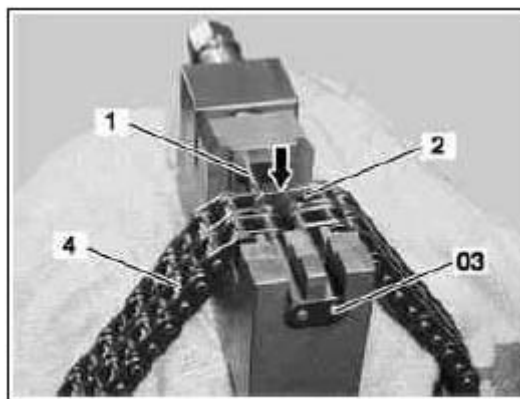


P05.10-2229-01

Fig. 15: Placing Assembly Insert In Rivet Press Tool
 Courtesy of MERCEDES-BENZ USA

3. Insert the riveted link (1), the centering fork (03) and the press-fit center plate (2) into the ends of the timing chain (4), and press the pins of the centering fork (03) into the holes of the press-fit center plate (2) and center the press-fit center plate (2).

i Insert riveted link (1) from the rear.





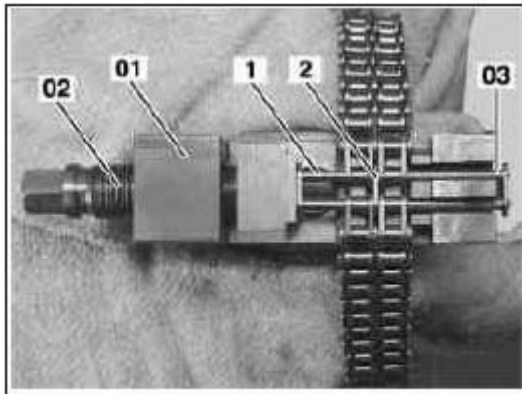
P05.10-2230-01

Fig. 16: Identifying Riveted Link, Centering Fork And Timing Chain
 Courtesy of MERCEDES-BENZ USA

4. ⚙ Screw in the pressure screw (02) at the ⚙ rivet press tool (01), and press the riveted link (1) into the press-fit center plate (2) all the way to the backstop.

i Ensure that the riveted link (1) and the ⚙ rivet press tool (01) are aligned. While screwing in the ⚙ pressure screw (02) ensure that the pins of the riveted link (1) are pressed into the holes of the press-fit center plate (2), and that the centering fork (03) that has been squeezed out does not fall into the timing case recess.





5.  Remove the pressure screw (02) and take off the  rivet press tool (01).

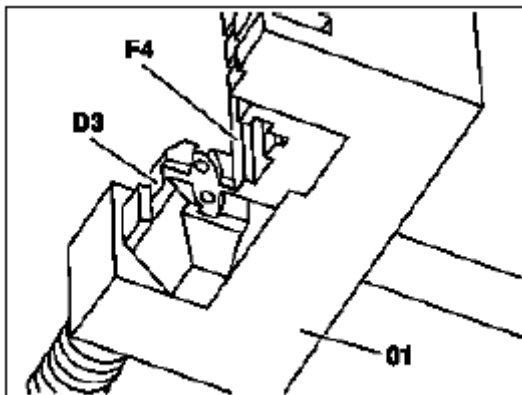


P05.10-2231-01

Fig. 17: Identifying Pressure Screw At Rivet Press Tool
Courtesy of MERCEDES-BENZ USA



Press the outer plate on the riveted link

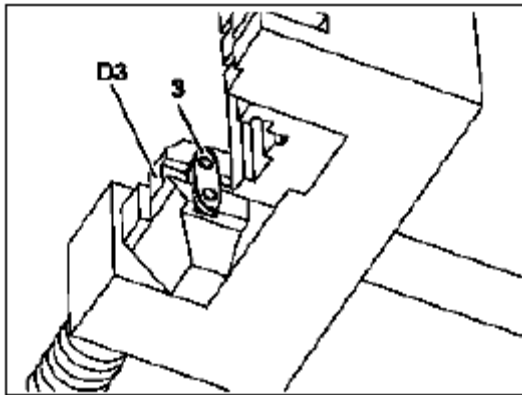
6.  Place the assembly insert (F401) in  the rivet press tool (01) and fix in place with the mounting screw.
7.  Place the assembly insert (01D3) in  the rivet press tool (01).



