

**Disassembly and Assembly of Engine  
(Individual Removal of Assemblies and Parts)**

Job No.
00-20

**A. OM 636**

**B. OM 621**

**C. General**

Apart from a general overhaul only those assemblies and engine parts are normally removed which have to be repaired or tested. The operations have therefore been subdivided and arranged in such a way that all operations for removal and installation of the assembly or the part in question are given in the respective section.

**A. OM 636**

If an engine has to be completely stripped, the operations of the sections 1 through 20 have to be carried through.

1. Removal and installation of air filter (see Job No. 09-7).
2. Removal and installation of intake line with throttle duct and exhaust manifold (see Job No. 14-1 and 14-5).
3. Removal and installation of starter motor (see Job No. 15-1).
4. Removal and installation of generator (see Job No. 15-11).
5. Removal and installation of injection lines, vacuum line and fuel main filter (see Job No. 07-15 and 09-1).
6. Removal and installation of cylinder head (see Job No. 01-3).  
Disassembly of cylinder head:
  - a) Removal and installation of glow plugs (see Job No. 15-31).
  - b) Removal and installation of nozzle holders with nozzles (see Job No. 07-17).
  - c) Removal and installation of prechambers (see Job No. 01-1).
  - d) Removal and installation of valves (see Job No. 05-11).
  - e) Removal and installation of water pump (see Job No. 20-5).
  - f) Removal and installation of cooling water outlet pipe.
7. Removal and installation of oil filter (see Job No. 18-7).
8. Removal and installation of injection pump and fuel feed pump (see Job No. 07-11).
9. Removal and installation of fan bracket with pulley and support for fan bracket, if installed (see Job No. 20-15).
10. Removal and installation of operation hour counter, if installed (see Job No. 01-11).
11. Removal and installation of revolution counter drive, if installed (see Job No. 01-12).
12. Removal and installation of injection timing device, if installed (see Job No. 07-25).
13. Removal and installation of timing gear housing cover (see Job No. 01-15).
14. Removal and installation of timing gears (see Job No. 05-31).
15. Removal and installation of oil pressure relief valve (see Job No. 18-3).
16. Removal and installation of oil pan (see Job No. 01-21).
17. Removal and installation of oil pump (see Job No. 18-11).

18. Removal and installation of crankshaft and flywheel (see Job No. 03-5).  
Disassembly of crankshaft:
  - a) Removal and installation of intermediate piece and crankshaft gear (see Job No. 03-5, section A, item 8).
  - b) Removal and installation of flywheel (see Job No. 03-16).
  - c) Removal and installation of grooved bearing and cap (see Job No. 03-17).
19. Removal and installation of pistons with connecting rods (see Job No. 03-11).
20. Removal and installation of camshaft, camshaft bearings and valve tappets (see Job No. 05-35).

## **B. OM 621**

In an engine has to be completely stripped, the operations of the sections 1 through 20 have to be carried through.

1. Removal and installation of air filter (see Job No. 09-7).
2. Removal and installation of intake line with throttle duct and exhaust manifold (see Job No. 14-1 and 14-5).
3. Removal and installation of starter motor (see Job No. 15-1).
4. Removal and installation of generator (see Job No. 15-11).
5. Removal and installation of water pump with fan (see Job No. 20-5).
6. Removal and installation of injection lines, vacuum line and fuel main filter (see Job No. 07-15 and 09-1).
7. Removal and installation of cylinder head (see Job No. 01-3).  
Disassembly of cylinder head:
  - a) Removal and installation of slide vail in cylinder head (see Job No. 05-29).
  - b) Removal and installation of glow plugs (see Job No. 15-31).
  - c) Removal and installation of nozzle holders with nozzles (see Job No. 07-17).
  - d) Removal and installation of prechambers (see Job No. 01-1).
  - e) Removal and installation of camshaft with bearings (see Job No. 05-36).
  - t) Removal and installation of valves (see Job No. 05-11).
  - g) Removal and installation of idler sprocket and idler sprocket bearing (see Job No. 05-23).
  - h) Removal and installation of guide sprocket (see Job No. 05-25).
8. Removal and installation of oil filter (see Job No. 18-7).
9. Removal and installation of injection pump and fuel feed pump (see Job No. 07-11).
10. Removal and installation of oil pump drive (see Job No. 18-16).
11. Removal and installation of injection timing device (see Job No. 07-25).
12. Removal and installation of injection pump drive (intermediate gear shaft) (see Job No. 05-28).
13. Removal and installation of oil pressure relief valve (see Job No. 18-3).
14. Removal and installation of oil pan (see Job No. 01-21).
15. Removal and installation of oil pump (see Job No. 18-11).
16. Removal and installation of crankshaft with flywheel (see Job No. 03-5).  
Disassembly of crankshaft:
  - a) Removal and installation of counterweight, seal ring, spacer ring, oil thrower ring, crankshaft gear spacer washer (see Job No. 03-5, section B, item 7).
  - b) Removal and installation of flywheel (see Job No. 03-16).
  - c) Removal and installation of annular grooved bearing and cap (see Job No. 03-17).