



Workshop Manual
competence level 3

TCD 2015

0312 3514 en

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The engine company.

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1 Foreword



- Read and observe the information in this documentation. You will avoid accidents, retain the manufacturer's warranty and possess a fully functional and ready to operate engine.
- This engine is built exclusively for purpose according to the scope of delivery - defined by the equipment manufacturer (use for the intended purpose). Any use above and beyond this is considered improper use. The manufacturer will not be liable for damages resulting from this. The user bears the sole risk.
- Use for the intended purpose also includes observance of the operating, maintenance and repair instructions specified by the manufacturer. The engine may only be used, maintained and repaired by persons who are familiar with this and are aware of the risks involved.
- Make sure that this documentation is available to everyone involved in the operation, maintenance and repair and that they have understood the contents.
- Failure to observe this documentation may lead to malfunctions and engine damage as well as injury to persons for which the manufacturer will not accept any liability.
- Prerequisite for proper maintenance and repair is the availability of all the necessary equipment, conventional and special tools and their perfect condition.
- Engine parts such as springs, clamps, elastic retaining rings etc. pose an increased risk of injury when handled incorrectly.
- The pertinent rules for the prevention of accidents and other generally recognised health and safety regulations must be observed.
- Maximum economy, reliability and long life is only guaranteed when using DEUTZ original parts.
- Repair of the engine must correspond to its use for the intended purpose. Only parts released by the manufacturer for the respective purpose may be used for conversion work. Unauthorised modifications to the engine exclude manufacturer liability for resulting damages. Failure to observe this will void the warranty!
- The engines made by DEUTZ are developed for a wide range of applications. A wide range of variants ensures that the respective special requirements are met.
- The engine is equipped according to the installation case, i.e. not all the parts and components described in this documentation are installed in your engine necessarily.
- We have done our best to highlight the differences so that you can easily find the operating, maintenance and repair instructions relevant to your engine.

We are at your service for any questions you may have in this matter.

Your DEUTZ AG





2 General



DEUTZ engines are the product of years of research and development. The profound expertise gained through this, in combination with high demands on quality, attests to the fact that our engines possess all the qualities of long life, high reliability and low fuel consumption. It goes without saying that the high environmental protection requirements are also met.

Maintenance and care are the only way the engine can satisfy the demands you make on it. Compliance with the prescribed maintenance times and the careful execution of maintenance and care work are therefore essential. Difficult operating conditions, deviating from normal operation, must be particularly heeded.

Please consult one of our service representatives responsible for operating faults and spare parts questions. Our trained specialist personnel ensures fast and professional repairs using original DEUTZ spare parts in the event of damage.

Original spare parts from DEUTZ AG are always manufactured according to the state of the art.



3 User notes

3.1 General

The documentation of the workshop manual has been created based on the engine available at the time of going to press.

There may be deviations in the descriptions, illustrations and parts due to further developments.

The maintenance work described in the operation manual and in the workshop manual must be carried out on schedule and completely. The maintenance personnel must have the necessary technical knowledge to perform the work. Safety and protection devices which are removed during maintenance work must be replaced again afterwards.

Caution!

The rules for the prevention of accidents and the safety regulations must be observed during maintenance work.

Reference is made in the workshop manual job cards to the regulations in chapter 3.2. These must be read before working on the engine and must be strictly followed.

The maintenance intervals and the work to be performed are specified in the maintenance schedule of the operation manual. The job cards contain technical documentation on the execution of maintenance work.

3.2 Specifications

3.2.1 Accident prevention and safety regulations

The legally prescribed rules for the prevention of accidents must be observed. These are available from professional associations or from dealers. These are dependent on the application site, operating mode and the operating and auxiliary materials being used.

Special protection measures are specified depending on the work being carried out, and are identified in the job description.

