



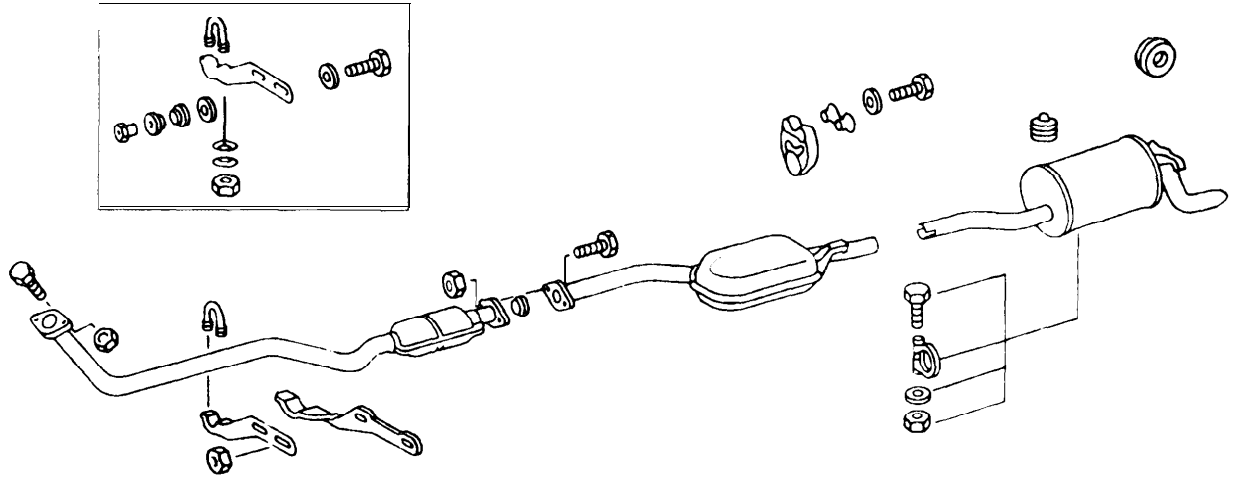
Job No.

Removal and installation of exhaust system .....	49 - 100
Removal and installation of exhaust system - Turbodiesel .....	49 - 100

## 49-100 Removal and installation of exhaust system

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### A. Model 201 with Engine 602



Hexagon bolt (1) .....	Replace, 20 Nm.
Front exhaust pipe (2) or front exhaust pipe with oxidation catalytic converter (2a) .....	Check flanges for signs of damage, tighten evenly.
Self-locking hexagon nut (3) .....	Replace.
Self-locking hexagon nut (4) .....	Replace, 20 Nm.
Sintered sealing ring (5) .....	Examine for signs of damage, ensure correctly seated.
Retaining clamp (6) .....	Examine for re-use.
Center muffler (7) .....	Examine for signs of damage.
Hexagon bolt (8) .....	Replace.
Rear muffler (9) .....	Examine for signs of damage.

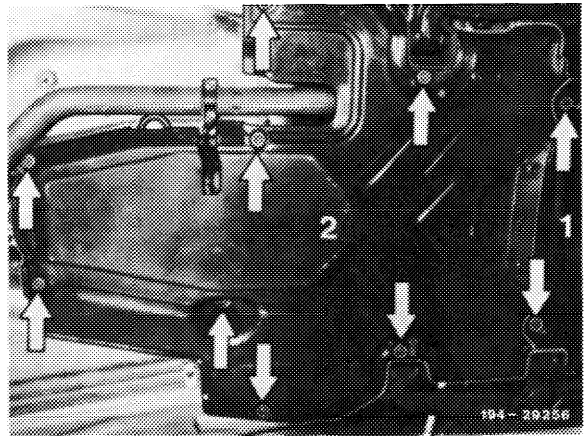
Side supporting bracket (10)	Loosen, fix.
Hexagon bolt (11) .....	20 Nm.
Washer (12)	
Rubber pad (13) .....	Examine for signs of wear.
Large rubber disc (14) , .....	Examine for signs of damage.
Spacer sleeve or small rubber disc (15)	
Self-locking hexagon nut (16) .....	Replace, 7 Nm.
Cup spring (17) .....	Replace, ensure correctly installed.
Rubber ring (18) .....	Examine for signs of damage and wear.
Hexagon bolt (19)	
Washer (20)	
Pipe clip (21)	
Spring lock washer (22) .....	Replace.
Hexagon nut (23) .....	20 Nm.
Hexagon bolt (24) .....	20 Nm.
Hanger plate (25) .....	Examine for signs of damage and wear.
Tensioning plate (26)	

The description which follows does not cover removal and installation of the exhaust system to the full extent, but deals only with particularly important points which should be noted during removal, installation or partial replacement of the exhaust system, e.g. the rear muffler with push-in joint.

