



TA 1400-0165

Technical Instruction

Roller tappet guide – Assembly (type 4 engines)



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1 Scope

This Technical Instruction applies to type 4 engines only. Its purpose is to describe the assembly of the roller tappet guide.

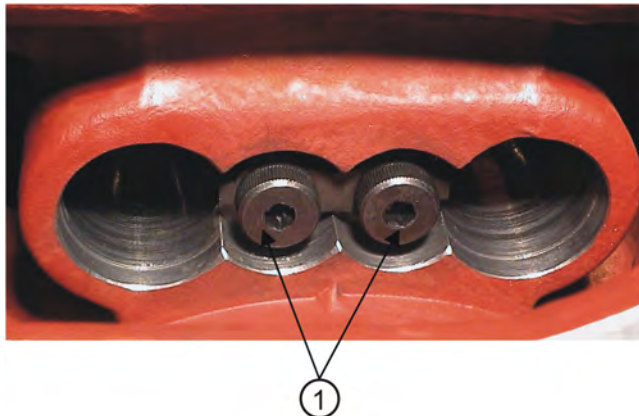
2 Tips

Only use the auxiliary assembly tool (Part No. 457172) for assembly. Using other tools is prohibited!

If the guide is assembled incorrectly (i.e. not according to this instruction), the roller tappet life will be drastically reduced. The reason is that a guide which is assembled askew will force the roller to roll on its side during the valve stroke, which may result in camshaft damage.

3 Procedure

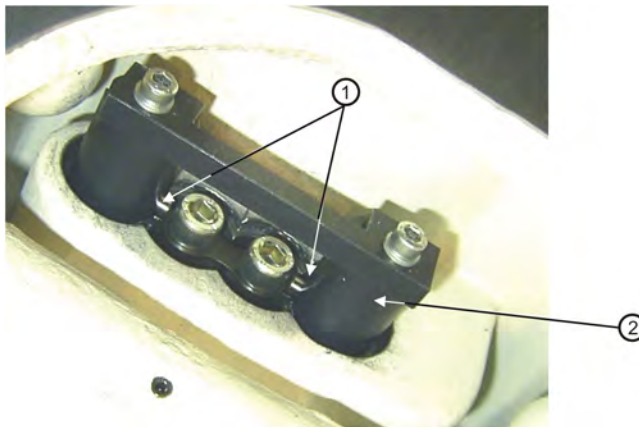
1. Apply Loctite 243 to the roller tappet guide fixture bolt (tappet guide).
2. Screw the guide into the crankcase using the bolts, making sure that the screws are hand-tightened so as to be able to still move the guide.



Roller tappet guide

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|---|---|--|--|
| ① | Roller tappet guide fixture bolt (tappet guide) | | |
|---|---|--|--|

3. Slide the auxiliary assembly tool into the roller tappet guide bore. Make sure to slide the auxiliary assembly tool into the guide bore until the bolts of the tool come into contact with the roller tappet guide. If this is not possible, the assembly procedure must be stopped.



Assembly tool for roller tappet guide

| | | | |
|---|---------------------|---|----------------------------------|
| ① | Assembly tool bolts | ② | Assembly tool (Part No.: 457172) |
|---|---------------------|---|----------------------------------|

4. If the roller tappet guide cams are in the assembly tool's guide grooves, tighten the bolts according to Technical Instruction No.: 1902-0213.

4 Revision code

Revision history

| Index | Date | Description / Revision summary | Expert Auditor |
|-------|------------|---|-------------------------------|
| 2 | 17.04.2019 | GE durch INNIO ersetzt / GE replaced by INNIO | Stojiljkovic T. Pichler R. |
| 1 | 30.09.2010 | Umstellung auf CMS / Change to Content Management System ersetzt / replaced Index: - | Schartner Bilek |