

P01.30-2188-11

**Fig. 12: Identifying Sealant Run On Left Front Cover**  
Courtesy of MERCEDES-BENZ USA

**INFORMATION ON APPLYING SEALANT TO CYLINDER HEAD GASKET - AH01.30-P-1000-04RX**

**Engine 272, 273**

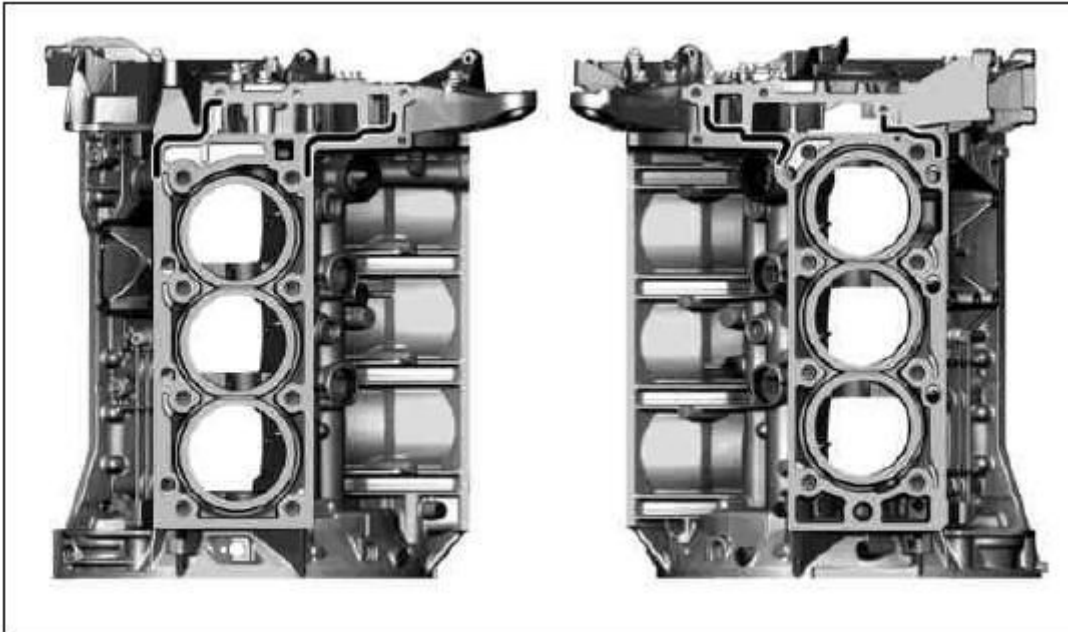
**[i]** Before mounting the cylinder heads, apply sealant around the timing case cover on the cylinder crankcase.

**[i] Repair information**

The sealing surface must be cleaned. Sealant should be applied only to the specified surface, in the form of a bead 2.0 mm (0.5 mm) in height and width (see picture).

The sealant remains workable for 10 min.

The bead should not be spread.



P01.30-2347-05

**Fig. 13: Locating Sealant On Cylinder Head**  
Courtesy of MERCEDES-BENZ USA

#### **INFORMATION ON CYLINDER HEAD CONTACT SURFACE - AH01.30-P-1000-05A**

The cylinder head contact surface should only be machined if there is mechanical damage. It should not be machined (by face grinding) if the contact surface of the cylinder head is uneven (warped) in the longitudinal and transverse directions.

When the cylinder head is mounted again, surface warping will be evened out when the cylinder head bolts are tightened.

Stock removal from the cylinder head and cylinder crankcase of an engine should together be no more than 0.3 mm

If the cylinder head contact surface is machined, the valve seats must be reset.

#### **NOTES ON THE APPLICATION OF SEALING COMPOUND TO THE CYLINDER HEAD COVER - AH01.30-P-1000-08SX**

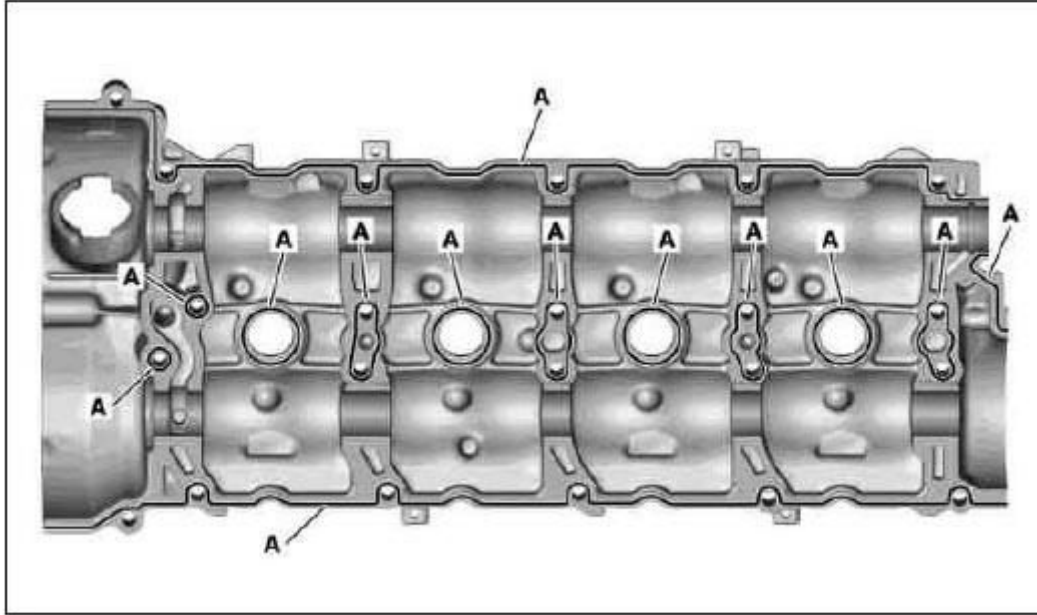
##### **Sealing compound beads on the right cylinder head cover**

