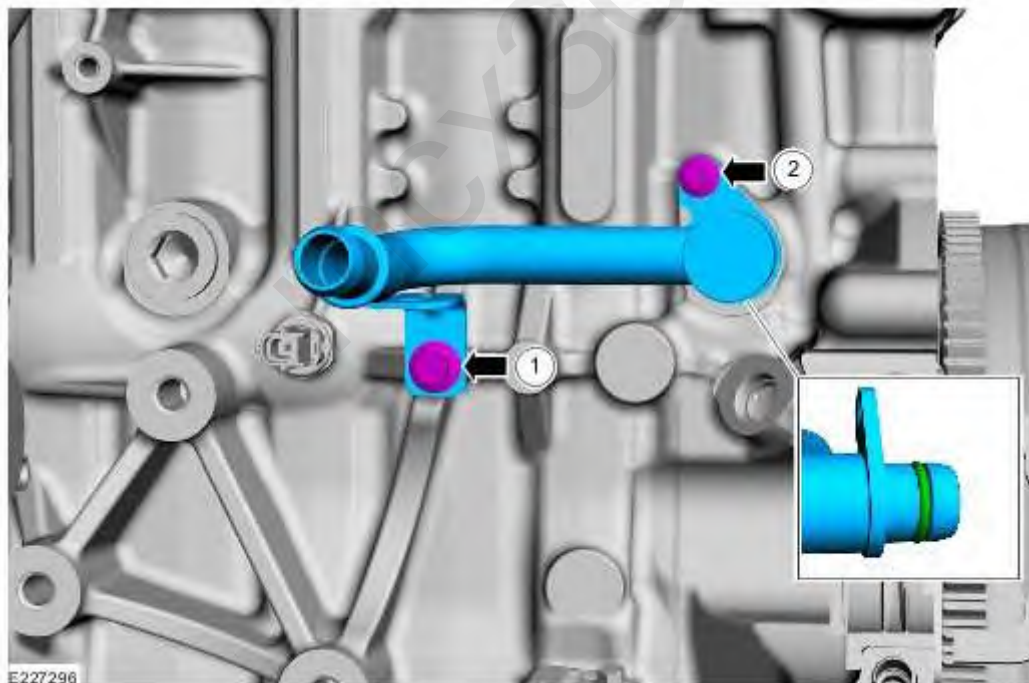


36. NOTE: Only tighten the bolts finger tight at this stage.

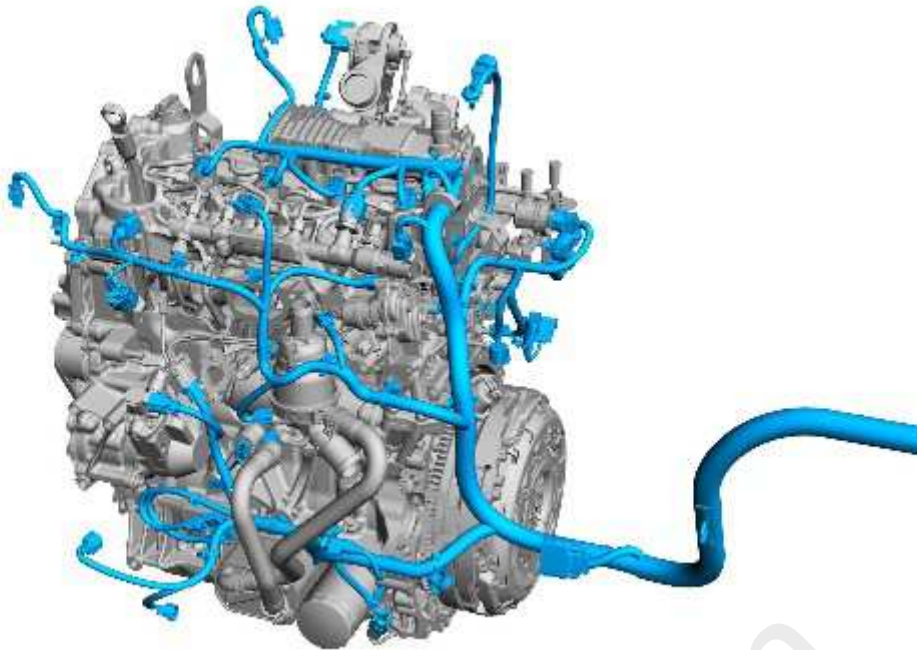
Torque:

1: 23 Nm

2: 10 Nm

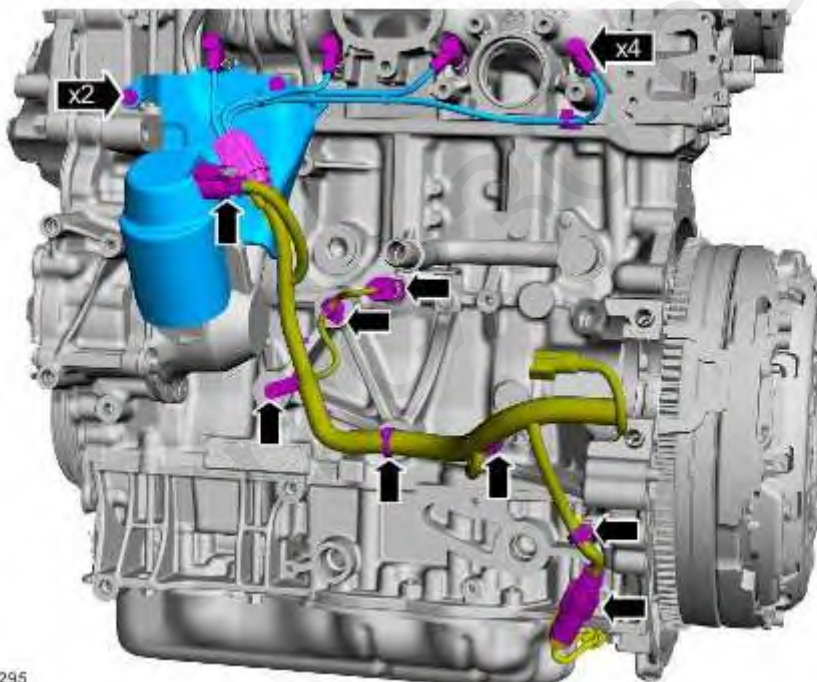


37.