## Removal

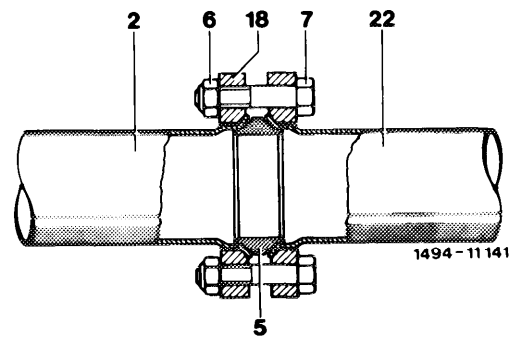
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1 Detach rear section of noise capsule when working on the front exhaust system.



2 Examine hanger parts for possible re-use, replace if necessary.

3 Before installing the exhaust system, ensure that the flange to the exhaust manifold is not twisted; align flange if necessary. Clean combustion residues from tapered connector pieces of pipes and centered sealing rings (2, 5 and 22), if necessary, with emery cloth.

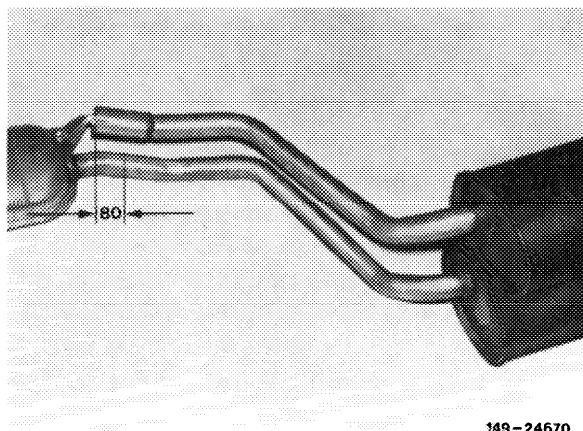


## Installation

Replacement of rear muffler.

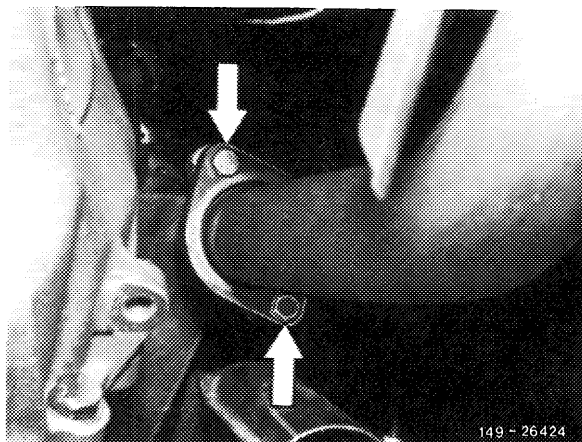
4 Position new rear muffler with plug-in joint precisely over removed system and mark length of pipe of new rear muffler on removed system.

Cut through the pipe 80 mm away from the mark (tolerance minus 10 mm) in the direction of rear muffler to obtain an insertion depth of 70-80 mm.



5 Always replace self-locking hexagon nut.

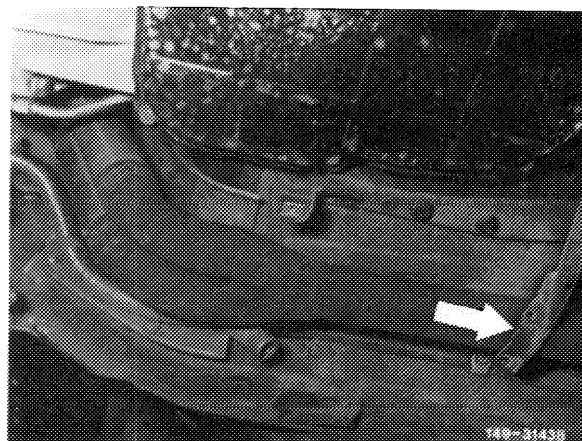
6 Tighten the flanged joint to the manifold evenly. Tightening torque of self-locking hexagon nuts 20 Nm.



