

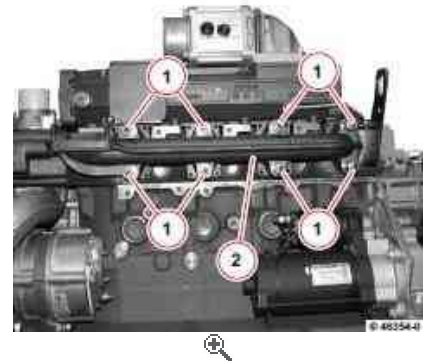


## Removal and refitting of the exhaust manifold

- DEUTZ S1 assembly product

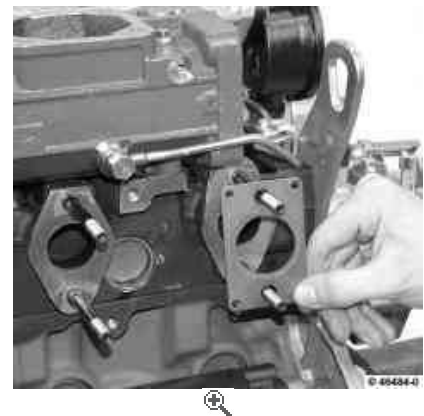
### Removal of the exhaust manifold

- Remove the turbocharger.  
See para.
- Unscrew nuts (1).
- Remove the spacer bushes.
- Remove exhaust manifold (2).



1.

- Remove the gaskets.
- Remove the stud bolts.



2.

- Carry out a visual inspection of the component.



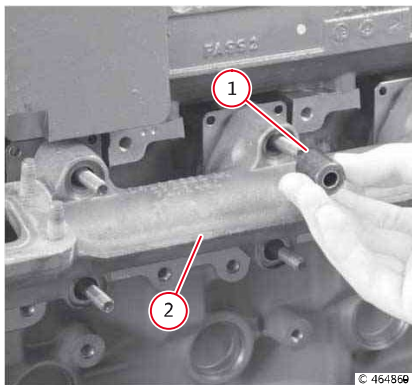
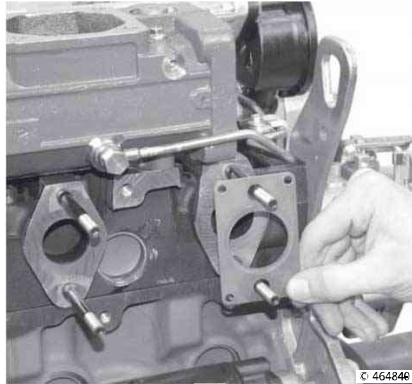
3.

### Refitting the exhaust manifold

- Clean the mating surfaces.
- Apply DEUTZ S1 assembly product to the new stud bolts.
- Fit the new stud bolts.
- Fit the new gaskets.

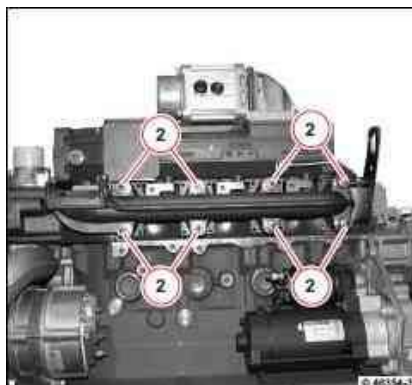
1.

- o Fit exhaust pipe (2).
- o Install spacer bushes (1).



2.

- o Tighten new nuts (2).



3.

- o Tighten all the nuts (1): 25 Nm.



**NOTE**

Tighten in order from inside out, starting from nut (1).

- o Fit the turbocharger.  
See para.



4.



## Removal and refitting of the fuel filter head.

Special tools:

- Special wrench: 170050
- Plugs and caps: 170160



### DANGER

After switching off the engine, wait at least 30 seconds before carrying out any work on the fuel system!



### WARNING

During work on the fuel system always maintain conditions of the maximum cleanliness. Thoroughly clean the area around the components to be worked on. Dry any wet areas with a compressed air jet. When handling fuel observe the safety directives and specific local regulations. All lines and unions should be closed immediately after opening using new, clean plugs or caps. Remove plugs and caps only immediately prior to assembly. Collect operating materials in suitable containers and dispose of them in compliance with the applicable regulations.