Among other things it generally applies that:

- for the personnel:
 - Only briefed personnel may operate or maintain the engine. Unauthorised persons are prohibited access to the machine room.
 - Wear close-fitting clothing and ear protectors in the machine room when the engine is in operation.
 - Only deploy trained personnel to do repairs and maintenance work.
 - Do not work on the fuel system when the engine is running. The fuel system is under high pressure - danger of death.
 - Go to the workshop immediately in case of leaks in the fuel system.
- for the engine room:
 - Ensure adequate ventilation (do not cover air shafts).
 - Provide first aid kit and suitable fire extinguishers. Check the filling and readiness for operation regularly.
 - Only store inflammable materials in the machine room if they are essential for operation of the system.
 - Smoking and naked flames are prohibited in the machine room.
- for operation, maintenance and repairs on the engine:
 - Wait 30 seconds after switching off the engine before working on the fuel system.
 - After all work on the fuel system, it must be bled - see the operation manual, chapter "6.2 Fuel system".
 - Only start the engine when all the protective devices have been fitted. Make sure no-one is standing in the danger area.
 - Cleaning, maintenance and repair work may only be performed with the engine at a standstill and secured against starting.
 - Injection lines and high pressure pipes must not be deformed.

- Damaged injection lines and high-pressure pipes must be renewed.
- Injection lines and high pressure fuel lines must never be connected when the engine is running.
- Do not place hands near to a leak in the high pressure fuel system.
- Also carefully check all high pressure components visually before performing tests on the running engine. Wear suitable protective clothing (for example protective glasses). Leaks are a potential source of danger for workshop personnel.
- Even if no leaks are discernible on the high pressure fuel system, the workshop personnel should avoid the immediate danger zone or wear suitable protective clothing (such as protective glasses) when performing tests on the running engine and during the first trial run.
- Always stay out of range of a fuel jet, as it could cause severe injury.
- Smoking is strictly prohibited when working on the fuel system.
- Do not work near to sparks and flames.
- Never disconnect an injector when the engine is running.

3.2.2 Cleanliness instructions and measures for handling the DEUTZ Common Rail System

The DEUTZ Common Rail system used in the DEUTZ engines consists of high-precision components which are exposed to extreme stress. Great attention must be paid to cleanliness when working on the fuel system due to the high precision technology.

Notes and measures to be observed before starting work on the fuel system

- The fuel system must be closed. Make a visual inspection for leaks / damage to the fuel system.
- Clean the whole engine and engine room with the system closed before starting work on the fuel system.
- The engine must be dry when you start working on the fuel system.
- Blowing (dry) with compressed air is only permissible with the fuel system closed.
- When using a steam jet, first cover up the control unit, the cable plugs, all other electrical plug connections and the generator. Also, the steam jet may not be pointed directly at them.
- Electrical plug connections must be plugged when spraying.
- Remove loose parts (for example paint chips from assembly work) with an industrial vacuum cleaner or other suction device. Only suction may be used in assembly work on the open fuel system.
- Only work on the fuel system in a clean environment (no dust, no grinding or welding). Avoid draughts (dust). Clean the workshop floor regularly. No brake or performance test benches may be kept or operated in the same room.
- Air currents which kick up dust, such as those caused by brake repairs or the starting of engines, should be avoided.
- For work such as removal and installation on defective hydraulic components on the Common Rail System it is recommended to partition off a separate workshop area in the factory. This must be separate from other areas in which general vehicle repairs such as brake repairs are carried out.
- No general machine tools may be operated in this room.
- Regular cleaning of the workshop area is mandatory. Draughts, ventilation systems and heating fans should be minimised.
- Areas of the engine room from which particles of dirt could be loosened (for example the bottom part of the tipped driver cab) must be covered with fresh clean film.
- Working materials and tools must be cleaned before work. Only use tools without damage to the chrome plating or tools which are not chrome-plated.

Notes and measures to be observed during work on the fuel system or with the fuel system open.

- Only work in clean overalls.
- Only lint-free cleaning cloths may be used for work on the fuel system.
- Remove loose parts (for example paint chips from assembly work) with an industrial vacuum cleaner or other suction device. Only suction may be used in assembly work on the open fuel system.
- Working materials and tools must be cleaned before work. Only use tools without damage to the chrome plating or tools which are not chrome-plated.
- Do not use used cleaning fluid or test fluid for cleaning.
- Compressed air must not be used for cleaning on the open fuel system.
- Work on removed components may only be performed at a suitably equipped workbench.