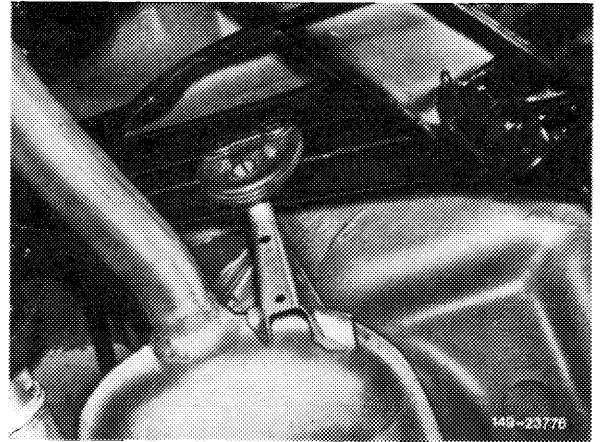
Model 201.1

### Caution!

When installing the front exhaust system to the manifold, do not allow the spiral hoses to be tensioned by the weight of the system. Use the side mounting brackets on the transmission as a support (arrow).

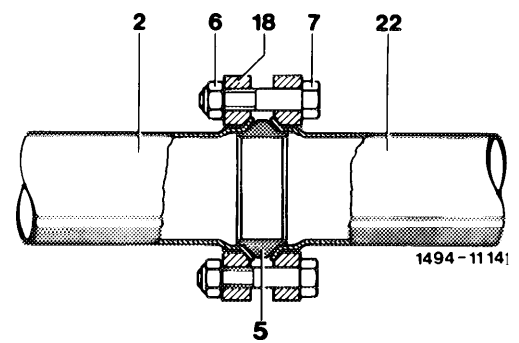


7 Install rear exhaust system with center and final mufflers, at the same time attaching the exhaust system to the rubber hanger at the rear axle support.

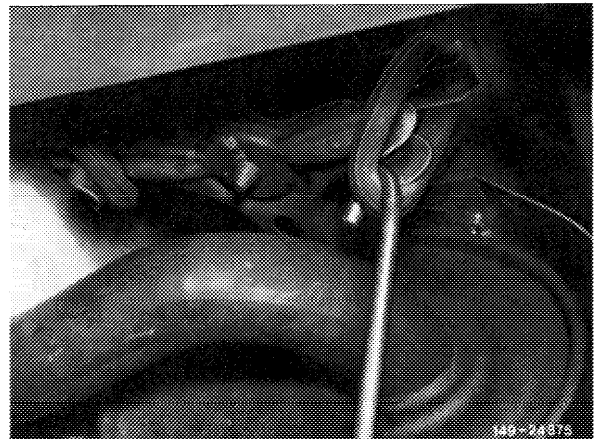


8 Install sintered sealing ring (5) at the flanged joint and ensure it is correctly seated. Tightening torque of self-locking hexagon nuts 20 Nm.

- 2 Front exhaust pipe
- 5 Sintered sealing ring
- 6 Self-locking hexagon nut
- 7 Hexagon bolt
- 18 Flange
- 22 Rear exhaust pipe



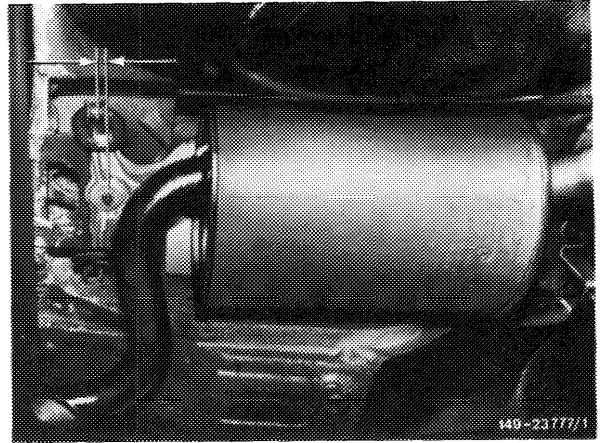
9 Use a suitable hook to attach rubber rings to the rear muffler.



