

WORK DESCRIPTION FOR FIELD MEASURE

Code: 21P1591015

Version: 2.0

Replace bolts for centering flange on integrated starter-alternator

Model 167 with M177

Work procedure

1. Remove transmission with torque converter
 - i** For basic data, see **AR27.10-P-0500MNO**
2. Replace **external** Torx bolts (1 to 4, figure 1) for centering flange on integrated starter-alternator.
 - i** Replace bolts individually in succession.
 - Nm** Bolt, centering flange to starter-alternator 1st phase **45 Nm** – 2nd phase **90°**
 - i** Secure engine against turning.

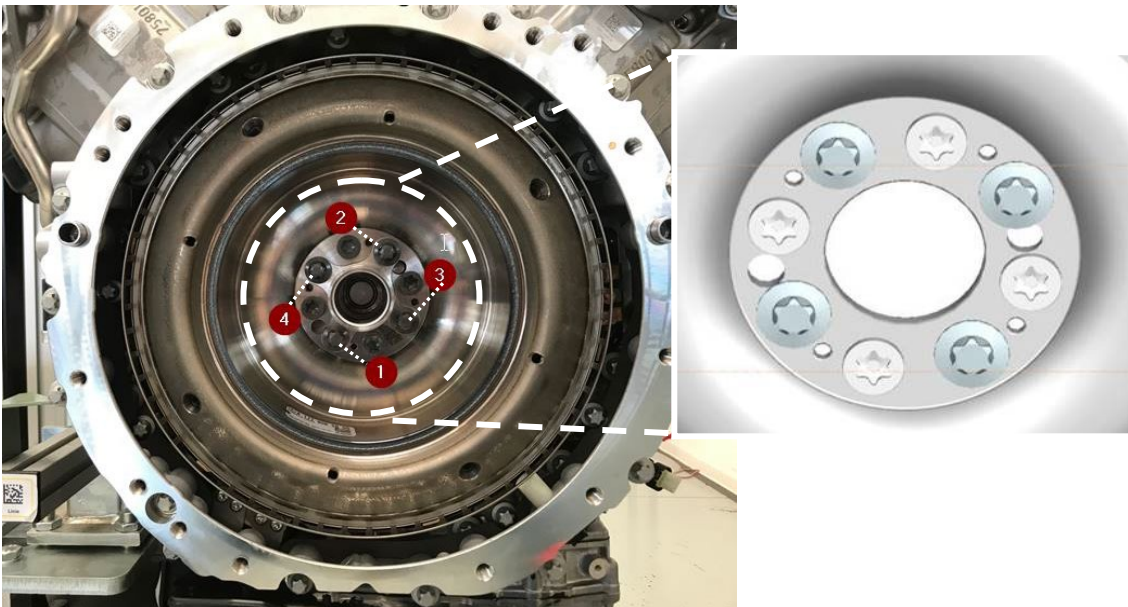


Figure 1

3. Install in the reverse order

Parts

Quantity	Designation	Part no.
4	Torx bolts 55	A 012 990 58 04

i Small parts such as screws/bolts, lock nuts, sealing rings, cable ties, fluids, sealant etc. are not listed in the parts list. The required small parts are taken into account in the budgeting.

Operation text and flat rate

Operation no.	Operation text	Flat rate	Accounting no./damage code
02-0819	Replace threaded connection of integrated starter alternator	12.1 h	15 910 15

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