- When removing and installing components, no materials which can leave behind particles or fibres (cardboard, wood, cloths) may be used.
- Removed parts may only be rubbed down with clean, lint-free cloths. No dirt particles may be rubbed into the components.
- Openings on the components and on the engine must be closed immediately with suitable stoppers/caps.
- The stoppers/caps may only be removed immediately before installing.
- Store stoppers/caps free from dust and dirt in the original packaging and dispose of after using once.
- Only remove new parts from the original packaging just before installation.
- Removed components must be kept in new, sealable bags or - if available - in the packaging of the new parts.
- Always use the original packaging of the new part to send back the removed components.

Notes and measures for the vehicle workshop area

- For work such as removal and installation on defective hydraulic components on the Common Rail System it is recommended to partition off a separate workshop area in the factory. This must be separate from other areas in which general vehicle repairs such as brake repairs are carried out.
- The workshop floor is sealed or tiled.
- No welding gear, grinders, general machine tools, brakes or performance test benches may be operated in this room.
- Regular cleaning of the workshop area is mandatory. Draughts, ventilation systems and heating fans should be minimised.

Notes and measures for workbench and tools in the vehicle hall

- A special workbench must be set up for work on removed components.
- Clean the removal and installation tools regularly and keep them in a closed tool cabinet.
- Remove loose parts (for example paint chips from assembly work) with an industrial vacuum cleaner or other suction device.
- Working materials and tools must be cleaned before work. Only use tools without damage to the chrome plating or tools which are not chrome-plated.

3.2.3 Disposal regulations

The work described in the operation manual and workshop manual necessitates renewal of parts and

operating materials among other things. The renewed parts / operating materials must be stored, transported and disposed of according to regulations. The owner himself is responsible for this.

Disposal includes recycling and the scrapping of parts / operating materials, although recycling has priority.

Details of disposal and their monitoring are governed by regional, national and international laws and directives which the system operator must observe on his own responsibility.

3.3 Operation manual and workshop manual

To structure the information to suit the user, the service documentation is divided into operation manual and workshop manual.

The operation manual contains a general description and instructions for all other maintenance work.

It contains the following chapters:

1. Contents, General
2. Engine description
3. Operation
4. Operating media
5. Maintenance
6. Care and maintenance work
7. Faults, causes and remedies
8. Engine conservation
9. Technical data
10. Service

The workshop manual assumes knowledge of the contents of the operation manual. This applies especially for the safety regulations. The workshop manual describes repairs to the engine and components for which more effort and appropriately qualified technicians are required.

3.4 Job cards

The job cards are divided in the workshop manual into "W" and "I" job cards.

The "W" job card documents standard repairs on the engine and/or its components. The necessary tools and special tools are also specified in the "W" job card.

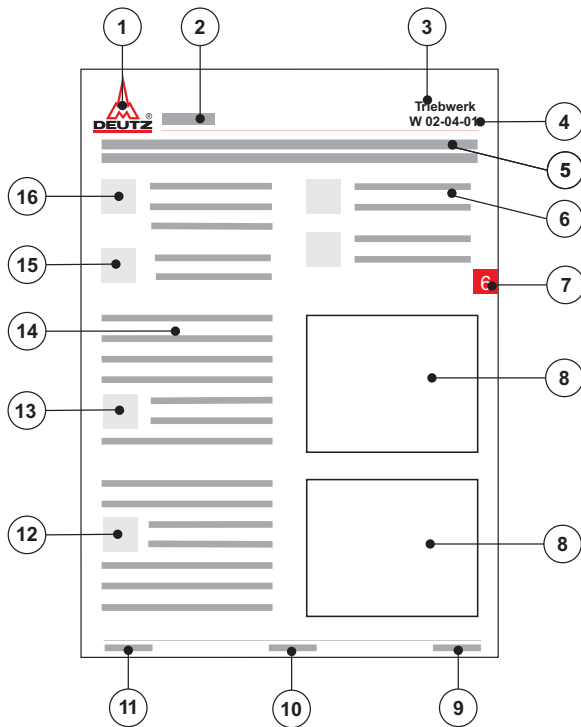
The "I" job card additionally documents the appropriate work procedures for repairing the engine and/or its components. The workshop must satisfy special conditions to perform these work procedures. Special tools and machine tools must be available, for example.