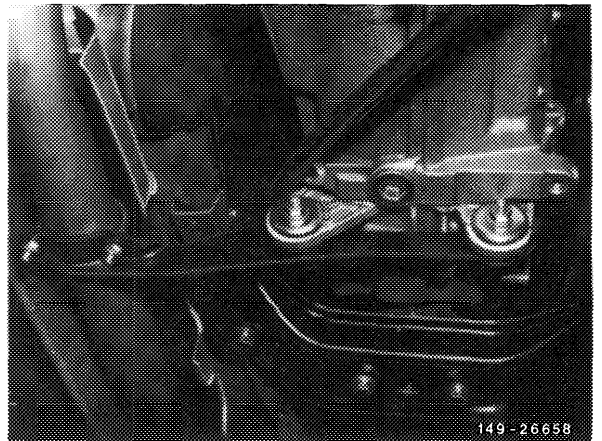
10 Install rear muffler in such a way that the retaining clamps of the rear muffler are positioned approx. 10 mm ahead of the brackets on the frame floor to ensure that the system is correctly installed when the exhaust expands (arrows).

**Note**

This applies only to replacement mufflers with plug joints between the center and rear mufflers.



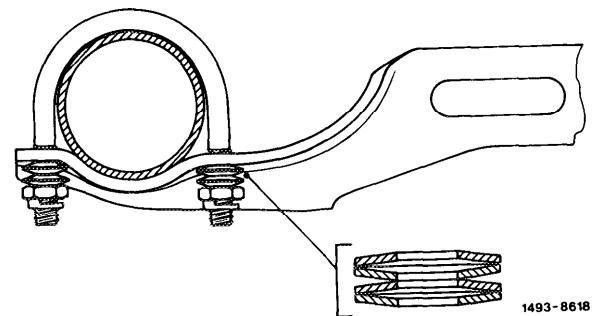
11 Install side mounting bracket of exhaust free of tension. Tightening torque of self-locking hexagon nuts at tensioning clamp is 7 Nm, of hexagon bolts of side mounting bracket on transmission 20 Nm.



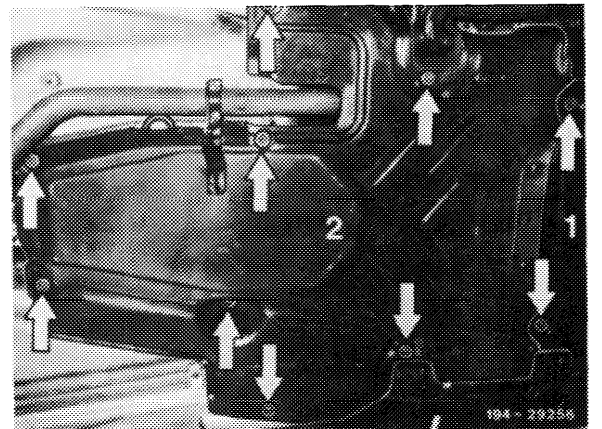
**Note**

Install 4 cup springs on each side of the retaining clamp in such a way that the convex ends are apart (as shown in illustration).