P05.10-2232-01









Fig. 18: Placing Assembly Insert In Rivet Press Tool
Courtesy of MERCEDES-BENZ USA

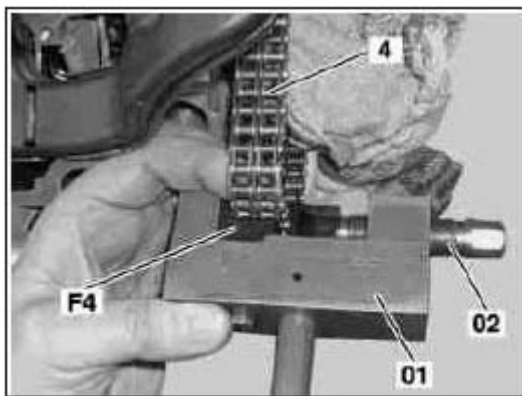
8. Insert the outer plate (3) into the  assembly insert (D3).
 The outer plate (3) is held magnetically.



P05.10-2233-01

Fig. 19: Identifying Outer Plate On Assembly Insert
 Courtesy of MERCEDES-BENZ USA


9.  Place the rivet press tool (01) in such a way that the spacer webs of the  assembly insert (F4) lies on the rolls of the timing chain (4).
-  Ensure that the riveted link (1) and the outer plate (3) are aligned.
10. Screw in the  pressure screw (02) at the  rivet press tool (01) until there is solid resistance.
-  While turning the  pressure screw (02), ensure that the pins of the riveted link (1) are pressed into the outer plate (3).
11.  Remove rivet press tool (01).

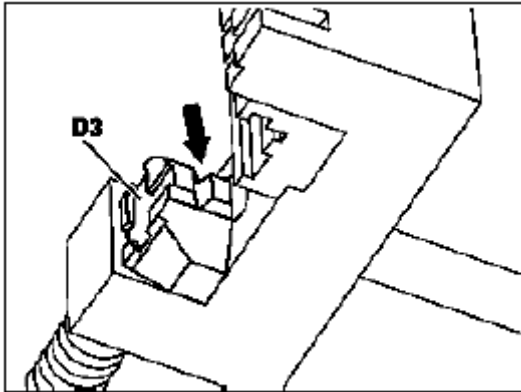


P05.10-2234-01

Fig. 20: Placing Rivet Press Tool
 Courtesy of MERCEDES-BENZ USA








Rivet timing chain

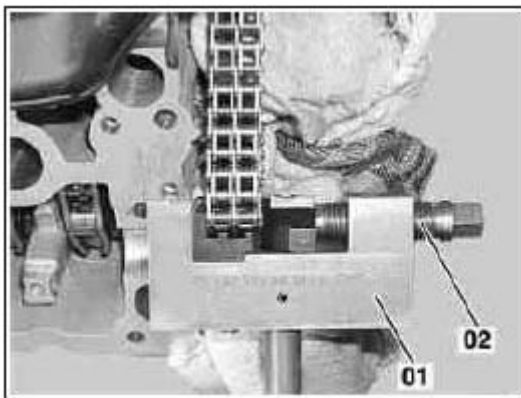
12.  Shift the assembly insert (D3) on the riveted section (arrow).