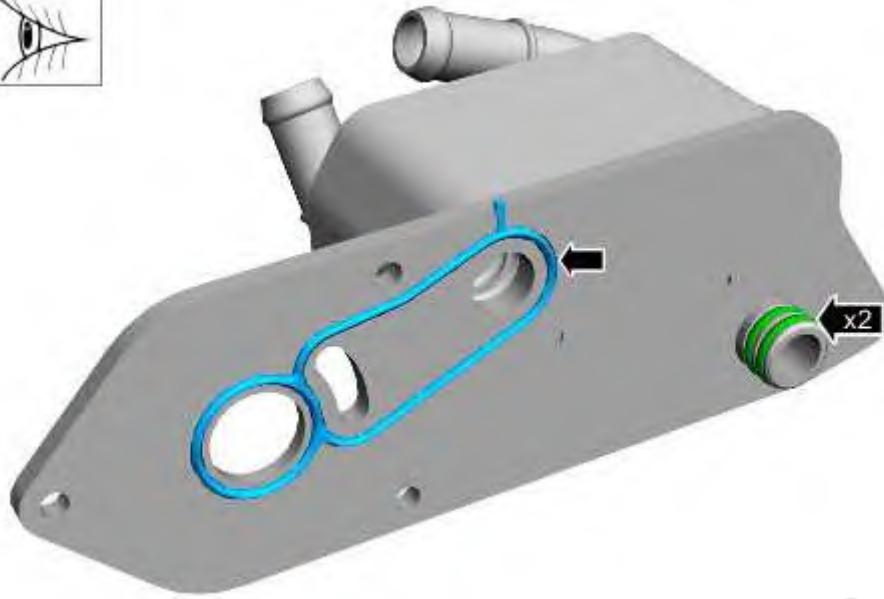
E227372

38. Torque: 10 Nm



E227295

39.  **NOTICE:** Make sure that the gasket is correctly located.
NOTE: Use new seals.

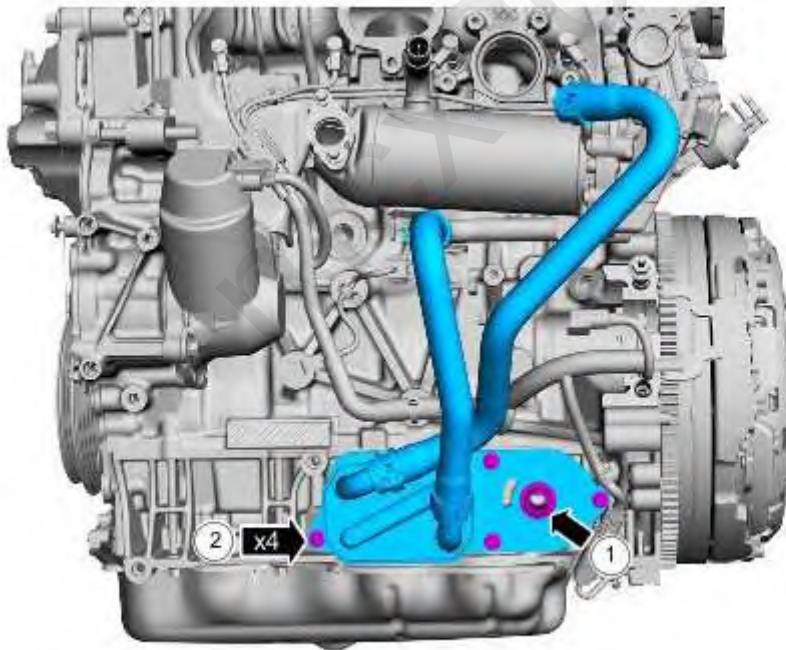


E230929

40.  **NOTICE:** Make sure that the gasket is correctly located.
NOTE: Only tighten the bolts finger tight at this stage.

Torque:

- 1: 55 Nm
2: 10 Nm

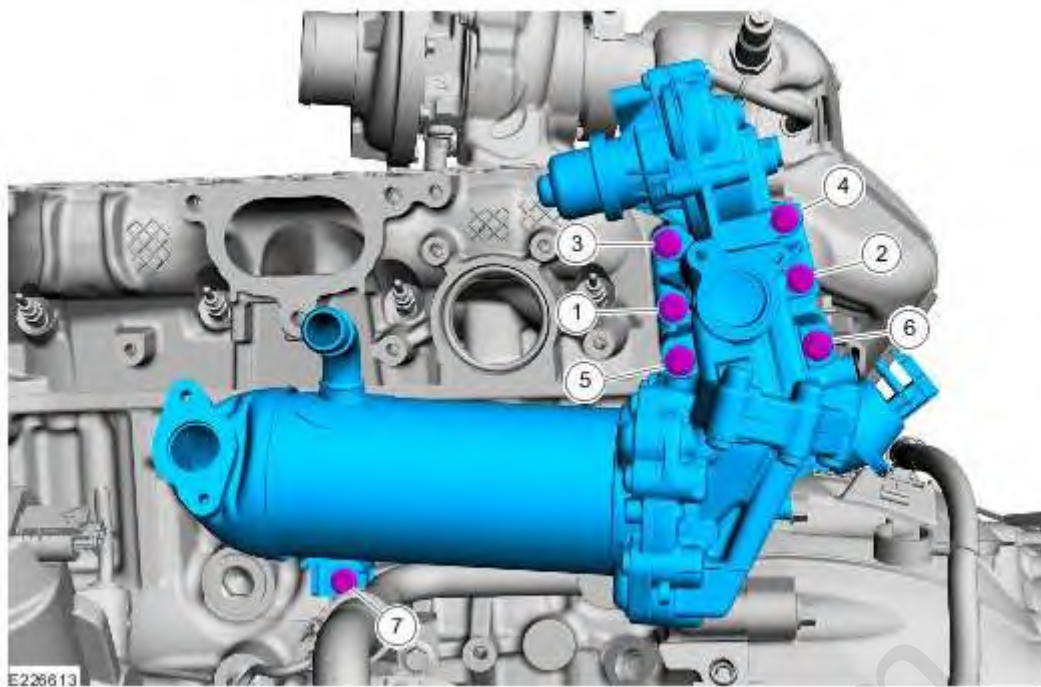


E227294

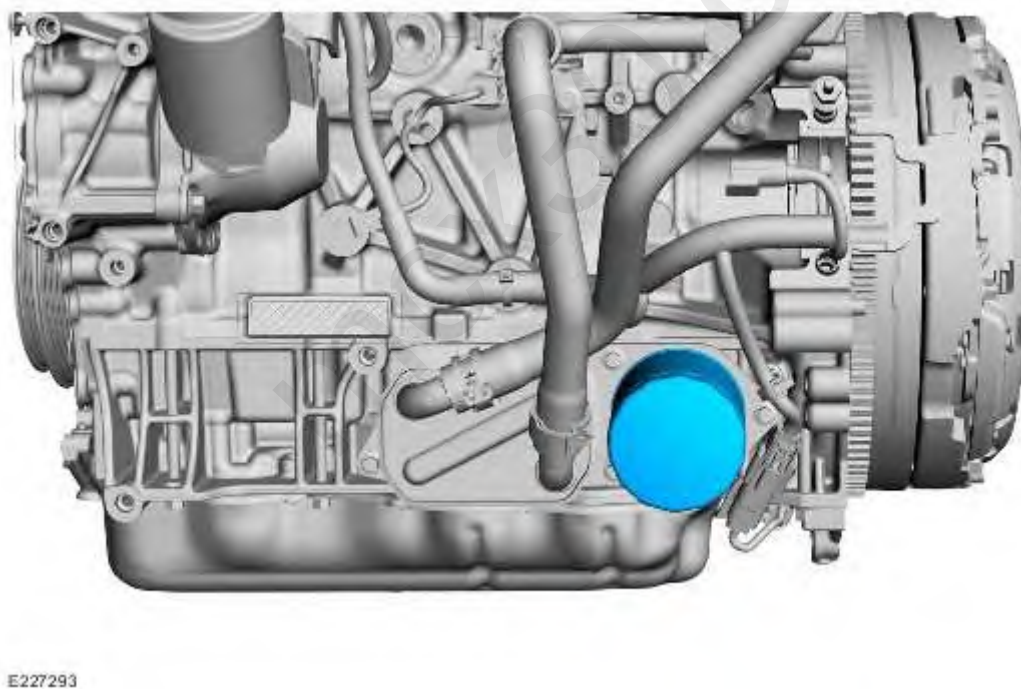
41. **NOTE:** Use a new seal.
NOTE: Make sure that the seal is correctly located.
NOTE: Only tighten the bolts finger tight at this stage.

Torque:

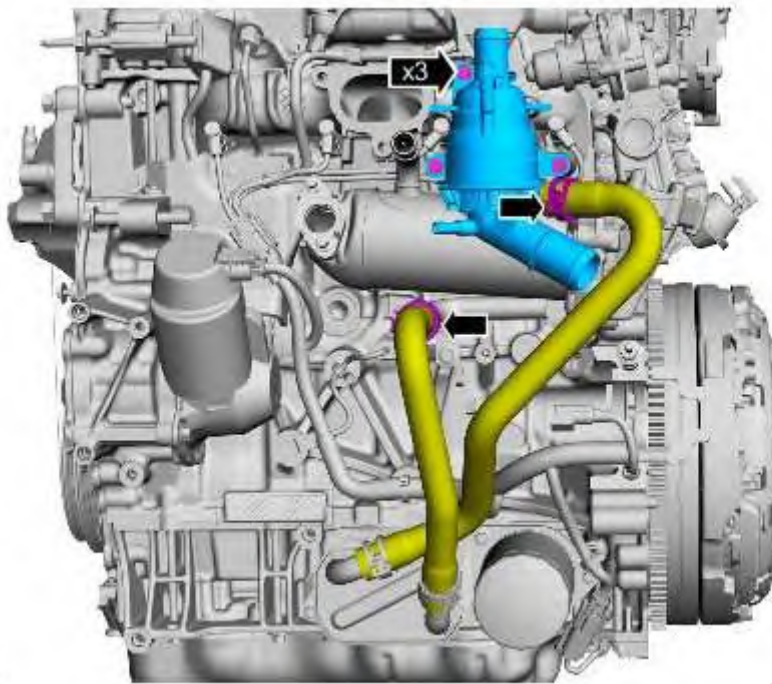
- Stage 1: 4 Nm
Stage 2: 10 Nm



42. **NOTE:** Component must be lubricated with clean engine oil.
 Refer to: [Specifications](#) (303-01A Engine, Specifications).
 Torque: 15 Nm

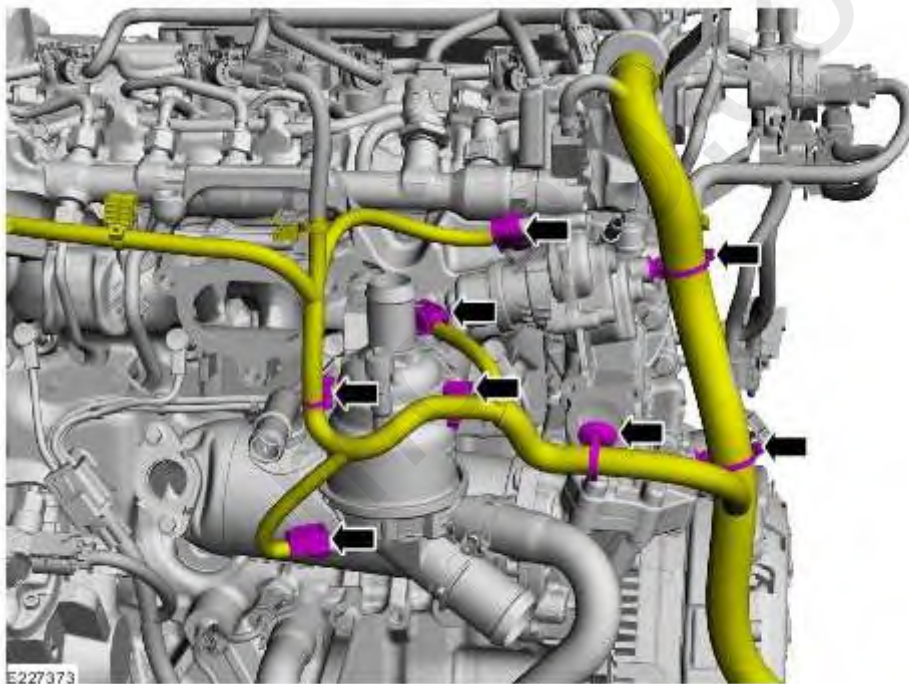


43. **NOTE:** Only tighten the bolts finger tight at this stage.
 Use the General Equipment: [Hose Clamp Remover/Installer](#)
 Torque: 10 Nm



E227292

44.