12 Run engine and examine exhaust system for leaks.



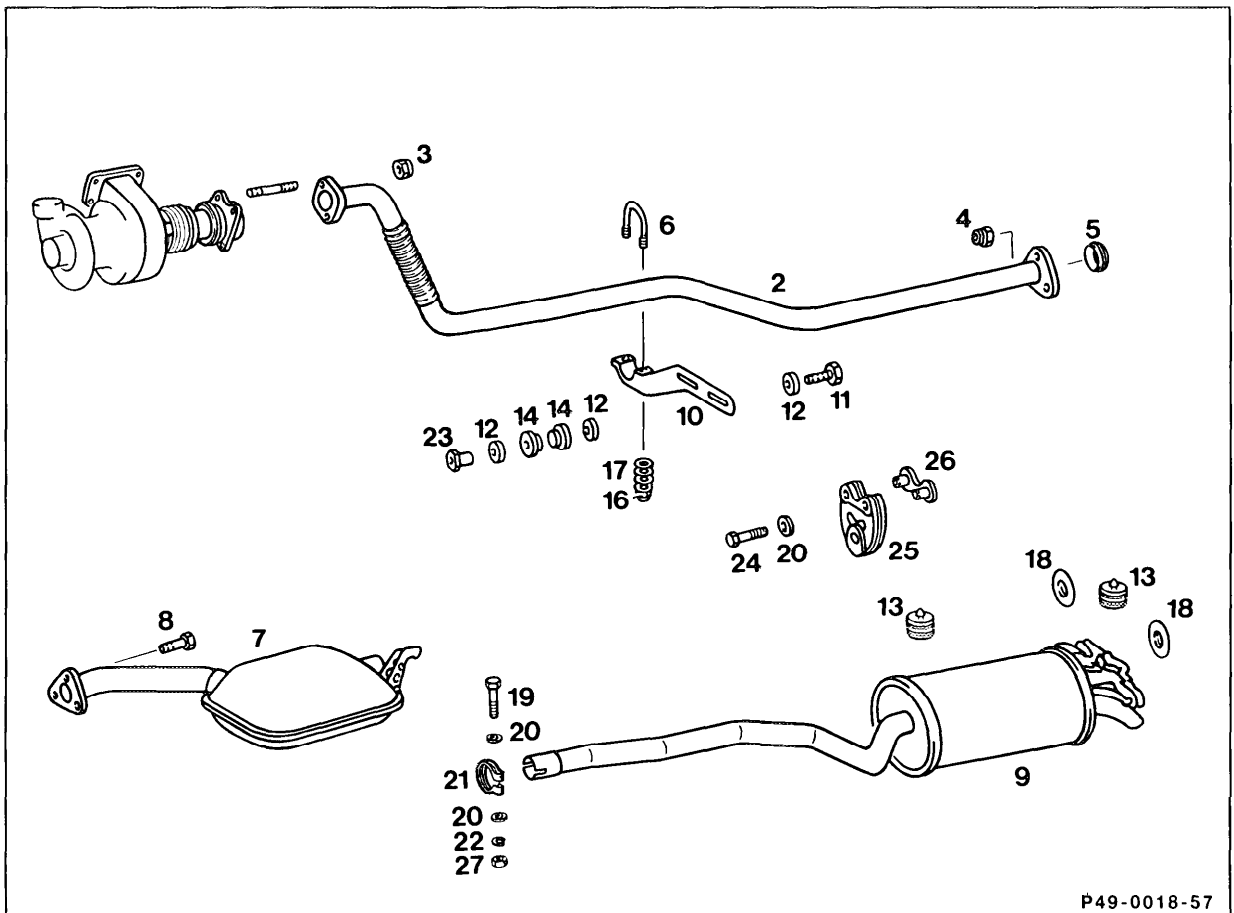
13 Install noise capsule.





## 49-I 00 Removal and installation of exhaust system - Turbodiesel

### A. Model 201 with Engine 602.96



Rear muffler (9) . . . . .	remove, install, check for damage, replace if necessary.
Rubber buffer (13) . . . . .	check for wear, replace if necessary.
Pipe clamp (21) . . . . .	replace.
Center muffler (7) . . . . .	remove, install, examine for signs of damage, replace if necessary.
Hexagon bolts (8) and self-locking nuts (4) . . . . .	replace. Tightening torque 20 Nm.

Sintered seal (5) .....	examine for signs of damage, Ensure correct seating.
Retaining bar (6) with Belleville spring washers (17) and self-locking nuts (16) .....	remove, refit. Tightening torque 7 Nm.