P05.10-2235-01

Fig. 21: Identifying Assembly Insert
Courtesy of MERCEDES-BENZ USA

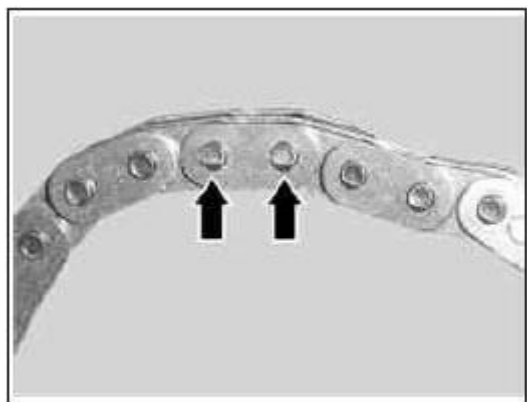
13.  Place the rivet press tool (01) in the center of a riveted link (1) pin.
-  Rivet the pins of the riveted link (1) individually.
14.  Tighten the pressure screw (02) at the  rivet press tool (01).
-  Tightening torque of the  pressure screw (02): reference value 32 Nm.
15.  Remove rivet press tool (01).



P05.10-2236-01

Fig. 22: Identifying Rivet Press Tool And Pressure Screw
Courtesy of MERCEDES-BENZ USA

16.  Inspect riveting (arrows), re-rivet if necessary.



P05.10-2237-01

Fig. 23: Locating Rivets
Courtesy of MERCEDES-BENZ USA

DRAWING IN TIMING CHAIN - AR05.10-P-7601-04VA



Fig. 24: Identifying Case (602 589 00 98 00)
Courtesy of MERCEDES-BENZ USA

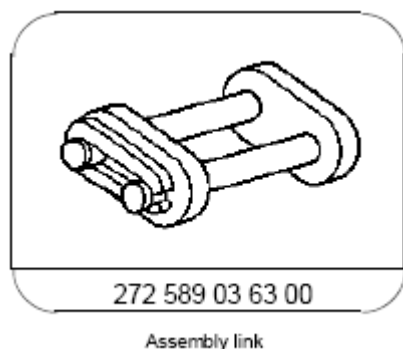


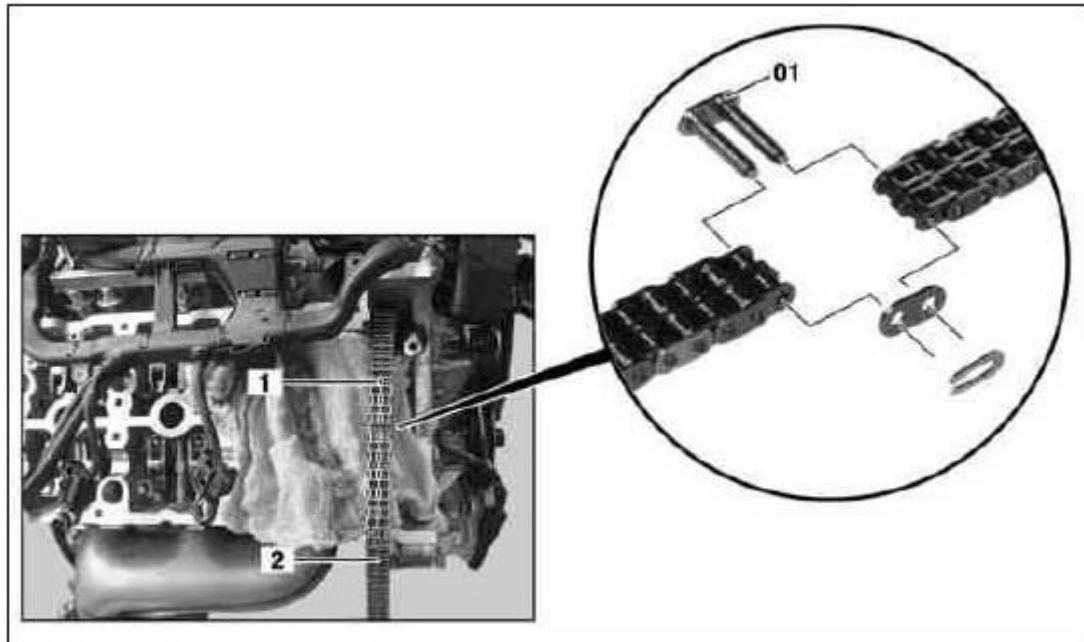
Fig. 25: Identifying Assembly Link (272 589 03 63 00)
Courtesy of MERCEDES-BENZ USA

1. Cover over timing case recess with a clean cloth.

i The timing case recess must be secured against parts falling down. Parts that have fallen into the timing case recess must be removed.