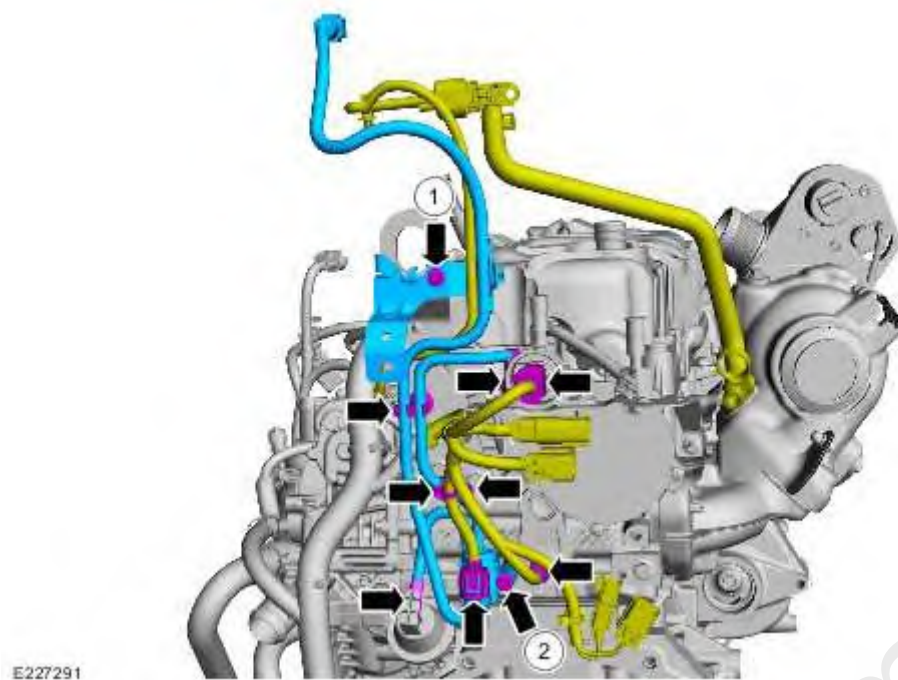


E227373

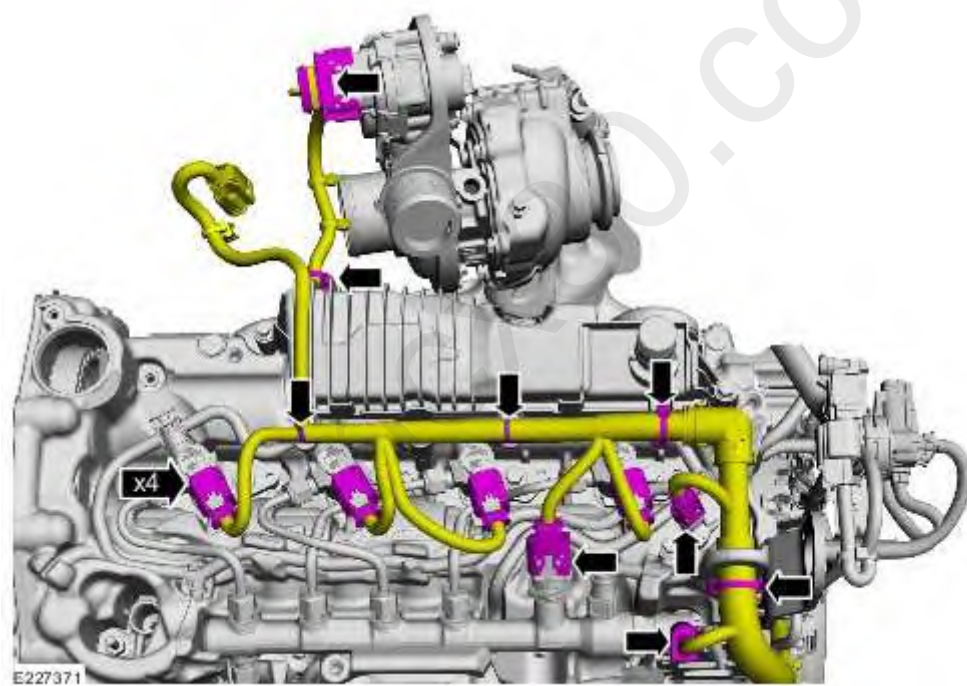
45. Use the General Equipment: [Hose Clamp Remover/Installer](#)
Torque:

1: 10 Nm

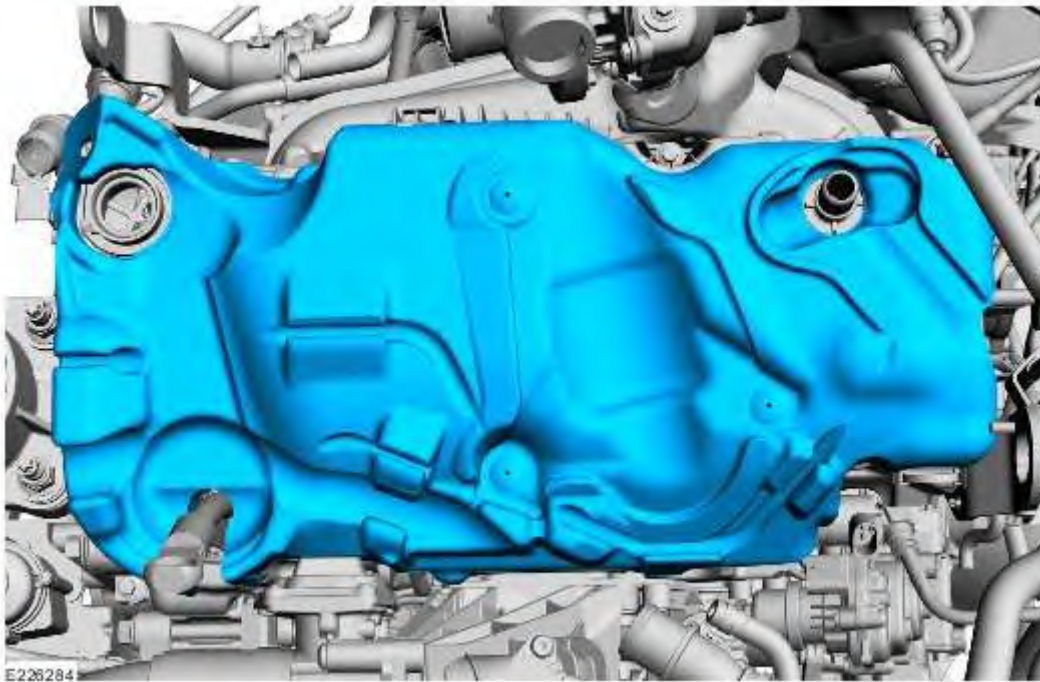
2: 10 Nm



46.



