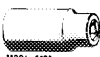
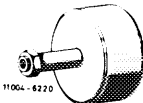


Tightening torques	Nm
Nuts for cylinder head cover	15
Necked-down screw for camshaft sprocket	80
Fastening screw for injection timer	40
Coupling nuts for injection lines	25
Closing plug for chain tensioner	90

Socket 27 mm, 1/2" square, for rotating engine  001 589 65 09 00

Box wrench socket, open, 17 mm, 1/2" square, for injection lines  000 589 68 03 00

Impact puller for bearing bolt (basic unit)  116 589 20 33 00

Threaded bolt M 6, 50 mm long for impact puller  116 589 01 34 00

Articulated wrench  000 589 21 07 22

Overflow pipe  636 589 02 23 00

Holding plate  616 589 02 40 00

Note

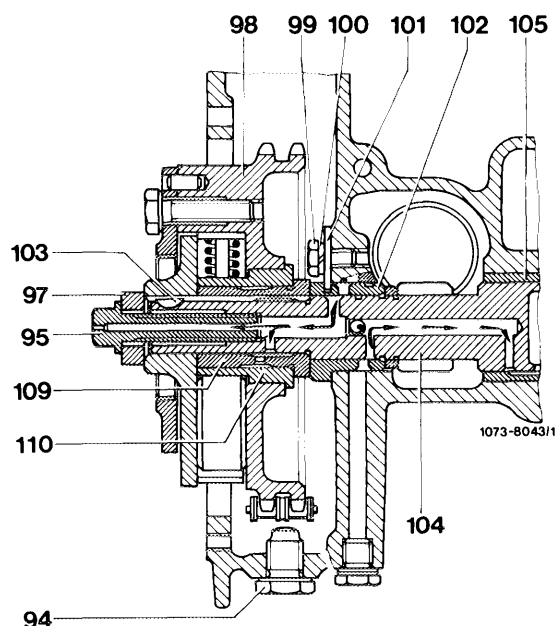
The injection timer is mounted on intermediate sprocket shaft with a screw M 10 x 45 (95).

On engine 617.950 with double diaphragm vacuum pump, the screw has a hollow shaft.

The vacuum pump is provided with the required oil through this hollow screw.

Layout of double diaphragm vacuum pump

- | | |
|------------------------|-------------------------------------|
| 94 Chain locking screw | 101 Lock washer |
| 95 Screw M 10 x 45 | 102 Bearing bushing front |
| 97 Washer | 103 Woodruff key |
| 98 Injection timer | 104 Intermediate sprocket shaft |
| 99 Screw M 6 x 12 | 105 Bearing bushing rear |
| 100 Snap ring B 6 | 109 Bearing bushing injection timer |

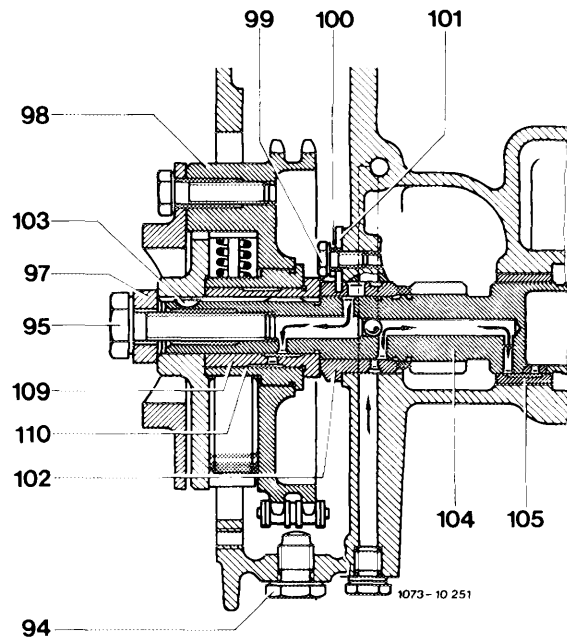


On engines with piston vacuum pump, screw (95) is not hollow.

Do not mix up screws (95).