3.4.1 Numbering of job cards

The job card numbers follow the pattern **W 02-04-01**. The individual parts of this pattern are explained below:

- **W 02-04-01**: Documentation type
 - **W**... Workshop manual
 - **I**..... Repair instructions
- **W 02-04-01**: Maintenance group
 - 00 ... General / interdisciplinary activities
 - 01 ... Cylinder head
 - **02** ... Drive system
 - 03 ... Crankcase
 - 04 ... Engine control system
 - 05 ... Speed governing
 - 06 ... Exhaust system / Charging
 - 07 ... Fuel system
 - 08 ... Lube oil system
 - 09 ... Cooling system
 - 10 ... Compressed air system
 - 11 ... Monitoring system
 - 12 ... Other components
 - 13 ... Electrical system
- **W 02-04-01**: Component grouping
- **W 02-04-01**: Consecutive number

3.4.2 Structure of a job card



1. DEUTZ AG, publisher of service documentation
2. Engine type (e.g. TCD 2013 4V)
3. Maintenance group
4. Job card number or topic
5. Title of job card
6. Reference to other job cards
7. Chapter
8. Graphic or photo
9. DEUTZ internal creation number
10. Page number
11. Date of issue of job card
12. Note
13. Danger / Important
14. Work sequence
15. Special tools; auxiliary materials
16. Conventional tools

3.5 Explanation of symbols



Danger!

of death or to health. Must be observed!
For example: The incorrect use or conversion of the turbocharger can lead to serious injury.



Caution!

Danger to the component/engine. Non-compliance can lead to destruction of the component/engine. Must be observed!



Note

General notes on assembly, environmental protection etc. No potential danger for man or machine.



Tool

Conventional and special tools required for the work.



Auxiliary materials

Working materials required in addition to the tools for performing the work (e.g. greases, oils, adhesives, sealants)



References

to important documents or job cards for the work process.
For example: Job card W 04-05-05



Reference

to a document or a job card within the work process.



Test and setting data

The necessary values are specified here. If several values are necessary, a cross reference is given to the Test and Setting Values table.

For example:

ID no. P01 61 = valve clearance, inlet



Tightening specification

The necessary values are specified here. If several values are necessary, a cross reference is given to the Tightening Specifications table.

For example:

ID no. A01 001 = cylinder head screws

4 Technical data

4.1 Testing and setting data



ID no.	Name	Information	Series	Value	Unit
General engine data					
P00 01	Length of engine	about all data	TCD 2015	V06 1200	mm
	Length of engine with connection housing		TCD 2015 (Railway)	V06 1107	mm
P00 02	Width of engine	about all data	TCD 2015 (Railway)	V08 1454	mm
	Width of engine with connection housing		TCD 2015	V06 1200	mm
P00 03	Height of engine	about all data	TCD 2015 (Railway)	V06 1125	mm
	Height of engine with connection housing		TCD 2015 (Railway)	V08 1120	mm
P00 04	Engine weight according to DIN 70020-A	without operating media	TCD 2015	V06 1300	mm
			TCD 2015 (Railway)	V06 835	mm
P00 10	Working principle		TCD 2015 (Railway)	V08 837	mm
			TCD 2015	V06 approx. 1020-1200	kg
P00 20	Combustion process		TCD 2015	V08 1244	kg
			TCD 2015 (Railway)	V06 920	kg
P00 30	Total volume		TCD 2015	V08 1160	kg
			TCD 2015 (Railway)	V06 4 stroke	-
P00 31	Bore		TCD 2015	V06 Direct injection	-
			TCD 2015 (Railway)	V06 11906	cm ³
			TCD 2015	V08 15874	cm ³
			TCD 2015	V06 132	mm

