

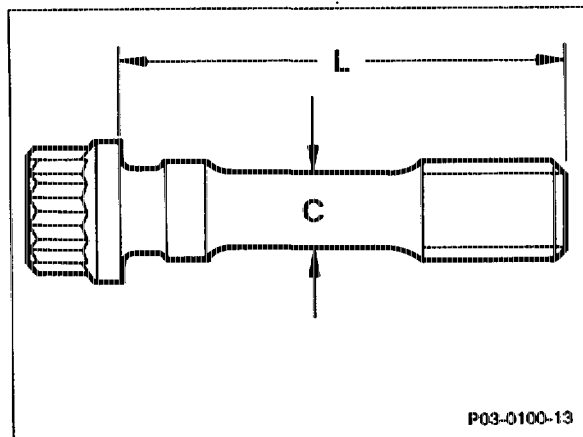
03-3100 Checking, replacing and tightening conrod bolts

Operation no. of operation texts and work units or standard texts
and flat rates:
03-4341, 4351

Stretch shank bolt (1st version) ¹⁾

Conrod bolt part no.	102 038 00 71
Thread dia.	M 9 × 1
Stretch shaft dia. (c) when new	7,4-0,1
Minimum stretch shaft dia. (c)	7,1
Length (L) when new	52-0,3

¹⁾ Engine 104.98 up to 11/90



Tightening torque in Nm or tightening angle

Stretch shank bolt	Initial torque ²⁾	30
	Tightening angle	90-100°

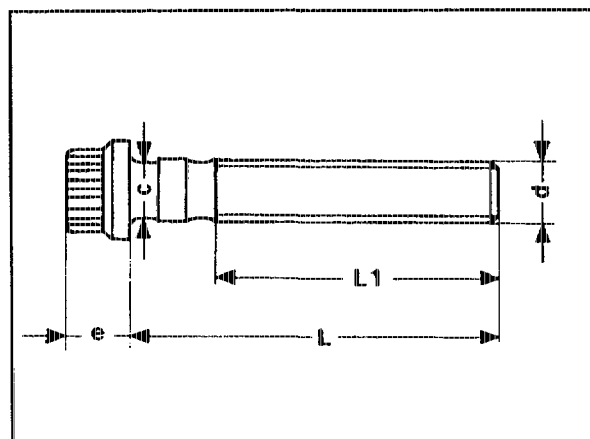
²⁾ Thread and contact surface of bolt moistened with engine oil when installing.

Straight stretch shank bolt (2nd version) ³⁾

Conrod bolt part no.	102 038 02 71
Thread dia. (d)	M 9 × 1
Length (L) when new	52-0,3 ⁴⁾

³⁾ Engine 104.98/104.99 as of 11/90

⁴⁾ Re-use conrod bolt up to max. 52.9 mm.



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Tightening torque in Nm or tightening angle

Straight stretch shank bolt	Initial torque ²⁾	30 (40) ⁵⁾
	Tightening angle	90-100°

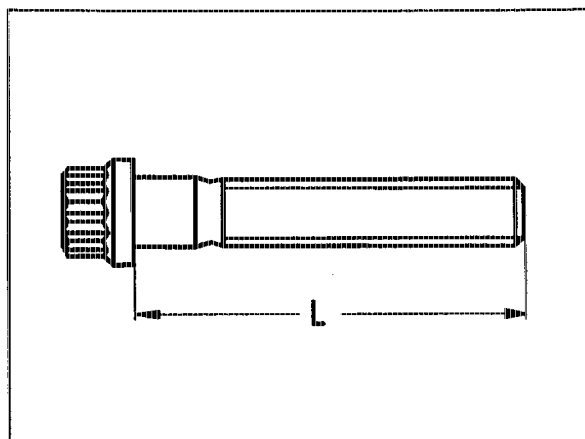
²⁾ Thread and contact surface of bolt moistened with engine oil when installing.

⁵⁾ For first tightening

**Straight stretch shank bolt
(3rd version)**

Conrod bolt part no.	111 038 00 71
Thread dia. (d)	M 9 × 1
Length (L1) when new	52-0.3 ⁴⁾

4) Re-use conrod bolt up to max. 52.9 mm.



P03-5270-13

Tightening torque in Nm or tightening angle

Straight stretch shank bolt ²⁾	Initial torque	First tightening	40
		Re-tightening	30
	Tightening angle		90-100°

²⁾ Thread and contact surface of bolt moistened with engine oil when installing.

Conrod bolts	re-use up to minimum stretch shaft dia. or up to max. stretch shaft length.
Weight	pay attention to differences.
Thread and bolt head contact surface	oil before installing.
Conrod bolts	tighten initially with torque wrench 001 589 66 21 00.
Conrod bolts	tighten with tightening angle wrench. Pay attention to tightening torques.



The conrod bolts differ in weight. Only identical conrod bolts may be installed in an engine.

Note

If no tightening angle wrench is available, the conrod bolt can be tightened further with a socket wrench and tommy bar by the specified angle in a single tightening operation. A flexi-rod torque wrench must not be used for tightening to degrees of angle in order to avoid angle errors.

Special tool