Layout with piston vacuum pump

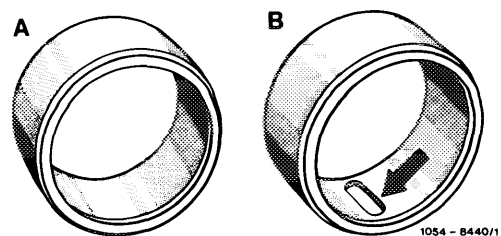
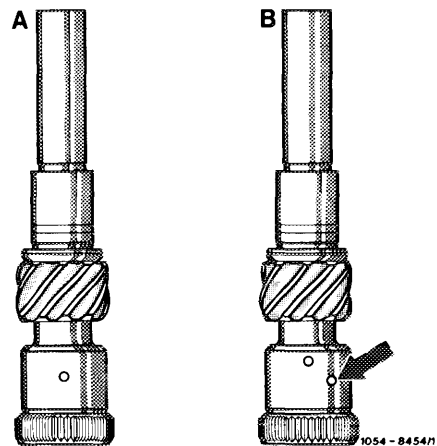
94	Locking screw	101	Lock washer
95	Screw M 10 x 45	102	Bearing bushing front
97	Washer	103	Woodruff key
98	Injection timer	104	Intermediate sprocket shaft
99	Screw M 6 x 12	105	Bearing bushing rear
100	Snap ring B 6	109	Bearing bushing



On engine 617.950 since August 1978, and on engines 617.951/952 since start of series, the intermediate sprocket shaft (B) and the rear bearing bushing (B) of engines 615, 616 and 617.912 are installed for reasons of standardization.

These parts can also be installed on engines 617.950 manufactured at an earlier date.

- A Intermediate sprocket shaft 1st version
B Intermediate sprocket shaft 2nd version



- A Rear bearing bushing 1st version
B Rear bearing bushing 2nd version

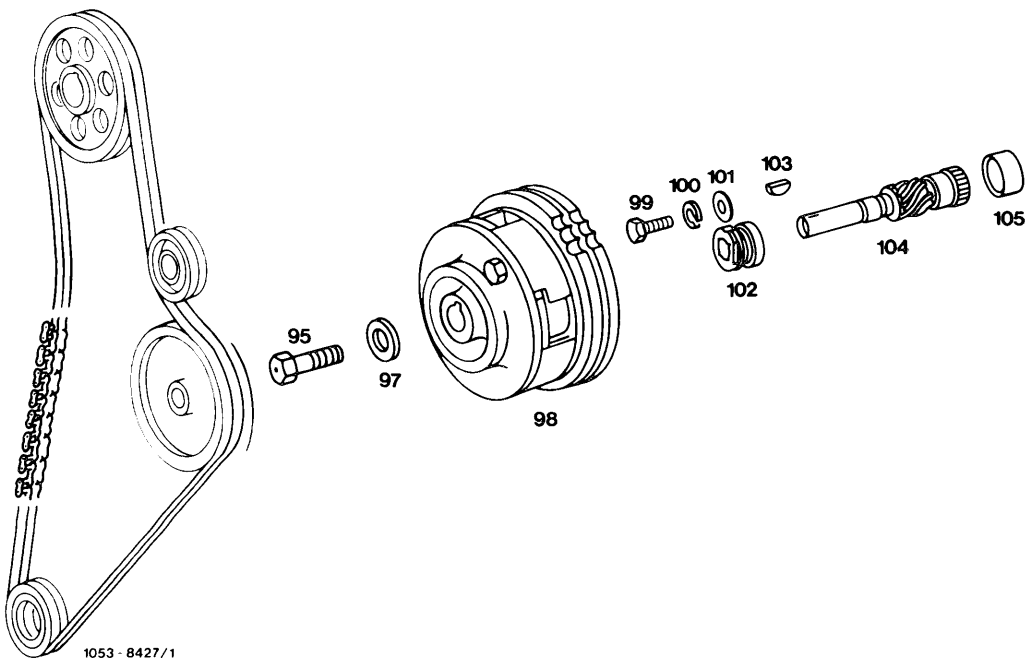
Removal

- 1 Remove fan and radiator shell.
- 2 Remove vacuum pump (42–610).
- 3 Remove injection timer (07.1–210).
- 4 Remove injection pump (07.1–180).
- 5 Pull out intermediate sprocket shaft toward the rear.

Installation

- 6 Insert intermediate sprocket shaft from the rear.
- 7 Install injection timer (07.1–210).
- 8 Install injection pump (07.1–180).
- 9 Check timing of camshaft (05–215) and begin of delivery (injection timing) of injection pump (07.1–110).
- 10 Install vacuum pump (42–610).
- 11 Install fan and radiator shell.

Intermediate sprocket shaft and injection timer



- 95 Screw M 10 x 45
97 Washer
98 Injection timer
99 Screw M 6 x 12
100 Snap ring B 6

- 101 Lock washer
102 Bearing bushing front
103 Woodruff key
104 Intermediate sprocket shaft
105 Bearing bushing rear