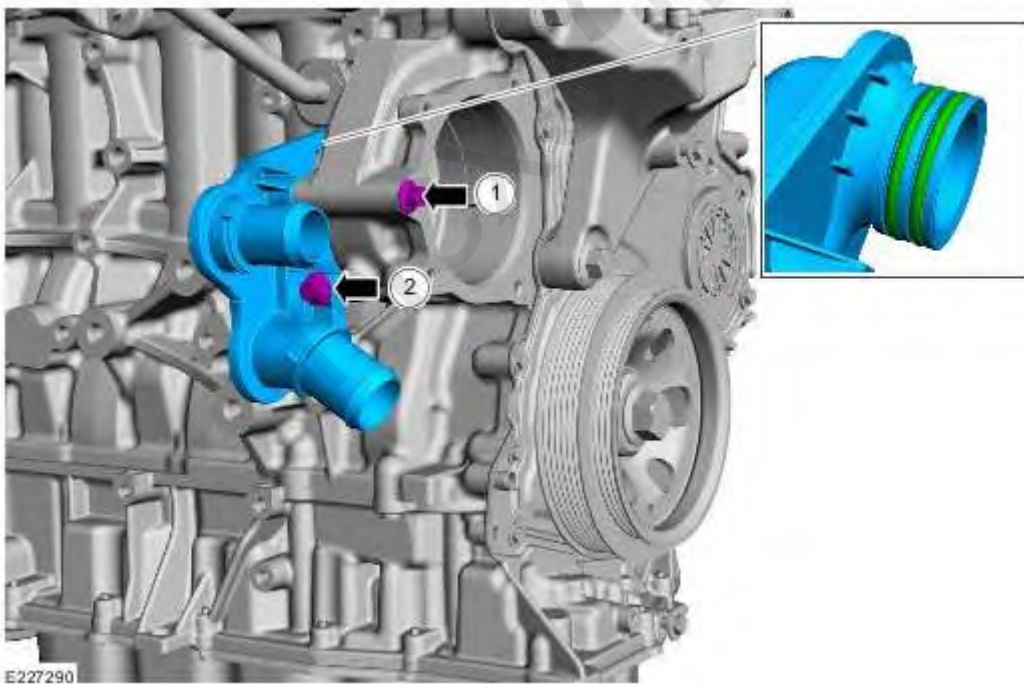
47.



48. NOTE: Make sure that the components are correctly located.
NOTE: Only tighten the bolts finger tight at this stage.

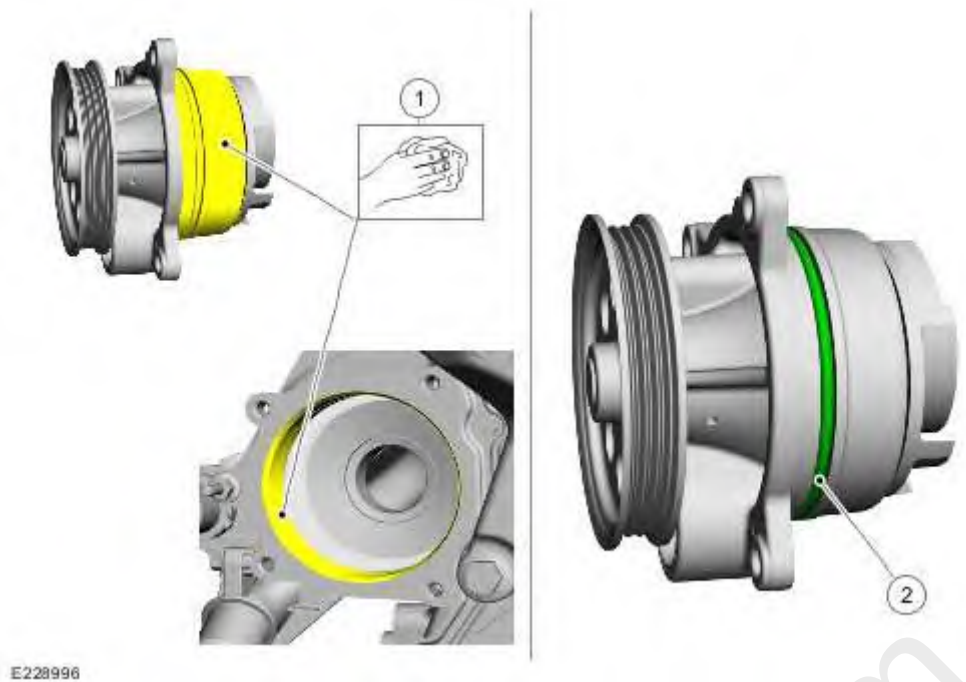
Torque:

- 1: 23 Nm
- 2: 23 Nm



49.

1.  NOTICE: Use lint free cloth.
NOTE: Make sure that the component is clean, free of foreign material and lubricant.
2. NOTE: Make sure that a new component is installed.