5 Job card overview

5.1 Sorted alphabetically

Activity	Job card	Maintenance group
Checking and setting fuel injectors	W 07-07-05	Fuel system
Checking and setting plunger lift of injection pumps	W 07-06-04	Fuel system
Checking axial backlash of crankshaft (crankshaft installed)	W 02-01-04	Drive system
Checking axial backlash of crankshaft (crankshaft removed)	W 02-01-04	Drive system
Checking piston overhang	W 01-04-09	Cylinder head
Checking the camshaft	W 04-05-06	Engine control
Checking the compression pressure	W 00-02-06	General
Checking the con rod	W 02-03-01	Drive system
Checking the crankshaft	W 02-01-07	Drive system
Checking the overhang of the cylinder liner	W 03-03-08	Crankcase
Checking the piston	W 02-09-07	Drive system
Checking the piston rings and piston ring grooves	W 02-10-03	Drive system
Checking the valve guide	W 01-06-03	Cylinder head
Checking the valve lag	W 01-07-08	Cylinder head
Checking the valves	W 01-05-04	Cylinder head
Checking thermostat (removed state)	W 09-08-01	Cooling system
Disassembling, assembling and checking the rocker arm and rocker arm bracket	W 01-02-06	Cylinder head
Dismantling and assembling fuel injector	W 07-07-02	Fuel system
Dismantling and assembling genset support	W 03-08-03	Crankcase
Grinding the cylinder head sealing surface	I 01-04-08	Cylinder head
Installing and removing turning gear	W 04-06-03	Engine control
Mounting engine on assembly block and demounting	W 00-05-01	General
Removing and installing charge air pipe (A-bank)	W 06-07-03	Exhaust system / Charging
Removing and installing charge air pipe (B-bank)	W 06-07-03	Exhaust system / Charging
Removing and installing connecting pipe	W 06-02-05	Exhaust system / Charging
Removing and installing connecting pipe (Railway)	W 06-02-05	Exhaust system / Charging
Removing and installing coolant pump	W 09-07-08	Cooling system
Removing and installing crankcase breather (oil separator)	W 03-01-11	Crankcase
Removing and installing exhaust line (A-bank)	W 06-01-05	Exhaust system / Charging
Removing and installing exhaust line (B-bank)	W 06-01-05	Exhaust system / Charging
Removing and installing exhaust manifold	W 06-01-07	Exhaust system / Charging

Activity	Job card	Maintenance group
Removing and installing small end bush	I 02-03-03	Drive system
Removing and installing tappets, checking tappet bores	W 04-02-02	Engine control
Removing and installing temperature transmitter	W 07-09-01	Fuel system
Removing and installing temperature transmitter	W 09-12-01	Cooling system
Removing and installing the cable harness	W 13-01-02	Electrical system
Removing and installing the camshaft	W 04-05-05	Engine control
Removing and installing the charge air line	W 06-02-03	Exhaust system / Charging
Removing and installing the connection housing	W 03-09-04	Crankcase
Removing and installing the crankshaft	W 02-04-01	Drive system
Removing and installing the cylinder head	W 01-04-04	Cylinder head
Removing and installing the cylinder liner	W 03-03-02	Crankcase
Removing and installing the fuel injectors	W 07-07-01	Fuel system
Removing and installing the fuel supply pump	W 07-11-01	Fuel system
Removing and installing the gearcase cover	W 04-04-09	Engine control
Removing and installing the generator (V-belt drive)	W 13-02-03	Electrical system
Removing and installing the impulse transmitter (camshaft)	W 05-07-03	Speed governing
Removing and installing the impulse transmitter (crankshaft)	W 05-07-01	Speed governing
Removing and installing the lubricating oil pan	W 08-04-07	Lube oil system
Removing and installing the oil cooler	W 08-08-02	Lube oil system
Removing and installing the oil suction pipe	W 08-04-06	Lube oil system
Removing and installing the piston and con rod	W 02-09-03	Drive system
Removing and installing the piston cooling nozzle	W 02-15-01	Drive system
Removing and installing the rocker arm and rocker arm bracket	W 01-02-02	Cylinder head
Removing and installing the starter	W 13-03-02	Electrical system
Removing and installing the valves	W 01-05-01	Cylinder head
Removing and installing thermostat	W 09-08-02	Cooling system
Removing and installing thermostat housing	W 09-08-04	Cooling system
Removing and installing torsional vibration damper	W 12-01-04	Other components
Removing and installing turbocharger	W 06-06-04	Exhaust system / Charging
Removing and installing turbocharger (A-bank) (Railway)	W 06-06-04	Exhaust system / Charging
Removing and installing turbocharger (B-bank) (Railway)	W 06-06-04	Exhaust system / Charging
Removing and installing, testing camshaft bearing	W 03-11-01	Crankcase