2. Connect the new timing chain (2) and the old timing chain (1) with the assembly link (01).

i **⚠** Fit the lock of the **⚠** assembly link (01) in the direction opposite to that in which the timing chain is drawn; otherwise it could get jammed on the slide rails and come off when the timing chain is drawn.



P05.10-2226-05

Fig. 26: Connecting New And Old Timing Chain
Courtesy of MERCEDES-BENZ USA

3. Remove the rags from the timing case recess.


i Otherwise, they could get pulled into the timing case recess when the engine is cranked.


4. Turn the crankshaft slowly in the engine's direction of rotation (arrow) and draw in the new timing chain (2) until the ends of the new timing chain (2) can be connected.

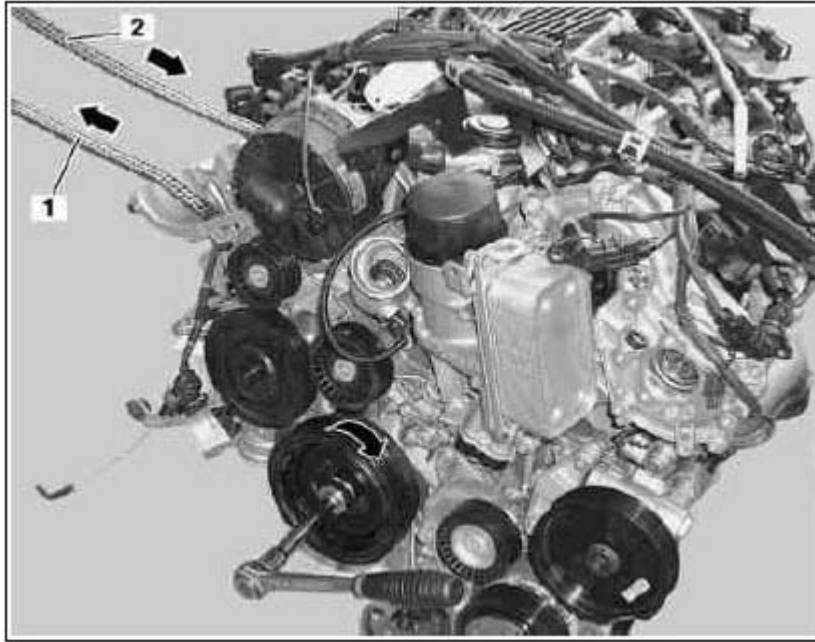
i As the new timing chain (2) is being drawn in (arrows), pull out the end of the old timing chain (1) evenly as it becomes free.

5. Cover over timing case recess with a clean cloth.

i The timing case recess must be secured against parts falling down. Parts that have fallen into the timing case recess must be removed.

6.  Detach the assembly link (01), and separate the old timing chain (1) from the new timing chain (2).

 The assembly link (01) must be removed. The assembly link is only an aid for assembly and is not suitable for engine operation.