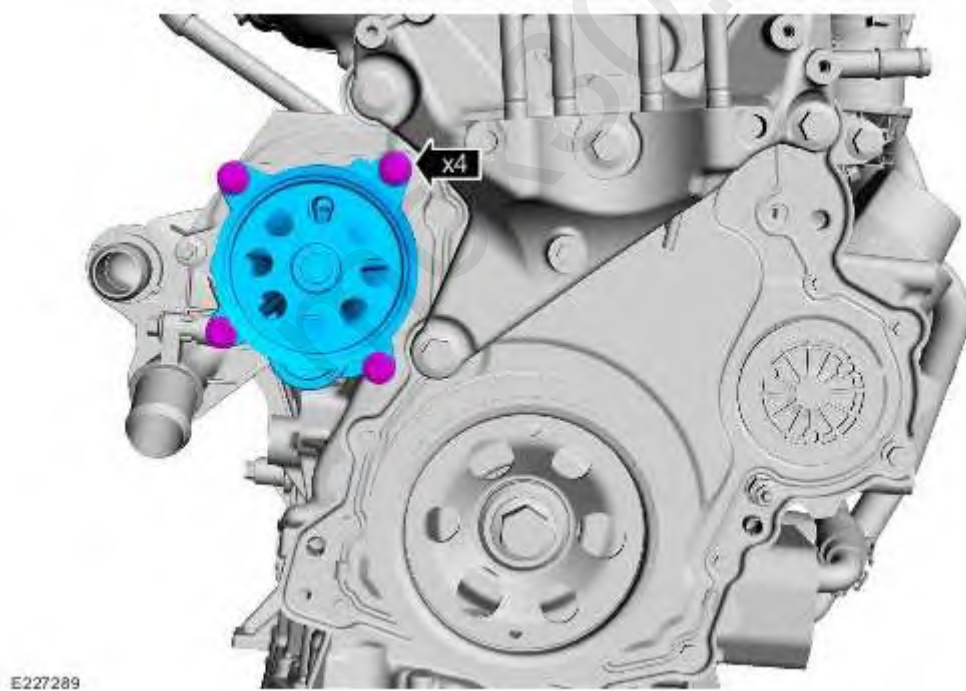
50. **NOTE:** Only tighten the bolts finger tight at this stage.

Torque:

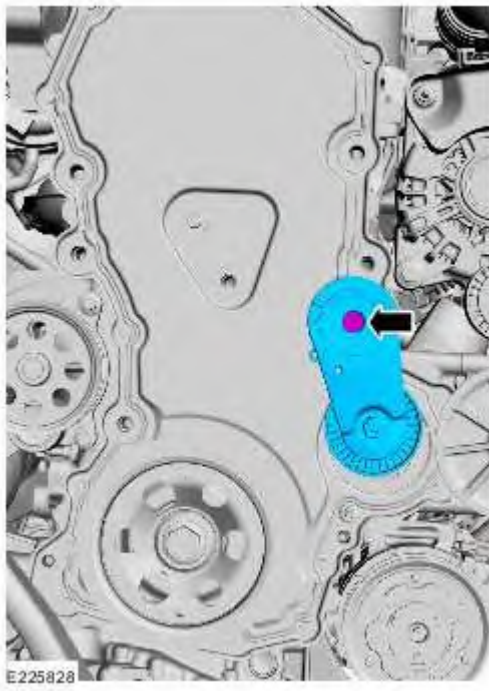
Stage 1: 5 Nm

Stage 2: 10 Nm

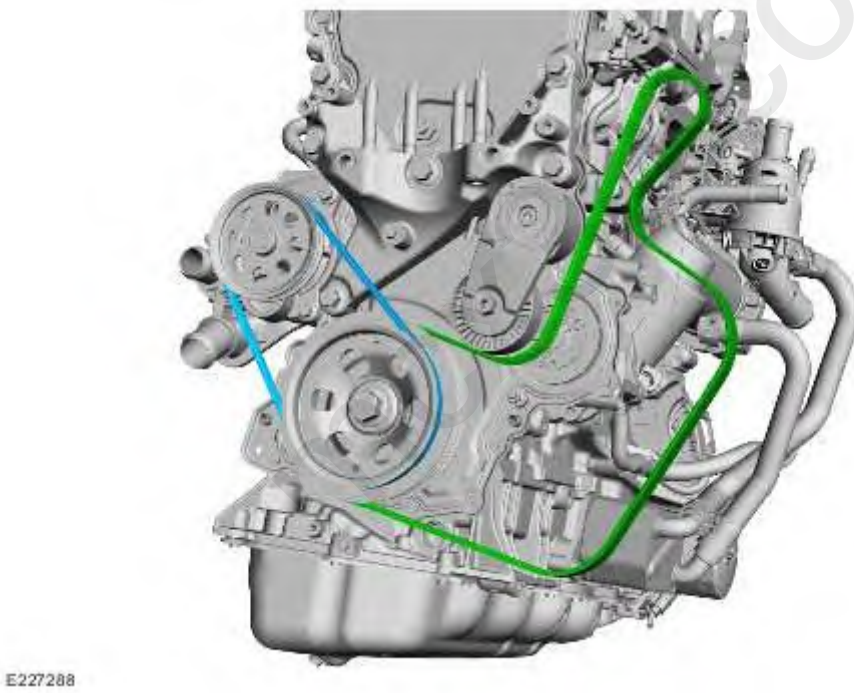
Stage 3: 23 Nm



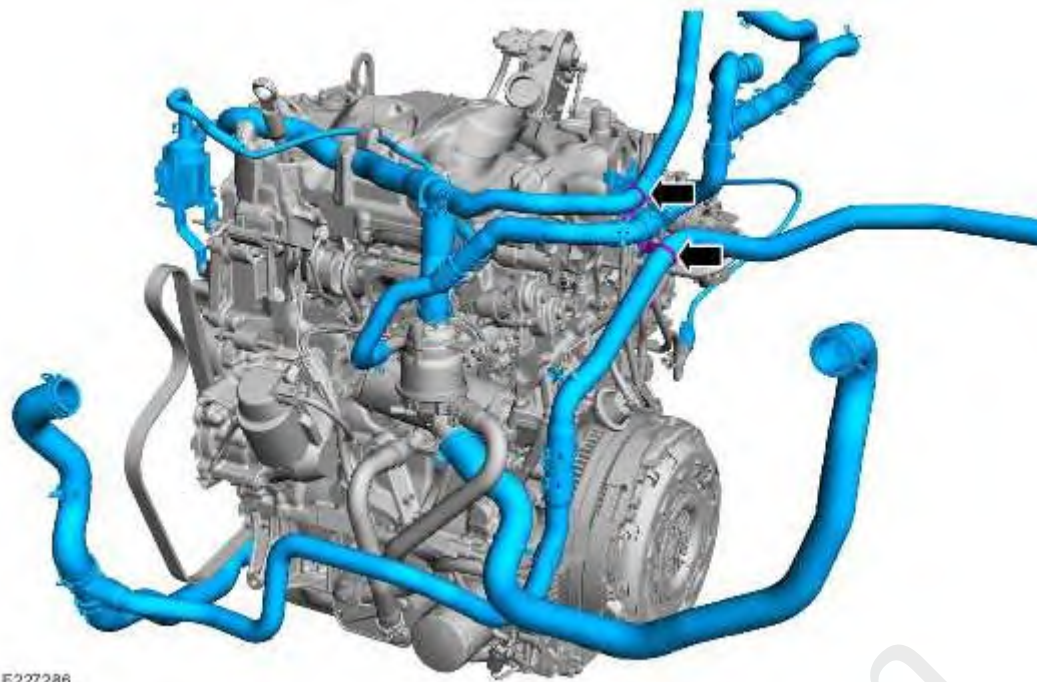
51. *Torque:* 63 Nm



52.