5.2 Sorted numerically

Job card	Activity	Maintenance group
I 01-04-08	Grinding the cylinder head sealing surface	Cylinder head
I 01-06-04	Renewing valve guide (oversize, pressed version)	Cylinder head
I 01-07-09	Replacing valve seat insert (oversize)	Cylinder head
I 02-03-03	Removing and installing small end bush	Drive system
I 03-10-05	Repairing the collar rest of the cylinder liner	Drive system
W 00-02-06	Checking the compression pressure	General
W 00-05-01	Mounting engine on assembly block and demounting	General
W 01-01-01	Setting valve clearance	Cylinder head
W 01-02-02	Removing and installing the rocker arm and rocker arm bracket	Cylinder head
W 01-02-06	Disassembling, assembling and checking the rocker arm and rocker arm bracket	Cylinder head
W 01-04-04	Removing and installing the cylinder head	Cylinder head
W 01-04-09	Checking piston overhang	Cylinder head
W 01-05-01	Removing and installing the valves	Cylinder head
W 01-05-04	Checking the valves	Cylinder head
W 01-06-03	Checking the valve guide	Cylinder head
W 01-07-08	Checking the valve lag	Cylinder head
W 02-01-04	Checking axial backlash of crankshaft (crankshaft removed)	Drive system
W 02-01-04	Checking axial backlash of crankshaft (crankshaft installed)	Drive system
W 02-01-07	Checking the crankshaft	Drive system
W 02-02-02	Renewing the crankshaft sealing ring (flywheel side)	Drive system
W 02-02-04	Renewing the crankshaft sealing ring (opposite side to flywheel)	Drive system
W 02-03-01	Checking the con rod	Drive system
W 02-04-01	Removing and installing the crankshaft	Drive system
W 02-09-03	Removing and installing the piston and con rod	Drive system
W 02-09-07	Checking the piston	Drive system
W 02-10-03	Checking the piston rings and piston ring grooves	Drive system
W 02-15-01	Removing and installing the piston cooling nozzle	Drive system
W 03-01-11	Removing and installing crankcase breather (oil separator)	Crankcase
W 03-03-01	Testing the cylinder liner	Crankcase
W 03-03-02	Removing and installing the cylinder liner	Crankcase
W 03-03-08	Checking the overhang of the cylinder liner	Crankcase

Job card	Activity	Maintenance group
W 07-01-02	Removing and installing flame glow plug (Railway)	Fuel system
W 07-01-03	Removing and installing fuel shut-off valve (flame glow plugs)	Fuel system
W 07-01-03	Removing and installing fuel shut-off valve (flame glow plugs) (Railway)	Fuel system
W 07-01-04	Removing and installing fuel pipes (flame glow plugs)	Fuel system
W 07-01-04	Removing and installing fuel pipes (flame glow plugs) (Railway)	Fuel system
W 07-03-01	Renewing injection pipes (A-bank)	Fuel system
W 07-03-01	Renewing injection pipes (B-bank)	Fuel system
W 07-04-01	Removing and installing injection pumps (cylinder A1)	Fuel system
W 07-04-01	Removing and installing injection pumps (cylinder A2-B3)	Fuel system
W 07-06-04	Checking and setting plunger lift of injection pumps	Fuel system
W 07-07-01	Removing and installing the fuel injectors	Fuel system
W 07-07-02	Dismantling and assembling fuel injector	Fuel system
W 07-07-05	Checking and setting fuel injectors	Fuel system
W 07-09-01	Removing and installing temperature transmitter	Fuel system
W 07-10-06	Removing and installing fuel pipes	Fuel system
W 07-10-06	Removing and installing fuel pipes (Railway)	Fuel system
W 07-11-01	Removing and installing the fuel supply pump	Fuel system
W 07-13-01	Removing and installing fuel pressure holding valve	Fuel system
W 07-13-01	Removing and installing fuel pressure holding valve (Railway)	Fuel system
W 08-04-06	Removing and installing the oil suction pipe	Lube oil system
W 08-04-06	Removing and installing oil suction pipe (Railway)	Lube oil system
W 08-04-07	Removing and installing the lubricating oil pan	Lube oil system
W 08-04-07	Removing and installing lubricating oil pan (Railway)	Lube oil system
W 08-08-02	Removing and installing the oil cooler	Lube oil system
W 08-11-09	Removing and installing oil pressure pick-up	Lube oil system
W 08-11-10	Removing and installing pressurestat	Lube oil system
W 09-07-08	Removing and installing coolant pump	Cooling system
W 09-08-01	Checking thermostat (removed state)	Cooling system
W 09-08-02	Removing and installing thermostat	Cooling system