P05.10-2227-11

Fig. 27: Drawing In Timing Chain
Courtesy of MERCEDES-BENZ USA

REPLACE TIMING CHAIN - AR05.10-P-7601QB

ENGINE 272.920 in MODELS 203.052/252/752

ENGINE 272.940 in MODELS 203.054/254, 209.354/454

ENGINE 272.960 in MODELS 203.056/256/756, 209.356/456

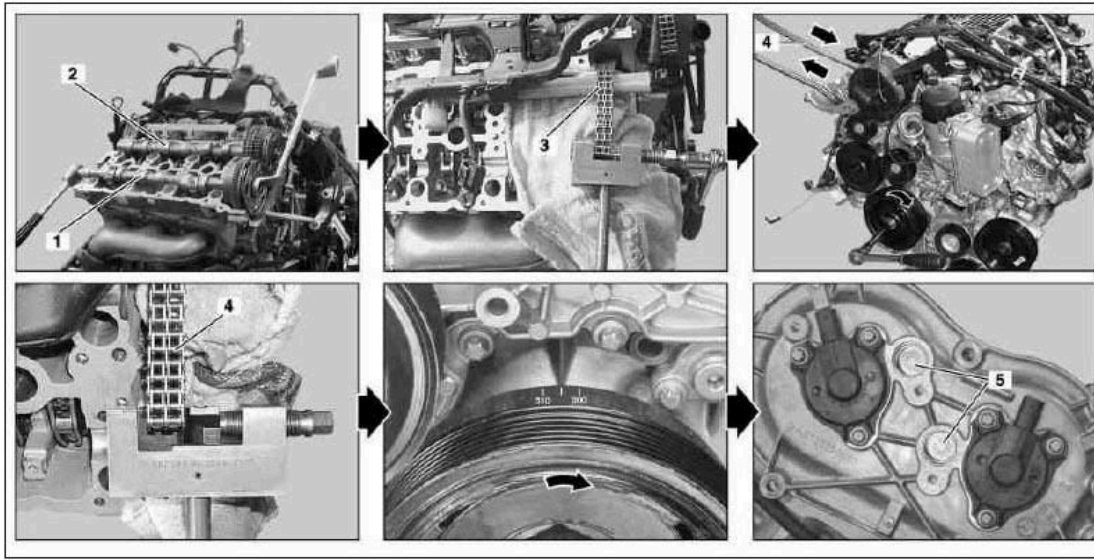
ENGINE 272.970 in MODELS 203.087/287

ENGINE 272.941 in MODELS 203.092/292

ENGINE 273 in MODEL 209

2009 Mercedes-Benz CLK350

2008-09 ENGINE Engine Timing - 209.456 CLK 350 Cabriolet

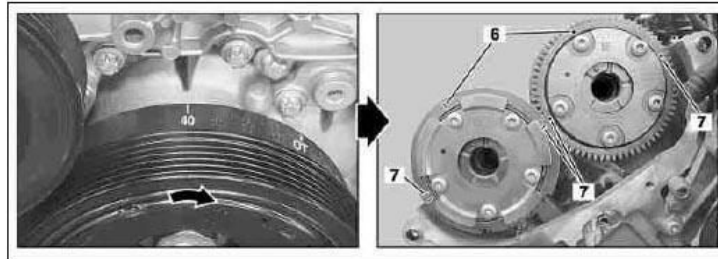


P05.10-2238-09

- | | | |
|---|--|-----------------------------------|
| <p>1 Exhaust camshaft
2 Intake camshaft</p> | <p>3 Old timing chain
4 New timing chain</p> | <p>5 Markings on pulse wheels</p> |
|---|--|-----------------------------------|

Fig. 28: Replacing Timing Chain
Courtesy of MERCEDES-BENZ USA

- | |
|--|
| <p>6 Markings on camshaft adjuster
7 Markings on camshaft adjuster</p> |
|--|



P05.10-2238-04

Fig. 29: Aligning Markings On Camshaft Adjuster
Courtesy of MERCEDES-BENZ USA

☒	Removing		
⚠ Danger!	Risk of injury caused by fingers being pinched or crushed when removing, installing or aligning hoods, doors, trunk lids, tailgates or sliding roof.	Keep body parts and limbs well clear of moving parts.	<u>AS00.00-Z-0011-01A</u>
⚠ Danger!	Risk of explosion caused by oxyhydrogen gas. Risk of poisoning and caustic burns caused by swallowing battery acid. Risk of injury caused by burns to skin and eyes from battery acid or when handling	No fire, sparks, open flames or smoking. Wear acid-resistant gloves, clothing and safety glasses. Only pour battery acid into suitable and appropriately marked containers.	<u>AS54.10-Z-0001-01A</u>