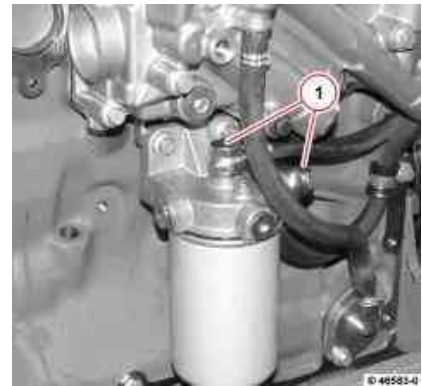
## Removal of the fuel filter head.

- Unscrew hollow screws (1)
- Remove the seals.



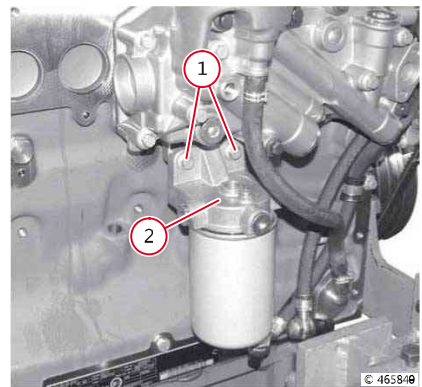
### NOTE

Collect any leaked fuel and dispose of it properly.



1.

- Remove screws (1).
- Remove fuel filter head (2).



2.

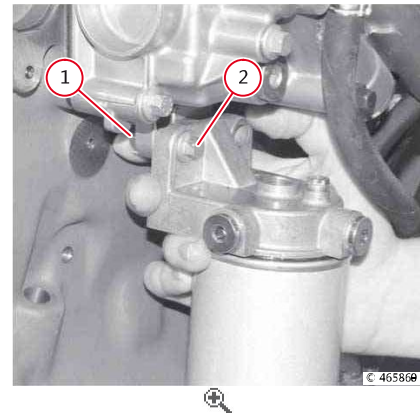
- Carry out a visual inspection of the component.



3.

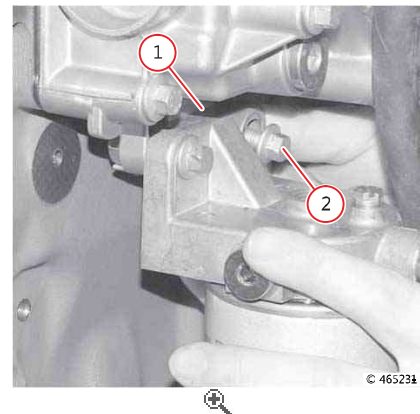
## Refitting the fuel filter head.

- o Fit the fuel filter head.
- o Fit the nut (1).
- o Tighten screws (2).



1.

- o Fit the nut (1).
- o Tighten screws (2).
- o Tighten the screws: 30 Nm.



2.

- o Tighten the hollow screw (1) with the new O-rings: 39 Nm.
- o Tighten the hollow screw (2) with the new O-rings: 39 Nm.



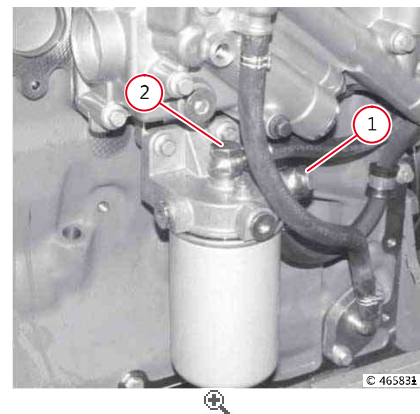
### WARNING

Route the flexible pipe without friction or tension points.



### NOTE

Bleed the fuel system as indicated in the instruction manual, using the hand pump on the fuel pre-filter.



3.



## Assembly and disassembly of the temperature sender



### NOTE:

Collect operating materials in suitable containers and dispose of them in compliance with the applicable regulations.

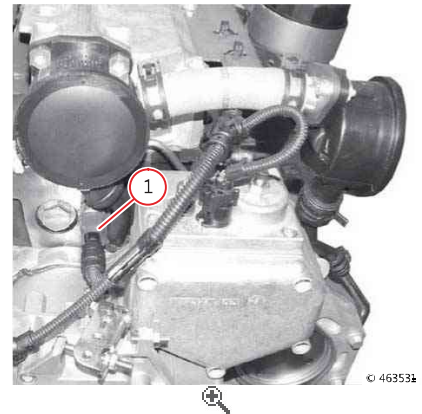


### NOTE:

The draining and replenishing of engine fluids and lubricants must be carried out in accordance with the instructions given in the documentation provided by the manufacturer of the vehicle/appliance.