5.3 Job card references

00 General

Job card	Activity and additional job cards necessary for its execution				
W 00-02-06	Checking the compression pressure				
	W 01-01-01	W 07-07-01			
W 00-05-01	Mounting engine on assembly block and demounting				
	W 13-02-03				

01 Cylinder head

Job card	Activity and additional job cards necessary for its execution				
W 01-01-01	Setting valve clearance				
	W 04-06-03				
W 01-02-02	Removing and installing the rocker arm and rocker arm bracket				
	W 01-01-01	W 04-06-03	W 07-03-01 (A-bank)	W 07-03-01 (B-bank)	
W 01-02-06	Disassembling, assembling and checking the rocker arm and rocker arm bracket				
	W 01-02-02				
W 01-04-04	Removing and installing the cylinder head				
	W 01-02-02	W 01-04-09	W 06-01-05 (A-bank)	W 06-01-05 (B-bank)	W 06-07-03 (A-bank)
	W 06-07-03 (B-bank)	W 07-07-01			
I 01-04-08	Grinding the cylinder head sealing surface				
	W 01-05-01				
W 01-04-09	Checking piston overhang				
	W 01-04-04	W 04-06-03			
W 01-05-01	Removing and installing the valves				
	W 01-04-04				
W 01-05-04	Checking the valves				
	W 01-05-01				
W 01-06-03	Checking the valve guide				
	W 01-05-01				
I 01-06-04	Renewing valve guide (oversize, pressed version)				
	W 01-05-01	W 01-06-03			
W 01-07-08	Checking the valve lag				
	W 01-04-04				
I 01-07-09	Replacing valve seat insert (oversize)				
	W 01-05-01	W 01-07-08			

03 Crankcase (continuation)

Job card	Activity and additional job cards necessary for its execution				
W 03-03-08	Checking the overhang of the cylinder liner				
	W 01-04-04				
W 03-08-01	Removing and installing genset support				
	W 02-02-04	W 06-07-03 (A-bank)	W 06-07-03 (B-bank)	W 08-04-06	W 09-07-08
	W 09-08-04				
W 03-08-03	Dismantling and assembling genset support				
	W 03-08-01				
W 03-09-01	Removing and installing rear cover				
	W 02-02-02	W 03-09-04	W 08-04-07		
W 03-09-04	Removing and installing the connection housing				
	W 05-07-01	W 06-01-07	W 12-06-01	W 13-03-02	
I 03-10-05	Repairing the collar rest of the cylinder liner				
	W 03-03-02				
W 03-11-01	Removing and installing, testing camshaft bearing				
	W 04-05-05				

5

04 Engine control

Job card	Activity and additional job cards necessary for its execution				
W 04-02-02	Removing and installing tappets, checking tappet bores				
	W 04-05-05				
W 04-04-09	Removing and installing the gearcase cover				
	W 06-06-04				
W 04-04-09	Removing and installing gear case cover (Railway)				
	W 07-13-01 (Railway)				
W 04-05-05	Removing and installing the camshaft				
	W 01-02-02	W 02-04-01	W 04-05-06	W 05-07-03	W 06-06-04
	W 07-04-01 (cylinder A1)	W 07-04-01 (cylinder A2-B3)	W 07-06-04		
W 04-05-06	Checking the camshaft				
	W 04-05-05				
W 04-05-07	Removing and installing injection pump camshaft				
	W 01-02-02	W 02-02-02	W 03-08-01	W 03-09-04	W 04-06-03
	W 05-07-03	W 06-06-04	W 07-04-01 (cylinder A1)	W 07-04-01 (cylinder A2-B3)	W 07-06-04