**Installation note**

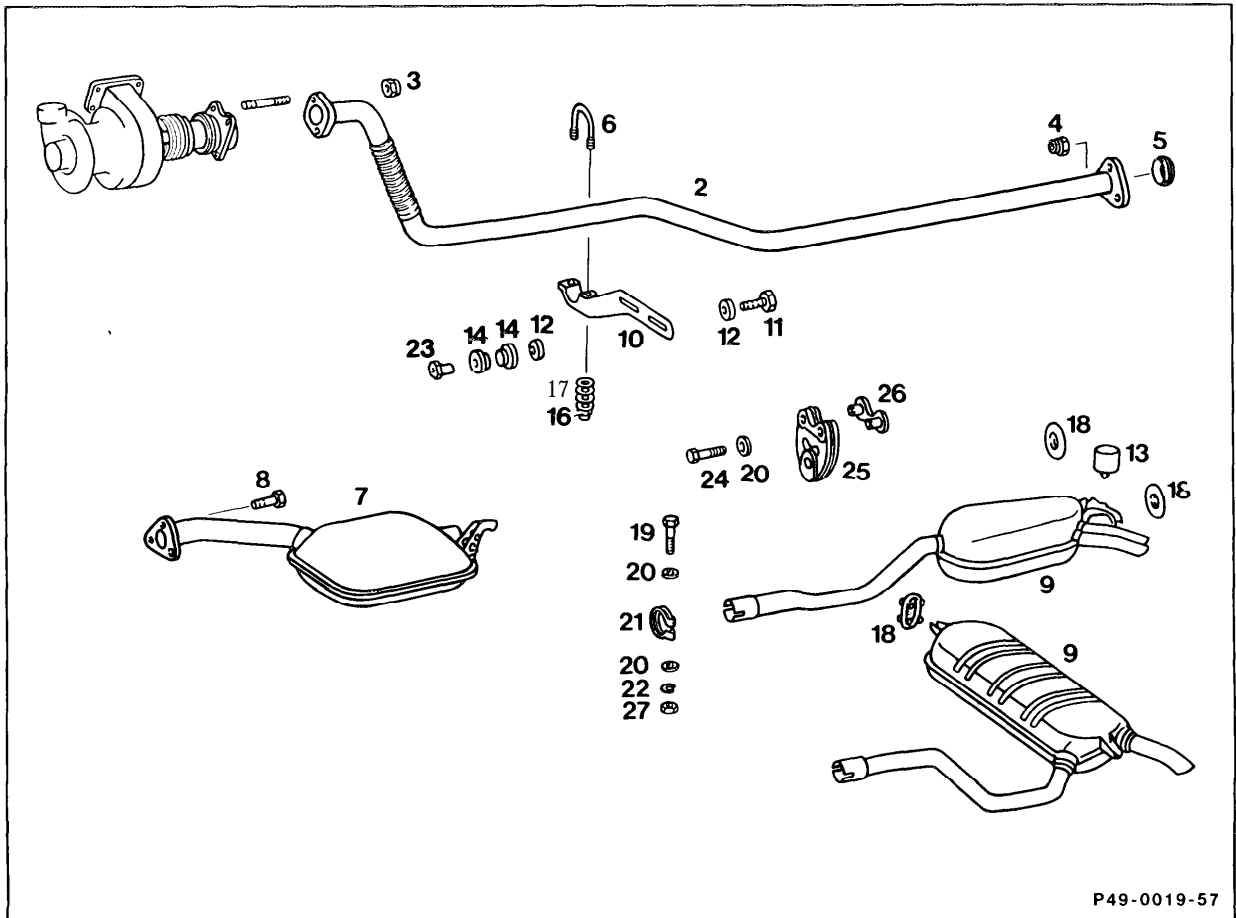
Check parts and replace if necessary.

**Caution!**

Note pictorial information for assembling Belleville spring washers.

Front exhaust pipe with flexible hose (2) .....	remove, install, check flange for damage, tighten evenly and assemble flexible hose free of tension. Replace self-locking nuts (16), tightening torque 20 Nm.
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**B. Model 124 with Engines 602.96, 603.96**



P49-0019-57

Rear muffler (9) .....	remove, install, check for damage, replace if necessary.
Rubber buffer (13) .....	check for wear, replace if necessary.
Pipe clamp (21) .....	replace.
Center muffler (7) .....	remove, install, check for signs of damage, replace if necessary.
Bolts (8) and self-locking nuts (4) .....	replace. Tightening torque 20 Nm.
Sintered seal (5) .....	check for damage, ensure correct position.

Retaining bar (6) with Belleville spring washers (17)  
and self-locking nuts (16) . . . . .

detach, mount, tightening torque 7 Nm.

**Installation note**

Test parts and replace if necessary.

**Caution!**

Note pictorial information on assembly of  
Belleville spring washers.

Front exhaust pipe with flexible hose (2) . . . . .

remove, install, check flanges for signs of  
damage, tighten evenly and install flexible hose  
free of tension. Replace self-locking nuts (16).  
Tightening torque 20 Nm.