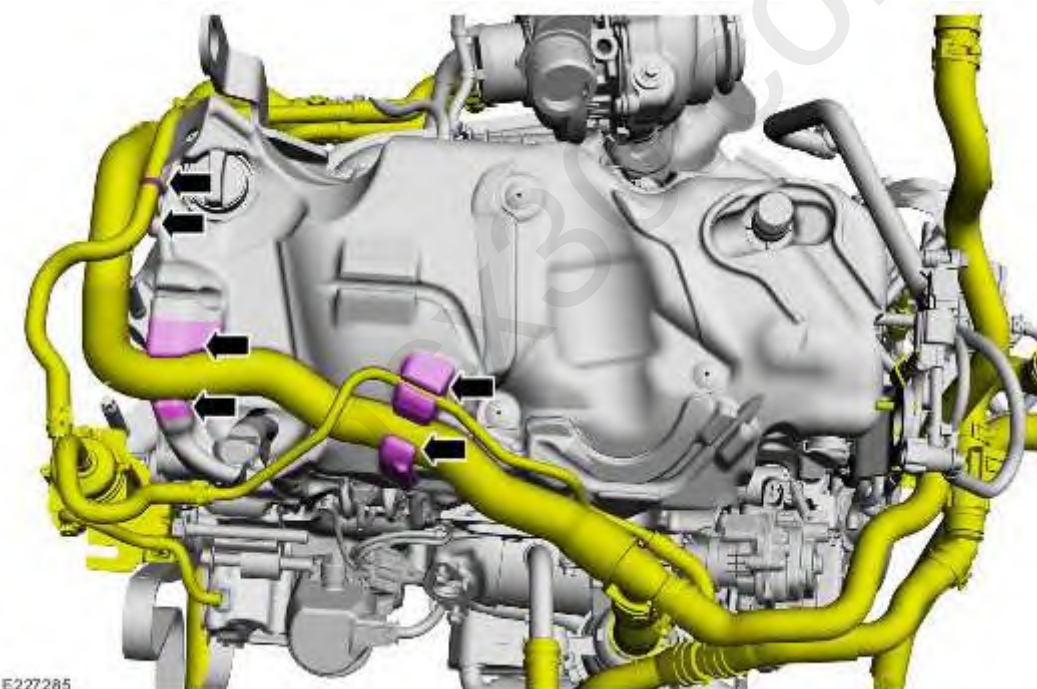


53. NOTE: Be prepared to collect escaping fluids.



E227286

54.