**[i]** The lines (A) identify the sealing compound beads.

**[i]** The sealing surface must be cleaned. The sealing compound must only be applied to the specified surface in the form of a bead and a height and width of 1.0 mm ( $\pm 0.2$  mm).

The sealing compound must be applied within 10 minutes.

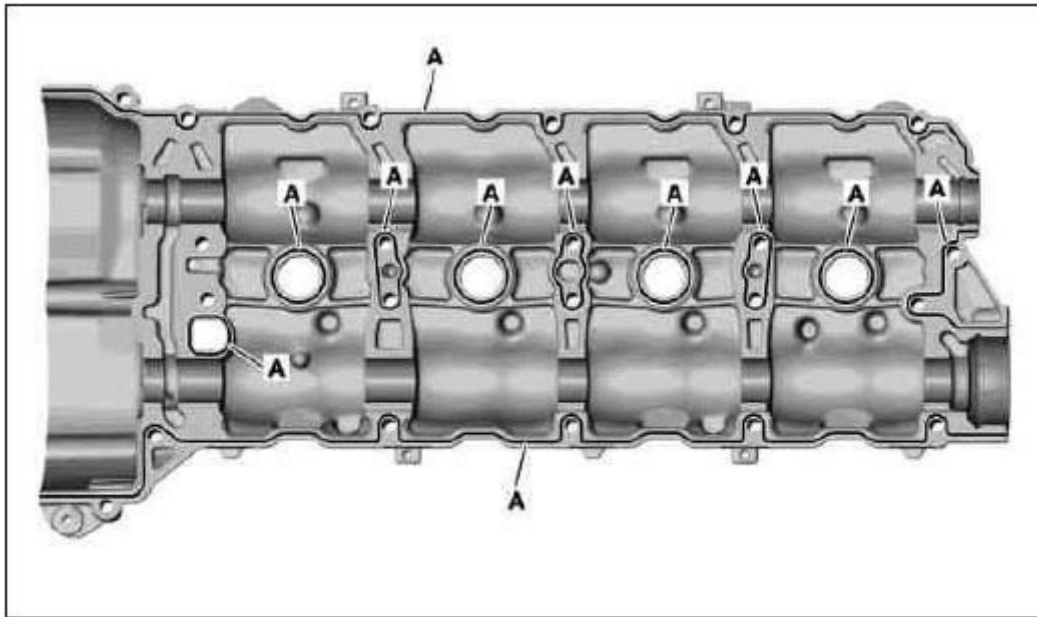
The sealing compound bead must not be spread. Only the approved sealant may be used.



PD1.30-2290-05

**Fig. 14: Identifying Sealing Compound Bead On Right Cylinder Head Cover**  
Courtesy of MERCEDES-BENZ USA

**Sealing compound beads on the left cylinder head cover**



P01.30-2291-05

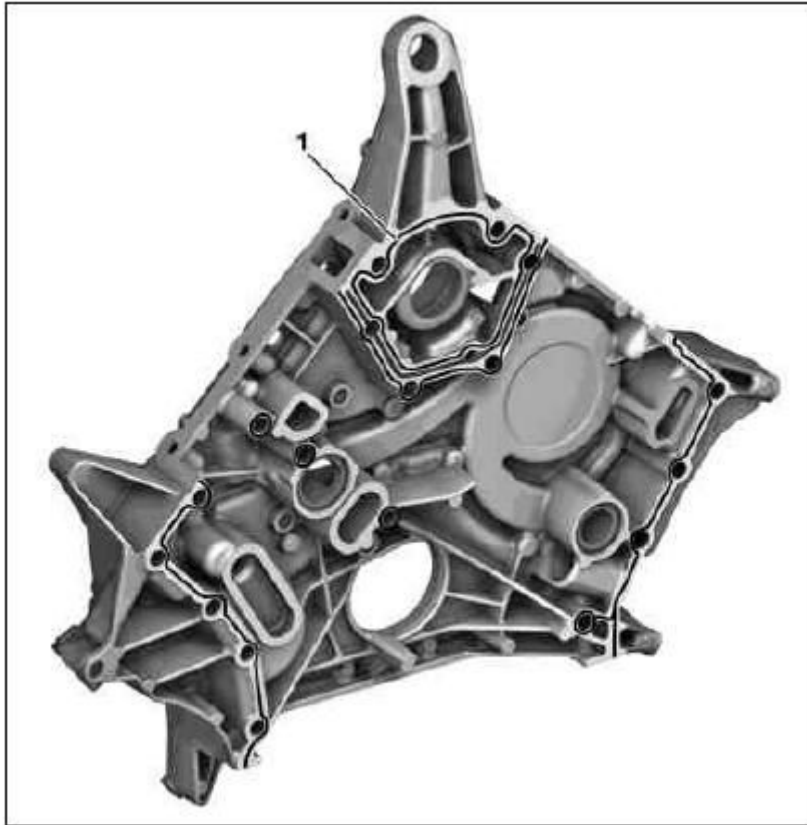
**Fig. 15: Identifying Sealing Compound Bead On Left Cylinder Head Cover**  
Courtesy of MERCEDES-BENZ USA