06 Exhaust system / Charging (continuation)

Job card	Activity and additional job cards necessary for its execution				
W 06-02-05	Removing and installing connecting pipe (Railway)				
	W 07-01-04 (Railway)				
W 06-06-04	Removing and installing the turbocharger				
	W 06-02-03				
W 06-06-04	Removing and installing turbocharger (A-bank) (Railway)				
W 06-06-04	Removing and installing turbocharger (B-bank) (Railway)				
W 06-07-03	Removing and installing charge air pipe (A-bank)				
	W 03-01-11	W 06-02-05	W 07-03-01 (A-bank)		
W 06-07-03 (B-bank)	Removing and installing charge air pipe (B-bank)				
	W 06-02-05	W 07-03-01 (B-bank)			

07 Fuel system

Job card	Activity and additional job cards necessary for its execution				
W 07-01-02	Removing and installing flame glow plug				
	W 07-01-04				
W 07-01-02	Removing and installing flame glow plug (Railway)				
	W 07-01-04 (Railway)				
W 07-01-03	Removing and installing fuel shut-off valve (flame glow plugs)				
W 07-01-03	Removing and installing fuel shut-off valve (flame glow plugs) (Railway)				
W 07-01-04	Removing and installing fuel pipes (flame glow plugs)				
	W 06-02-03				
W 07-01-04	Removing and installing fuel pipes (flame glow plugs) (Railway)				
W 07-03-01	Renewing injection pipes (A-bank)				

07 Fuel system (continuation)

Job card	Activity and additional job cards necessary for its execution				
W 07-13-01	Removing and installing fuel pressure holding valve (Railway)				

08 Lube oil system

Job card	Activity and additional job cards necessary for its execution				
W 08-04-06	Removing and installing the oil suction pipe				
	W 08-04-07				
W 08-04-06	Removing and installing oil suction pipe (Railway)				
	W 08-04-07 (Railway)				
W 08-04-07	Removing and installing the lubricating oil pan				
	W 13-03-02				
W 08-04-07	Removing and installing lubricating oil pan (Railway)				
W 08-08-02	Removing and installing the oil cooler				
	W 06-07-03 (A-bank)	W 09-08-04			
W 08-11-09	Removing and installing oil pressure pick-up				
W 08-11-10	Removing and installing pressurestat				
	W 03-01-11	W 06-07-03 (B-bank)			

09 Cooling system

Job card	Activity and additional job cards necessary for its execution				
W 09-07-08	Removing and installing coolant pump				
W 09-08-01	Checking thermostat (removed state)				
	W 09-08-02				
W 09-08-02	Removing and installing thermostat				
	W 09-08-01	W 09-08-04			
W 09-08-04	Removing and installing thermostat housing				
	W 07-01-04				



6 Job cards

Checking the compression pressure



Commercial available tools:
– Compression pressure tester..... 8005

Special tools:
– Connector..... 100130
– Grooved nut wrench..... 110130



– W 01-01-01
– W 07-07-01

Checking the compression pressure

- Check and set valve clearance.

W 01-01-01

- Removing fuel injectors.

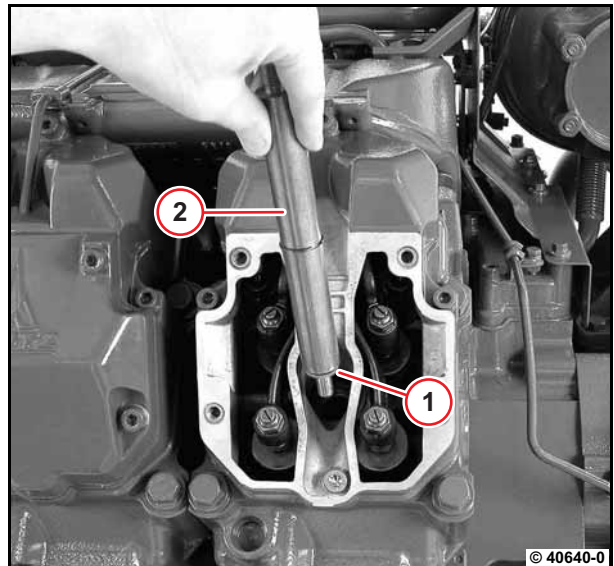
W 07-07-01

- Mount sealing ring (1).



Use sealing ring (1) for fuel injector.

- Insert connector (2).



- Tighten union screw with grooved nut wrench.

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