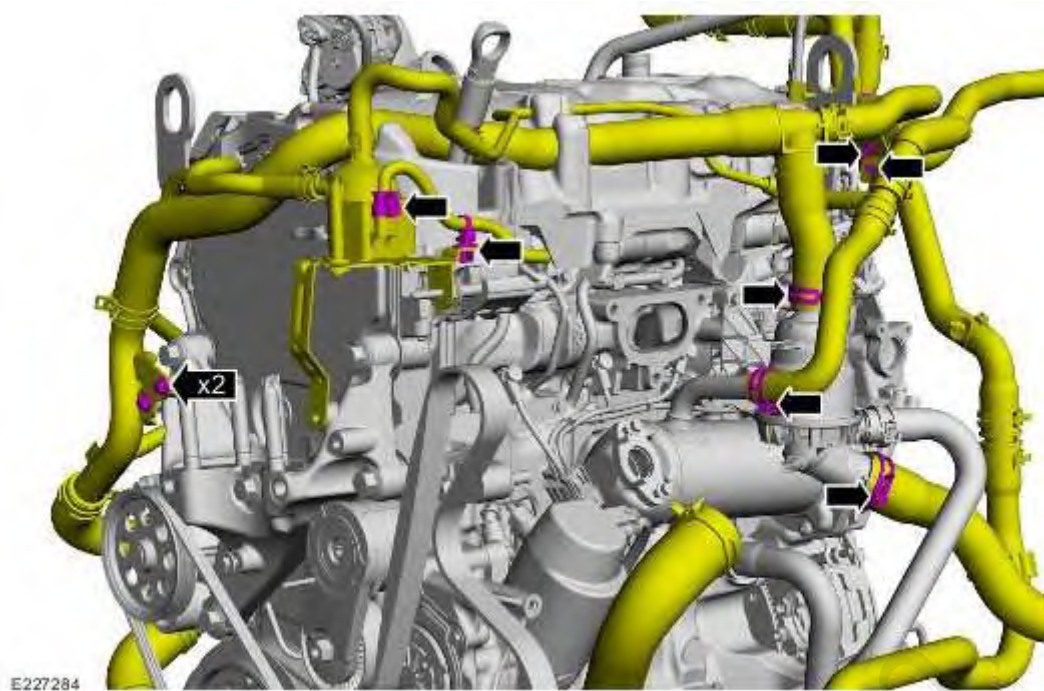


E227285

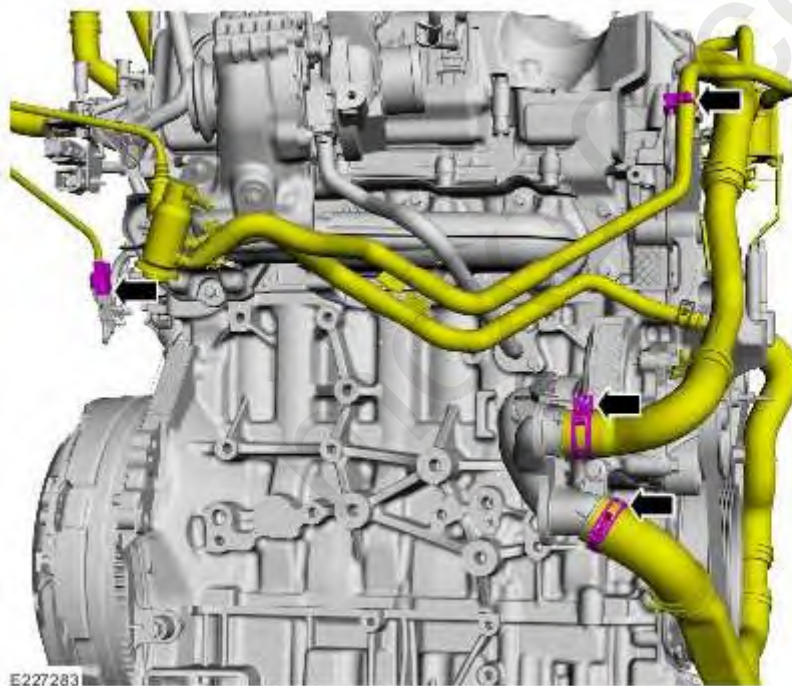
55. **NOTE:** Only tighten the bolts finger tight at this stage.

Use the General Equipment: [Hose Clamp Remover/Installer](#)

Torque: 10 Nm



56. Use the General Equipment: [Hose Clamp Remover/Installer](#)

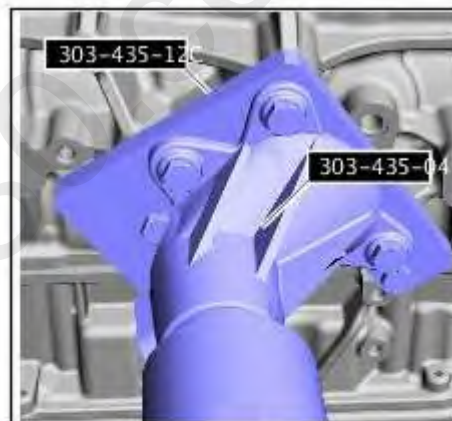


57. Install the General Equipments: [Lifting Bracket](#), [Floor Crane](#)



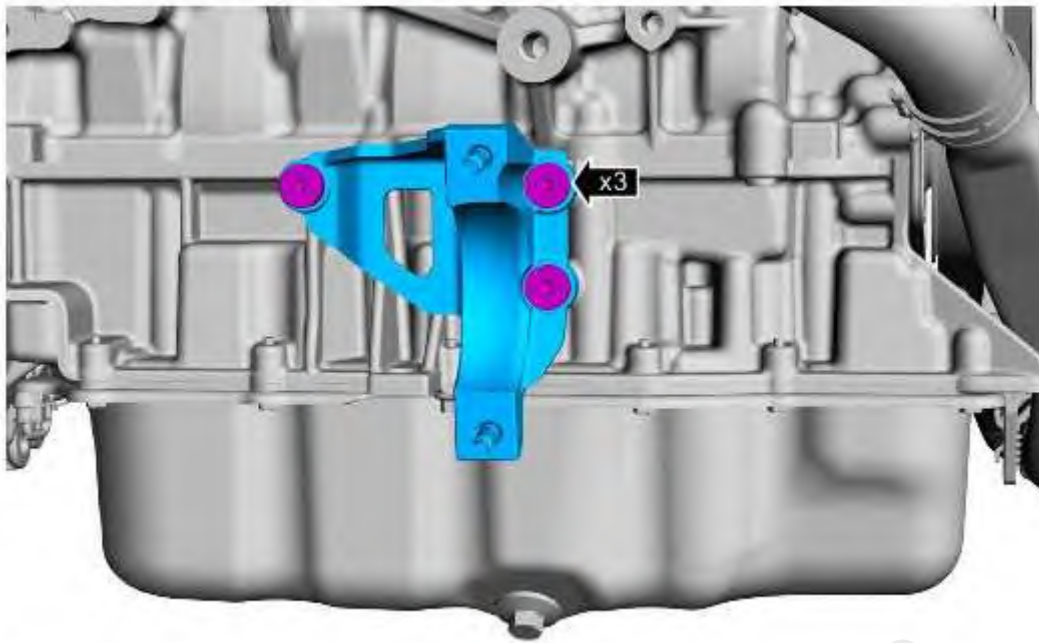
E188536

58. Remove Special Service Tools: [303-435-12C](#), [303-435-04](#), [303-435](#).



E227282

59. Torque: 23 Nm



E227281

60. **NOTE:** Only tighten the nut and bolts finger tight at this stage.

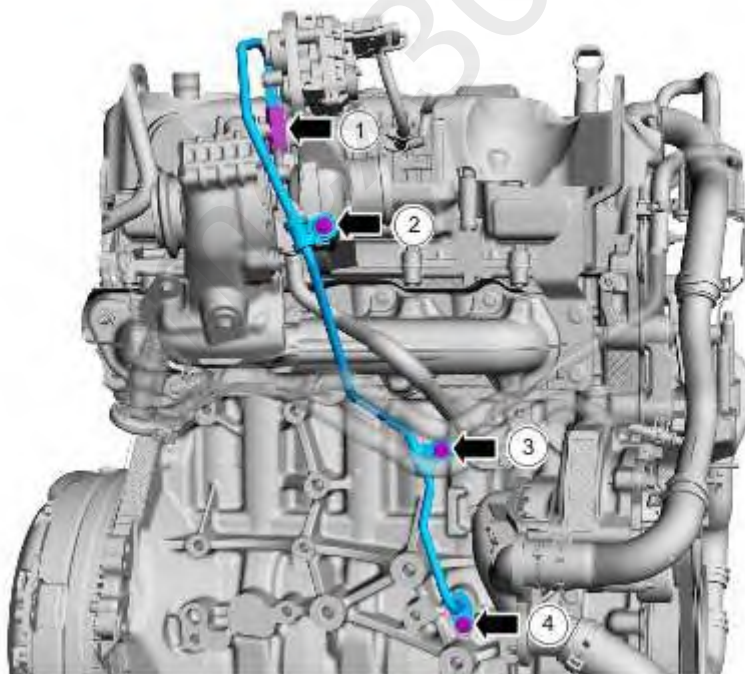
Torque:

1: 20 Nm

2: 10 Nm

3: 10 Nm

4: 10 Nm



E227279

61. *Torque:* 63 Nm