**NOTES ON SEALANT PATH FOR TIMING CASE COVER - AH01.40-P-1000-01VA**

**Engine 272, 273**

**i** The lines (1) identify the application of the sealant.

**i** The sealing surface must be cleaned. Sealant should be applied only to the specified surface, in the form of a bead of height and width 1.5 mm 0.5 mm. The sealing compound must be applied within 10 min. The sealing compound bead must not be spread. Use only the sealant indicated in Repair Materials.



P01.40-2126-12

**Fig. 16: Locating Sealant Path For Timing Case Cover**  
 Courtesy of MERCEDES-BENZ USA

**NOTES ON APPLICATION OF SEALANT TO OIL PAN - AH01.45-P-0001-01SX**

**MODIFICATION NOTES**

28.2.06	Sealant path for adapted to specifications of the Development Department	Engine 273
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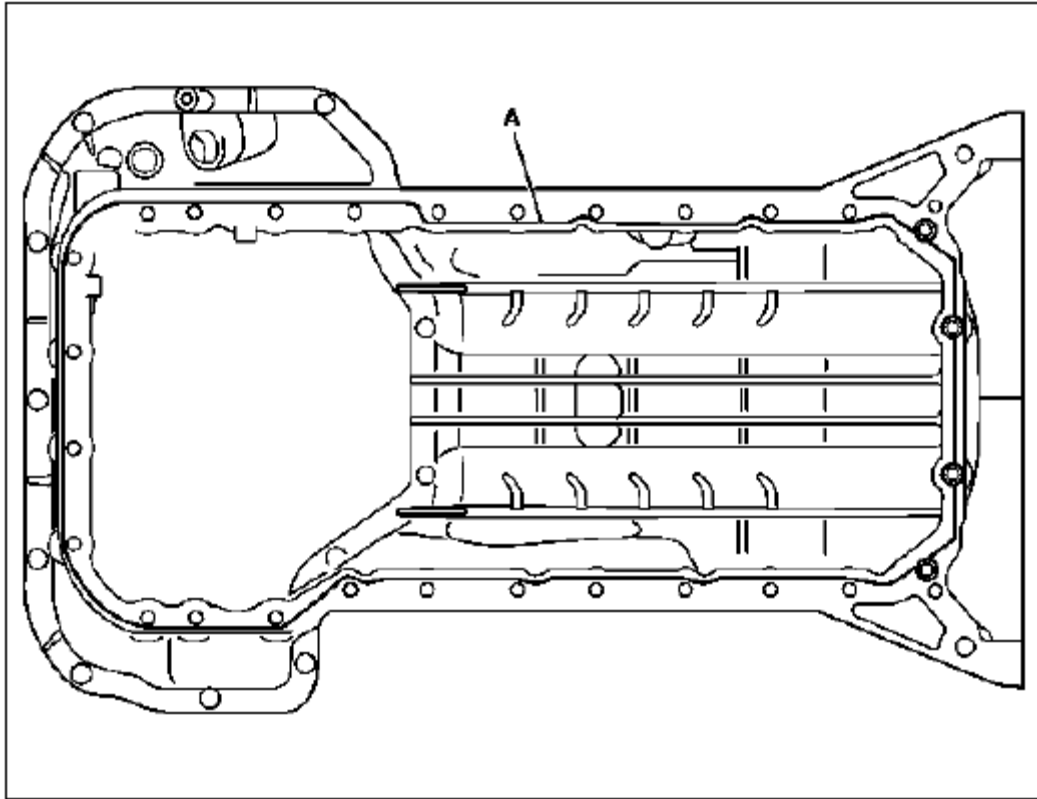
**Oil pan with front sump**

**i** The line (A) identifies the sealant run.

**i** The sealing surface must be cleaned. The sealant must only be applied to the specified surface in the form of a bead and a height and width of 2.0 mm ( $\pm 0.5$  mm).

The sealant must be applied within 10 min.

The sealant bead must not be spread. Only the sealant listed in the Repair Products may be used.



P01.45-2274-06

**Fig. 17: Identifying Sealant Application Areas On Oil Pan With Front Sump**  
Courtesy of MERCEDES-BENZ USA

**Oil pan with rear sump**