

- 1.) Drain engine oil.
- 2.) Loosen all 14 oil pan screws, remove oil pan, possibly persuade with easy jarring blow of a rubber hammer. Clean and degrease sealing surface and screw holes.
- 3.) Remove hooks, perforated plate and slot sheet metal (missing on older models). Hooks can possibly re-bend, if so these can be re-used later.
- 4.) Loosen 2 screws of the oil intake bell (sits very firmly). Degrease bell, remove seal, clean and degrease all sealing surfaces and threads. The removed suction bell may not be re-used in any case; designation on new suction bell: 37
- 5.) Install and seal intake bell 37 with two socket head screws (black) M6 x 35 DIN 912 (with integrated washers). These screws are sealed with thread lock (threaded part blue = thread lock high-strength) and may be used only once! Re-use only in exceptional cases, then install with LOCTITE 2701 (green). Clean threads thoroughly if you must reuse. Loosening these screws during install results inevitably in major damage to the engine!! Screw torque: 9 +1 Nm. Install slot sheet metal, perforated plate and handle. Ensure perfect alignment of the handle!
- 6.) On oil pan sealing surface a make a continuous bead with 3-Bond 1209 B. Apply sparingly and as per guidance on tube. Leave in the open to set. Make bead around screw holes. Place seal in location and press in slightly, Apply sealing compound. To set leave in open, place intermediate ring etc.
- 7.) Screw on extension ring to motor with 14 countersunk screws M6 x 55 DIN 7991. Tighten screws crosswise from the center outward in three steps (see pattern sketch). Place a drop of oil onto screw head and threaded part.
Torque 7 +2 Nm. Do not use thread lock with these screws!!
- 8.) Install oil drain plug M18 x 1.5 with sealing ring C18 gently, torque 20 +2 Nm.
- 9.) Put sealing ring C12 on plug M12 x 1.5 (or temperature senders), oil threads before install.
- 10.) Add fresh engine oil up to the maximum fill marking.
- 11.) After approx. 500 to 1,000 km travel distance check screws and possibly retorque.