## Removal of the temperature sender

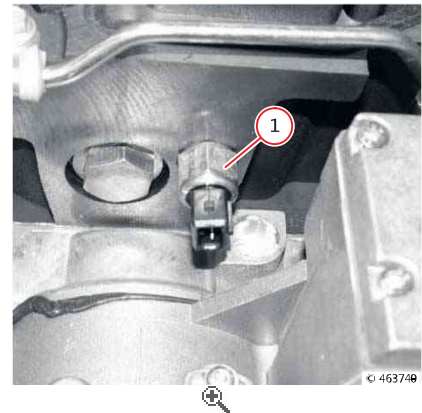
- o Unlock and disconnect wiring connectors (1).



© 463531

1.

- o z Unscrew the temperature sensor (1)



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2.

- o Carry out a visual inspection of the component.



© 440849

3.

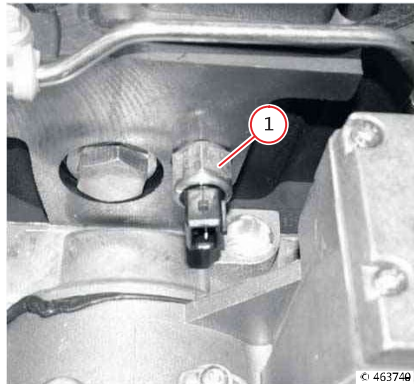
## Refitting the temperature sender

- o Tighten the temperature sender (1): 24 Nm.



### NOTE:

Check that the seal is present.



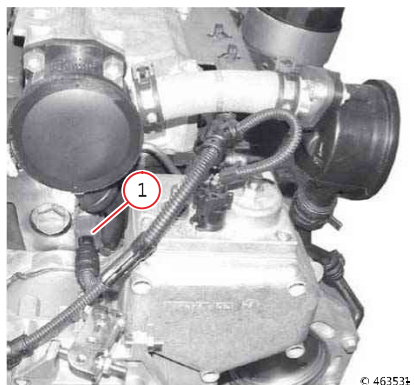
1.

- Reconnect wiring connector (1).



**NOTE:**

Check that the connection is made correctly.



2.

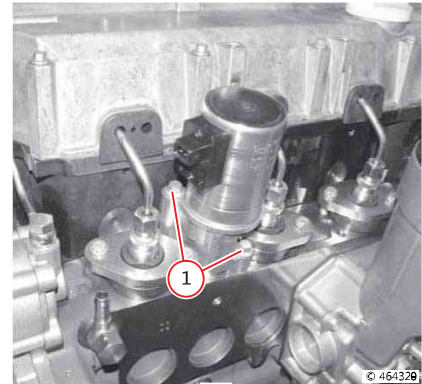




## Removal and refitting the engine block

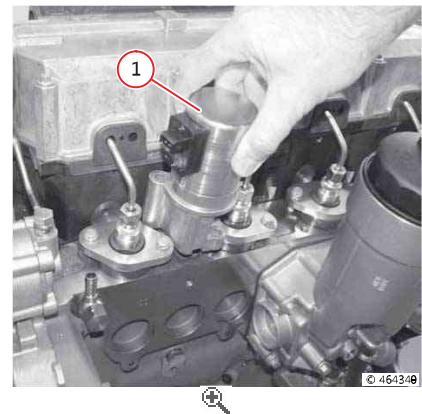
### Removing the engine block

- Remove the hollow connector from the engine block
- Remove screws (1).



1.

- Withdraw the engine block (1).
- Carry out a visual inspection of the components.



2.

### Fitting the engine block



#### WARNING

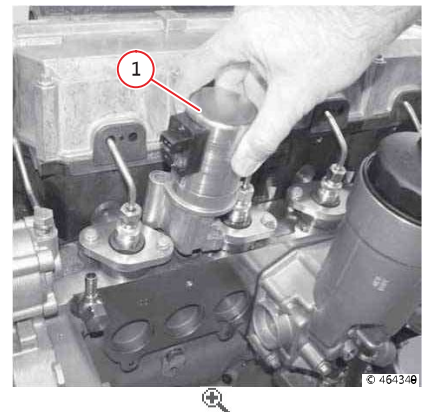
Check the mobility of the adjustment rod.

- Operate the stop lever between the start and stop position.
- Fit a new O-ring (1).
- Lightly lubricate the O-ring.



1.

- Press and hold down the adjustment rod in the stop position, using the stop lever.
- Insert the engine block (1).



2.

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